

TECHNICAL SPECIFICATIONS

FORM P927



CERTA-TTEE

CERTA-TTEE PRODUCTS CORPORATION
PIPE DIVISION

SPECIFICATIONS CLASSIFICATION

Standard Purchasing Specification

T.C.O. REF. NO.

14

SPECIFICATION NO.

503-B

PAGE NO.:

1

SUPERSEDES

May 7, 1968

DATE OF ISSUE:

APR 17 1973

DESCRIPTION:

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

1.0 USE

These rubber rings are intended for use as seals in FLUID-TITE B couplings of asbestos-cement pipe. This seal is to prevent leaking from the inside out, and infiltration from the outside in. Rubber rings when placed in service shall meet the requirements of this specification.

2.0 CONFORMANCE

The rubber rings shall be made of an approved compound and meet the requirements of P&PG Purchasing Specification No. 506 and ASTM D-1869 latest issue.

3.0 DESIGN

All rings are circular in form and shall be manufactured to the dimensions specified in the drawings of Figures 1 through 5 of this specification.

4.0 LOT SIZE

For sampling and inspection purposes, a lot shall be defined as the quantity of rings of each size and type, received at one time.

5.0 REQUIREMENTS5.1 Manufacturer's Inspection

Each ring in each shipment of rings shall be inspected in its entirety at a circumferential elongation 50% in excess of the original circumference by the manufacturer before shipment to P&PG. Defective rings shall be removed from each shipment before shipment is made. All rings are to be shipped on a first-in first-out basis, i.e. oldest rings are shipped first.

5.2 Appearance5.2.1 Surface

The surface shall be smooth and clean. Any matter either foreign or migratory from the compounds that give a dirty appearance shall be cause for rejection. The surface shall be free from pitting, cracks, air and flow marks, blisters, and all other imperfections which would detrimentally affect the ring in service. A slightly raised radius around the holes is acceptable.

CTD014966

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TECHNICAL SPECIFICATIONS

 CERTAINTEED PRODUCTS CORPORATION PIPE DIVISION	SPECIFICATIONS CLASSIFICATION:					
	Standard Purchasing Specification					
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February 4, 1975			SEP 9 1975			
DESCRIPTION:						
Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings						
5.2.2 <u>Body</u> The body of the ring shall be free from porosity and air pockets. 5.2.3 <u>Permissible Defects</u> While the ring should contain no imperfections and every effort should be made toward this end, the following defects are considered acceptable. 5.2.3.1 <u>Mold Imperfections</u> Flow marks in and between holes of less than 1/16" in depth. No more than four such flow marks are permitted within any one ring. 5.2.3.2 <u>Cuts, Tears, Gouges</u> 5.2.3.2.1 Cuts or tears in holes of less than 1/16" in length or depth. No more than four such cuts or tears are permitted within any one ring. Any cut or tear extending toward the outside edge is a defect. 5.2.3.2.2 Gouges less than 1/16" in length and depth are permitted on the ring edge. No more than four such gouges are permitted with any one ring. Note: Cuts or tears in the ring edge 1/16 inch or greater is a defect. 5.2.3.3 <u>Flash</u> The maximum allowable flash shall be .063" thickness, 1/16" long at the holes. At the ring edge the allowable flash shall be .063" thickness, 1/16" high. Buffing to remove excessive flash from the ring edges shall be permitted. 5.2.4 <u>Color Stripes</u> Each rubber ring shall be identified by color coating in accordance with Table A. The ring shall be color coded by a continuous color stripe, at least 1/8 inch wide on the back of the ring. The color						
CTD014967						
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TECHNICAL SPECIFICATIONS



CERTAIN-TEED PRODUCTS CORPORATION
PIPE DIVISION

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DESCRIPTION:

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

stripe shall be compatible with the ring, non-toxic, and shall withstand abrasion and not peel when the ring is elongated.

5.2.5 Identification Marks

5.2.5.1 The letters are to be .010 inch x 3/32 inch high for 3, 4, and 6 inch sizes. In the 4 and 6 inch size, it is optional to have letters .015 inch x 3/16 inch high. In sizes 8 inch through 24 inch the letters shall be .015 inch x 3/16 inch high, length to suit, centrally located on the designated marking area. See Figures 1 through 5.

