

TECHNICAL SPECIFICATIONS

CertainTeedCertainTeed Corporation
Pipe and Plastics Group

SPECIFICATIONS CLASSIFICATION:

Advance A/C Standard Product Specification

T.C.O. REF. NO.

1

SPECIFICATION NO:

6

PAGE NO.:

1

SUPERSEDES:

None

DATE OF ISSUE:

11-3-80

DESCRIPTION:

A/C Air Duct Pipe - Plant 258 Only

1.0 General:

This Advance Specification is being issued in order to set forth the anticipated requirement for the kinds of pipe that will have to be manufactured in order to re-enter this market.

This Specification covers sizes 6" thru 24"; the 18", 20" and 24" sizes being additions to the previous product line. The proposed dimensions and furnishes have been discussed with Mr. Benhardt and he has agreed that the proposal is proper for this initial venture.

The pipe will be square cut and clean of dust.

The coupling will be an outside purchased item.

No fittings are required.

2.0 Composition:

Air Duct pipe shall be composed of an intimate mixture of portland cement, asbestos fibers and silica. The material shall be of laminar construction formed under pressure to a homogenous structure and cured to meet the physical and chemical requirements of this specification. The pipe shall be free of organic additives.

3.0 Type:

The pipe shall be Type II.

4.0 Physical Requirements:

CTD011982

4.1 Appearance

4.1.1 The I.D. shall be free from dents or tears that result in a variation in diameter of more than 3/16 inch from the diameter of the adjacent unaffected portion. No water marks are allowed.

4.1.2 Some external denting is allowed on the outside (B.O.D.) of the pipe providing there are no cracks connected with the dents.

4.1.3 Pipe ends shall be cut clean, with no "lace curtains".

PREPARED BY:

Rsb

APPROVED BY:

Vms

R & D

MFG.

SALES

I.E.

O. C.

OTHERS

ABN

J.P.A.

DESCRIPTION:

A/C Air Duct Pipe - Plant 258 Only

4.1.4 It is imperative that the product shipped to customers be free of any fiber or fiber-like material.

4.2 Crushing Strength

Each pipe shall be capable of withstanding a crushing strength of 500 lbs./ft. min.

Standard Test - One crush test every 600 pipe for 6", 8", 10"
400 pipe for 12", 14", 16"
200 pipe for 18", 20", 24"

5.0 Chemical Requirements:

Uncombined Calcium Hydroxide shall be 1.0 max. when tested in accordance with ASTM C-500.

6.0 Dimensions

6.1 Ovality

The maximum ovality allowed shall be:

6", 8", 10"	3/8"
12", 14", 16"	7/16"
18", 20", 24"	1/2"

6.2 Lengths

Standard 13' +0" -1"

Random 7'0" to 12'6" in 6" increments +0" -1"

No more than 15% of the footage on an order may be in random lengths

6.3 I.D.'s & B.O.D.'s

Size"	Nominal I.D.	B.O.D. +.08" -.00"
6	6.00	6.61
8	8.00	8.74
10	10.00	10.99
12	12.00	13.24
14	14.00	15.23
16	16.00	17.40
18	18.00	19.60
20	20.00	21.66
24	24.00	25.88

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	1	6			3				
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7.0 <u>Marking:</u> 7.1 Each pipe shall be stenciled in the middle with black ink: CERTAINTEED SIZE AIR DUCT 7.2 Each pipe shall have stenciled to the right of the above marking: First line - Month, Day, Year, Plant, Shift Second line - Pipe No. 7.3 At either end of the pipe, a "handling label" (see Sec. D of the General Standards Manual) shall be attached to the B.O.D. of all pipe. CTD011984									
PREPARED BY:		APPROVED BY:		R & D	MFG.	SALES	I.E.	Q.C.	OTHERS
<i>asb</i>		<i>mas</i>		<i>SPN</i>	<i>J.R.A.</i>				