5.2.5.2 The date of manufacture shall be shown by the number of the quarter and the last two digits of the year, such as ②-75, denoting the second quarter of 1975.

5.2.5.3 One quarter turn from the date code shall be the manufacturer's insignia, cavity, and mold number.

5.2.5.4 One half turn from the date code shall be the words FLUID-TITE, followed by the size and class:

i.e., FLUID-TITE 10" 150-200

5.2.5.5 Three-quarters turn from the date code shall be the words Combined C'pl'NG and Gasket U. S. Patent 2,871,031.

5.3 Splice

The splice (if any) shall be properly joined and sufficiently strong to withstand a 50% circumferential elongation without separation.

5.4 Dimensions

The dimensions shall be as shown in Figures 1 through 5.

6.0 TEST METHODS

6.1 Appearance - Visual in accordance with paragraph 5.2.

6.2 Splice - In accordance with paragraph 5.3.

6.3 Dimensions - In accordance with P&PG Test Method TM-22.

CTD014968

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TECHNICAL SPECIFICATIONS

CertainTeed

CertainTeed Corporation
Pipe and Plastics Group

SPECIFICATIONS CLASSIFICATION:

Standard Purchasing Specification

T.C.O. REF. NO.

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April 17, 1973

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JAN 9 1980

DESCRIPTION:

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

7.0 ACCEPTANCE AND REJECTION

P&PG reserves the right to reject any lot or lots found not conforming to the requirements of this specification. Such rejection or acceptance shall not be limited to the time of delivery, but shall be accomplished within thirty (30) days from receipt date. In the event of rejection, the vendor shall be immediately notified and the reason for the rejection explained. The vendor shall be given the opportunity to inspect representative samples of the rejected materials. The vendor must express his desire to inspect rejected material within seven days after notification of the rejection and the physical inspection must be performed within 30 days.

8.0 PACKAGING AND MARKING

8.1 Rings shall be shipped in the size carton as shown in the chart on page 5. The cartons shall be plain and 275 pound test regular slotted carton. The flute is to run parallel to the height. All cartons are to be sealed using reinforced tape.

The markings on the carton may be by either vendor's label or stencil. All cartons must show the size, class, FLUID-TITE and number of rings in the carton, and P&PG's Purchase Order No., i.e.,

6" Class 100-150-200 FLUID-TITE 375 (no. of rings) P&PG Order No.

8.2

Size	Class	Carton Size Inside Dimensions			Carton Contents		
		Length	Width	Height	Ring per Coil	No. Coils	No. Rings
3	All	16½	16½	16½	25	15	375
4	"	"	"	"	"	11	275
6	"	"	"	"	"	9	225
8	"	"	"	"	"	6	150
10	"	"	"	"	"	5	125
12	"	"	"	"	"	4	100
14	"	21	21	10	"	2	50
16	"	"	"	"	"	2	50
18	"	31	31	15	10	6	60
20	"	"	"	"	"	6	60
24	"	"	"	"	"	5	50

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 CertainTeed Corporation Pipe and Plastics Group	SPECIFICATIONS CLASSIFICATION:					
	Standard Purchasing Specification					
	T.C.O. REF. NO. 17-18		SPECIFICATION NO. 503-B		PAGE NO.: 5	
	SUPERSEDES: April 17, 1973				DATE OF ISSUE: JAN 9 1980	
DESCRIPTION: Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings						
9.0 <u>MOLD APPROVAL</u> All new or reworked molds must be approved by the Materials Laboratory Supervisor of P&PG before such molds are allowed to be placed in production. All rings, which are to be finished in the normal production method will be inspected for markings, visual defects, and dimensions in accordance with paragraph 6.0. <u>Dimensions</u> - From experience, it is known that all dimensions must be near the nominal dimensions in order to insure that all rings produced in a given cavity will be within specification limits.						
CTD014970						
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TECHNICAL SPECIFICATIONS

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Standard Purchasing Specification

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SUPERSEDED

May 7, 1968

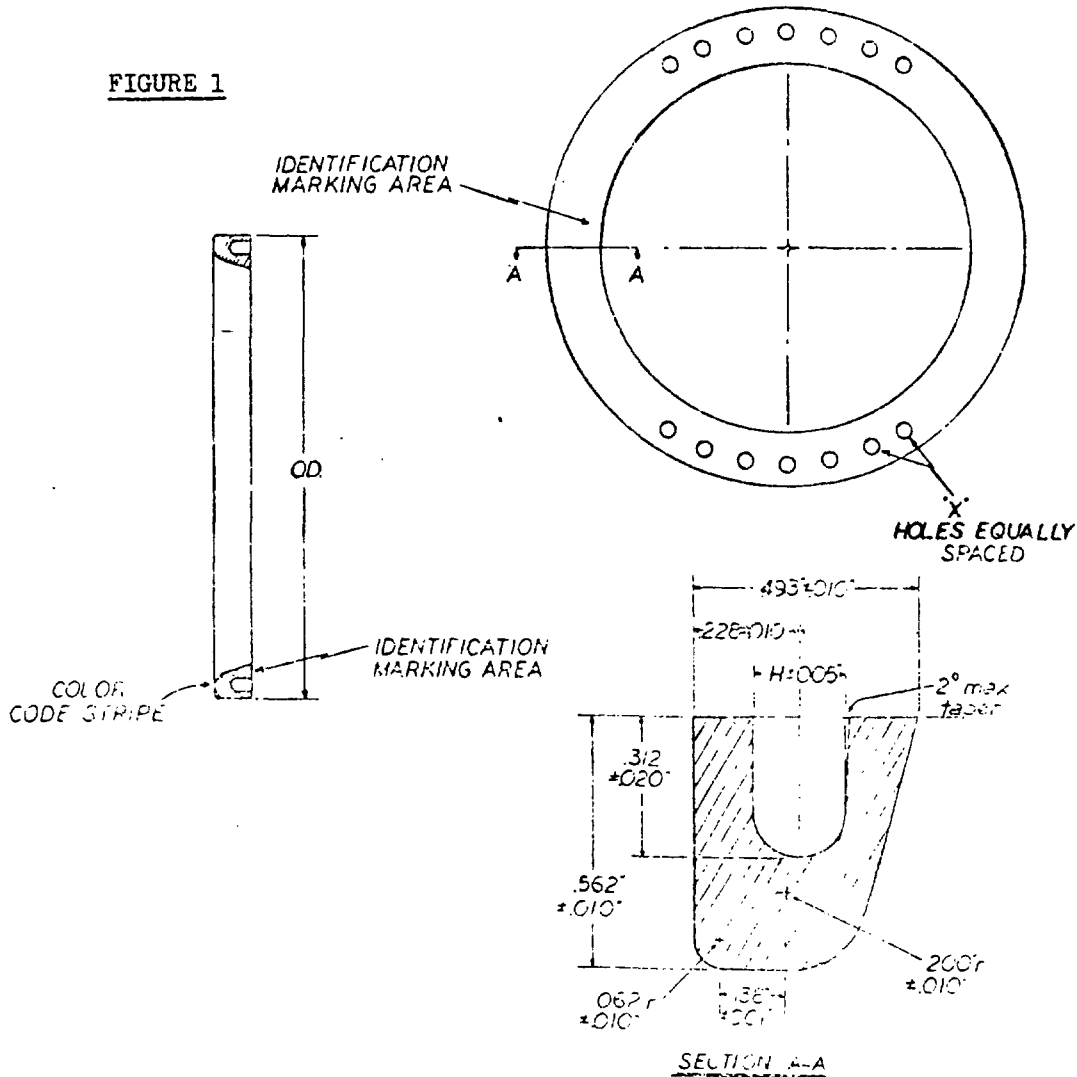
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DESCRIPTION

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

FIGURE 1



Size & Class	O.D. Dim.	H - Dia.	"X" - No. Holes ±2	Wt. Ring Lbs.
3"-100	4.450" ± .020"	.208" ± .005"	44	.10
3"-150/200	4.630" ± .020"	.187" ± .010" ± .005"	47	.11

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TECHNICAL SPECIFICATIONS

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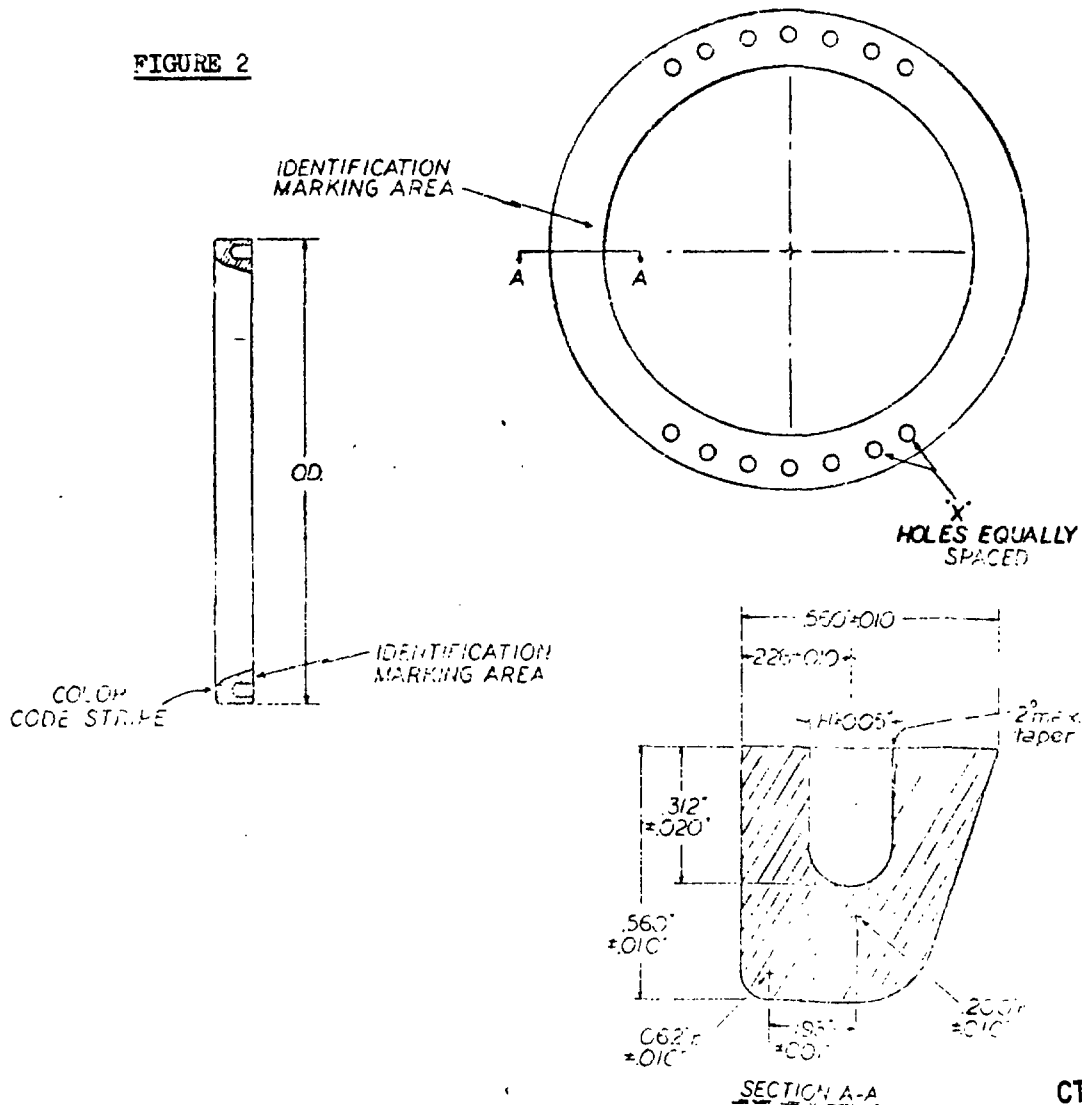
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DESCRIPTION:

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

FIGURE 2



CTD014972

Size & Class	O.D. Dim.	O.D. Tol.	H - Dia.	"X"-No. Holes ± 2	Wt. Ring Lbs.
4"-100	5.565"	±.020"	.208"	39	.16
4"-150/200	5.735"	±.020"	.208"	40	.18
6"-100/150/200	7.840"	±.025"	.208"	56	.22

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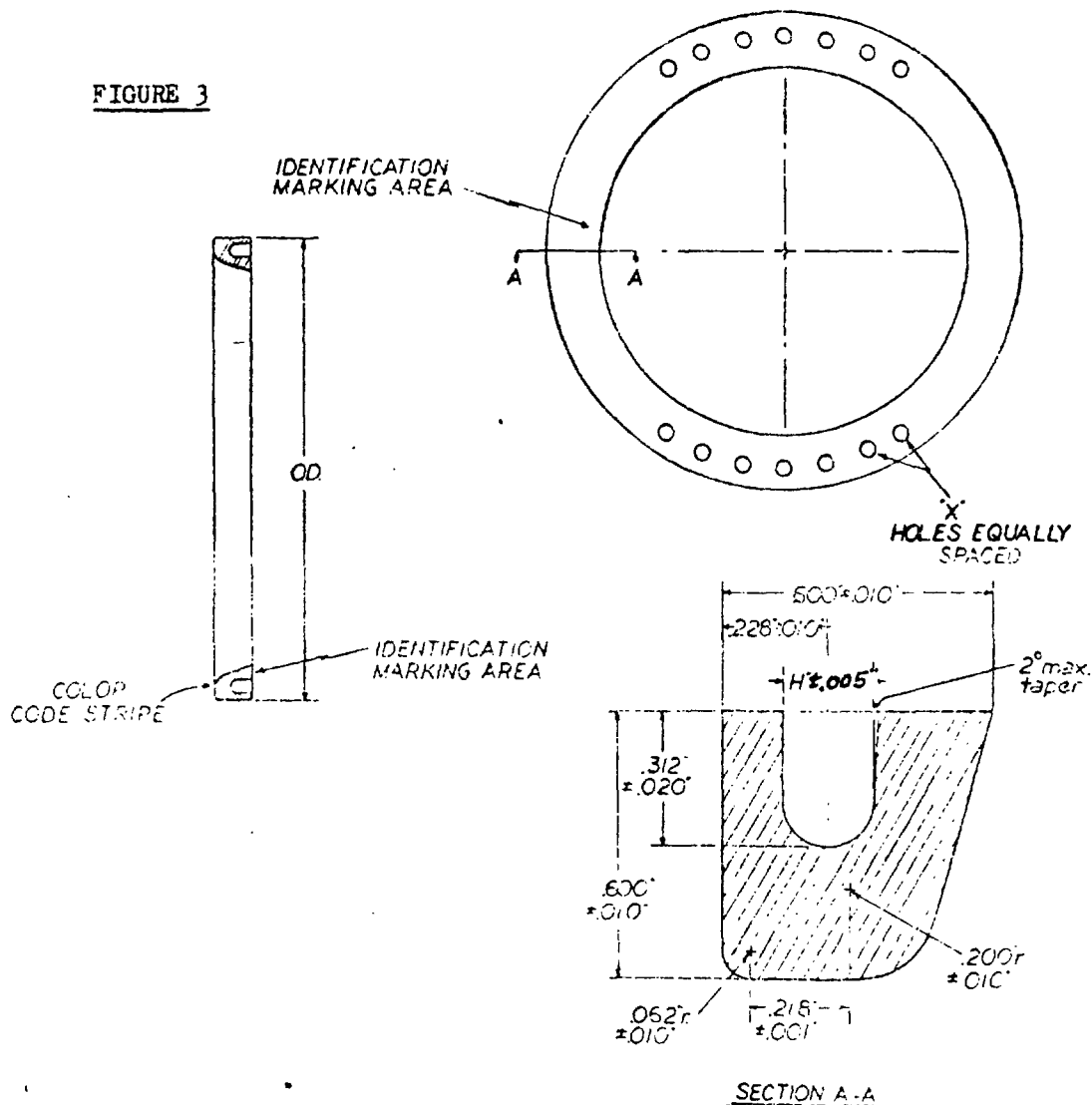
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DESCRIPTION:

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

FIGURE 3



Size & Class	O.D. Dim.	O.D. Tol.	H - Dia.	"X"-No. Holes ±2	Wt. Ring Lbs.
8"-100/150/200	10.115"	±.040"	.208"	73	.35
10"-100	12.115"	±.050"	.208"	88	.42
10"-150/200	12.675"	±.050"	.208"	92	.45
12"-100	14.350"	±.065"	.208"	105	.50
12"-150/200	14.950"	±.065"	.208"	109	.53

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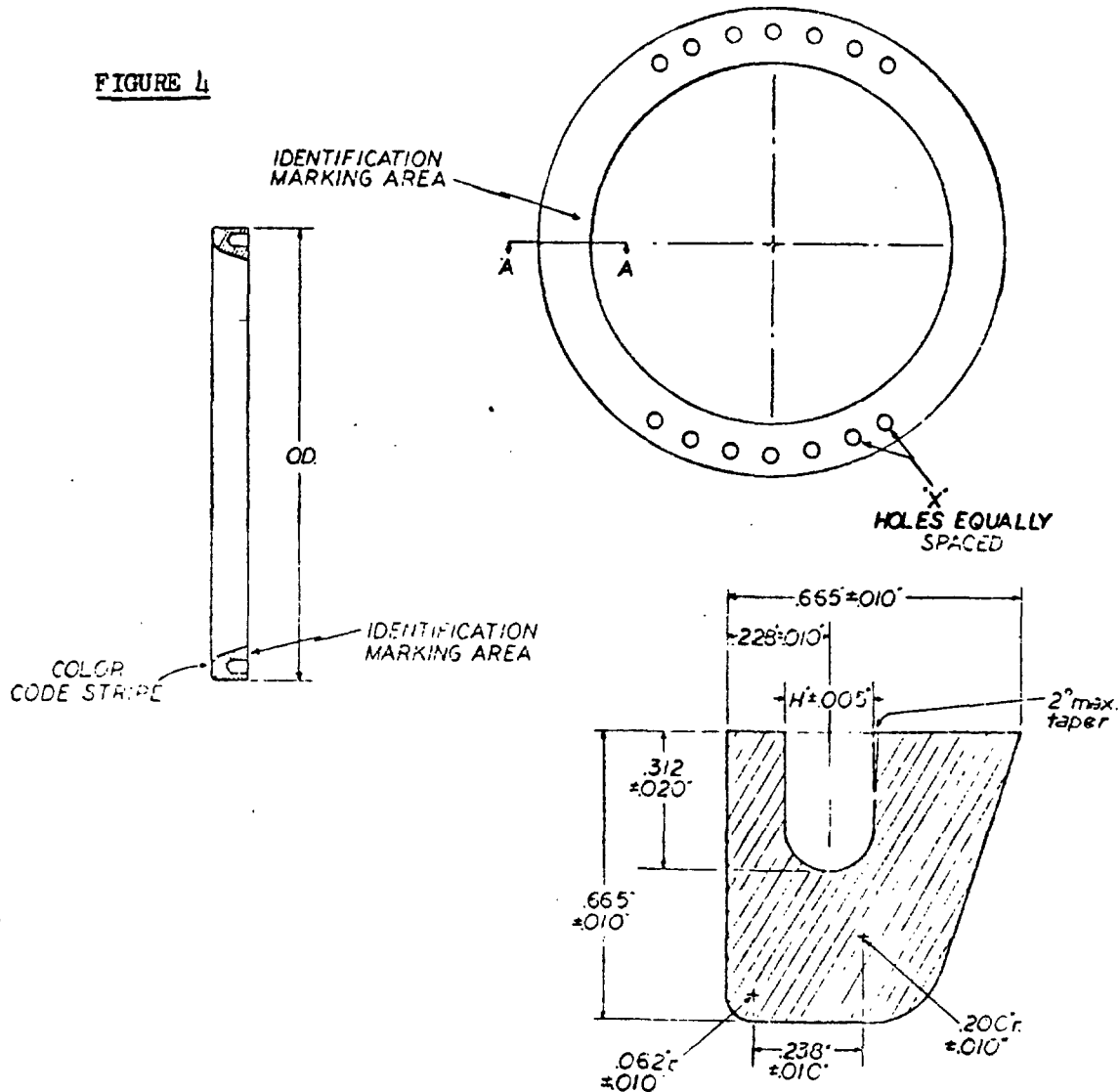
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DESCRIPTION:

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

FIGURE 4



SECTION A-A

CTD014974

Size & Class	O.D. Dim.	O.D. Tol.	H - Dia.	"X"-No. Holes ± 2	Wt. Ring Lbs.
14"-100	16.170"	±.075"	.208"	122	.63
14"-150/200	17.320"	±.075"	.208"	127	.70
16"-100	18.265"	±.090"	.208"	134	.76
16"-150/200	19.575"	±.090"	.208"	144	.86

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TECHNICAL SPECIFICATIONS



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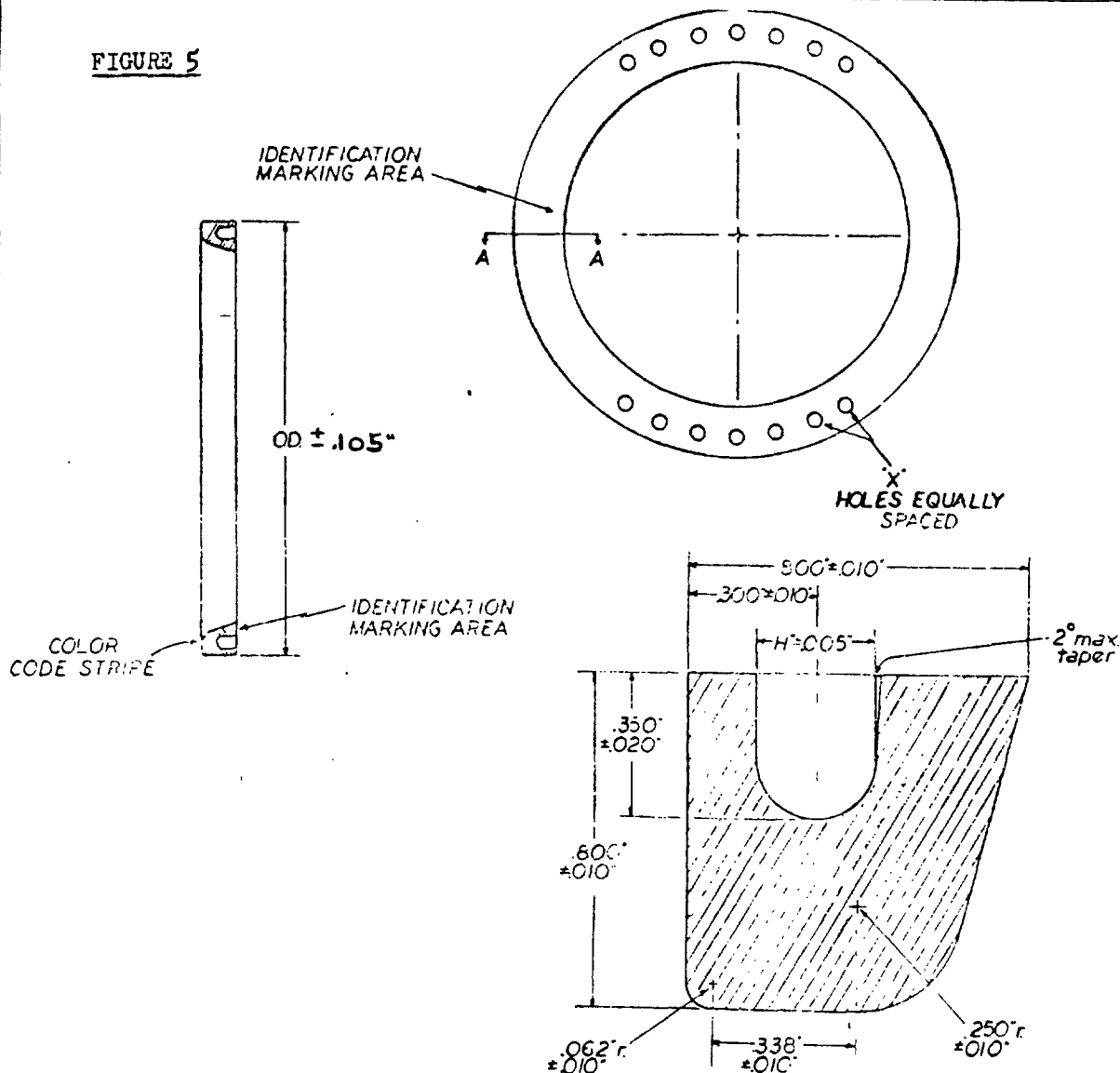
May 7, 1968

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DESCRIPTION.

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

FIGURE 5



Size & Class	O.D. Dim.	H - Dia.	"X" - No. Holes ± 2	Wt. Ring Lbs.
18"-100	21.170"	.313"	146	1.37
18"-150	22.210"	.313"	152	1.43
20"-100	23.390"	.307"	160	1.50
20"-150	24.550"	.307"	169	1.56
24"-100	27.750"	.307"	191	1.75
24"-150	29.230"	.307"	201	1.81

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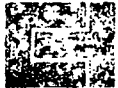
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TECHNICAL SPECIFICATIONS



CERTAIN-FLEX PRODUCTS CORPORATION
PIPE DIVISION

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DESCRIPTION:

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TABLE A

Color Identification

Ring Size and Class	Color Code	
	NR - SBR	NBR
3"-100	Yellow	Brown
4"-100	Yellow	Brown
10"-100	Yellow	Brown
12"-100	Yellow	Brown
14"-100	Yellow	Brown
16"-100	Yellow	Brown
18"-100	Yellow	Brown
20"-100	Yellow	Brown
24"-100	Yellow	Brown
3"-150/200	Orange	Gray
4"-150/200	Orange	Gray
6"-100/150/200	Orange	Gray
8"-100/150/200	Orange	Gray
10"-150/200	Orange	Gray
12"-150/200	Orange	Gray
14"-150/200	Orange	Gray
16"-150/200	Orange	Gray
18"-150	Orange	Gray
20"-150	Orange	Gray
24"-150	Orange	Gray

CTD014976

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TECHNICAL SPECIFICATIONS



CERTAINTEED

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PIPE DIVISION

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503-B Addendum

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DESCRIPTION:

Rubber Rings For Use With FLUID-TITE B Pressure Pipe and Couplings

NOT TO BE DISTRIBUTED TO VENDORS

1.0 Inspection

Sampling and Inspection shall be carried out in accordance with P&PG Test Method TM-23.

2.0 Rejection

The following procedure shall be followed on all rejected shipments.

2.1 The Headquarters Purchasing Department shall be notified. They will issue instructions on when and how the shipment is to be returned.

2.2 Quality Control Headquarters shall be notified and samples representative of the defect present in the shipment shall be forwarded to the Quality Control and Standards Manager.

3.0 Approved Vendors

Acushnet Process Company

New Bedford, Mass. 1X

Fort Worth, Texas 1X.

Approved to manufacture all classes 3" through 16".

Kirkhill Rubber Company

Brea, Calif. 

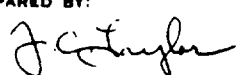
Approved to manufacture 6"-8"-12" class 150 rings.

Reeves Rubber Company

San Clemente, Calif. 

Approved to manufacture all classes 3" through 24". There is no class 200 in sizes 18" through 24".

CTD014977

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