

Hancor

CONCRETE PRODUCTS

BLUE SEAL® PIPE SPECIFICATIONS

Diameter: 12" - 60" (300 - 1500mm)

Length:

- 20' (6m) for 12" - 30" (300 - 750mm) diameter pipe.
- 20.5' (6.24m) for 36" - 60" (900 - 1500mm) diameter pipe.

Specifications: AASHTO M294, Type S and AASHTO MP7, Type S.

Joint Performance: Watertight

Joining System: Bell-and-spigot

Gasket: Polyisoprene meeting ASTM F477

Fittings and Accessories: Hancor offers a full line of fittings for all diameters of Hancor pipe.

SCOPE

This specification describes 12" - 60" (300 - 1500mm) Hancor BLUE SEAL pipe for use in gravity flow applications.

PIPE REQUIREMENTS

BLUE SEAL pipe shall have a smooth interior and annular exterior corrugations.

- 12" - 48" (300 - 1200mm) shall meet AASHTO M294, Type S.
- 60" (1500mm) meets AASHTO MP7, Type S.
- Manning's "n" value for use in design shall be no less than 0.010.

MATERIAL PROPERTIES

Pipe and fitting material shall be high-density polyethylene meeting ASTM D3350 minimum cell classification 335400C. The pipe material shall be Hancor Resin 8™, which is a high stress crack resistant material evaluated using the single point notched constant tensile load (SP-NCTL) test. Average SP-NCTL test specimens must exceed 24 hrs. with no test result less than 17 hrs. The closed cell structural foam core must have a free rise density no less than

3 lbs/ft³ and compressive strength no less than 20 lbs/in².

JOINT PERFORMANCE

Pipe shall be joined with the BLUE SEAL joint meeting the requirements of AASHTO M294, or AASHTO MP7. 12" - 60" (300 - 1500mm) shall be watertight according to the requirements of ASTM D3212. Gaskets shall be made of polyisoprene, meeting the requirements of ASTM F477 with the addition that the gaskets shall not have any visible cracking when tested according to ASTM D1149 after 72 hours exposure in 50 PPHM ozone at 104° Fahrenheit. Gaskets shall be installed by the pipe manufacturer and covered with a removable wrap to ensure the gasket is free from debris. 12" - 30" (300 - 750mm) bells shall include a reinforcing rib at the flare OD to assure meeting roundness tolerances and enhance proper joint assembly. A joint lubricant available from the manufacturer shall be used on the gasket and bell during assembly. 24" - 60" (600 - 1500mm) diameters shall have a reinforced bell-and-spigot, including a bell tolerance device. The bell tolerance device shall be installed by the manufacturer and covered with a protective wrap. The gasket corrugation shall be reinforced with a closed cell structural foam core.

FITTINGS

Fittings conform to AASHTO M294 or AASHTO MP7. Fabricated fittings are welded at all accessible interior and exterior junctions.

WATERTIGHT FIELD TEST PERFORMANCE

To assure watertight field performance, verification may be accomplished using ASTM F 1417 or ASTM C 969 test procedures. Appropriate safety precautions must be used when field testing any pipe material.



Bury it and forget it.

INSTALLATION

Installation should be in accordance with ASTM D2321, with the exception that minimum cover in trafficked areas for 12" - 48" (300 - 1200mm) diameters is 1 ft. (0.3m), and for 60" (1500mm) diameters, 1.5 ft. (0.5m).

QUALITY ASSURANCE

All corrugated polyethylene pipe meeting or exceeding AASHTO M294 or MP7 shall only be provided by manufacturers listed by the Plastic Pipe Institute (PPI) as having met the requirements of the PPI sponsored third-party certification program. All AASHTO M294 and MP7 pipe shall be clearly marked with a certification program mark or logo representing the supplied pipe is in compliance with all applicable standards.



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DUCKS UNLIMITED

Hancor is an Official Partner of Ducks Unlimited, the world's leading wetland conservation organization.

Direct Contact

Customer Service

888-FOR PIPE (367-7473)

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Application Engineering

For technical questions, call

800-2HANCOR (242-6267), ext. 809

Electronic Media

Web Site

Find market- and application-specific information and the latest industry news at our On-Line Pipeline - www.hancor.com

Pipe I.D., in. (mm)	12 (300)	15 (375)	18 (450)	24 (600)	30 (750)	36 (900)	42 (1050)	48 (1200)	60 (1500)
Pipe O.D., in. (mm)	14.2 (361)	17.7 (450)	21.5 (546)	28.4 (721)	36.0 (914)	41.4 (1052)	48.0 (1219)	55.0 (1397)	67.3 (1709)
Flare O.D., in. (mm)	15.4 (391)	19.6 (498)	23.9 (607)	29.9 (759)	37.9 (963)	43.6 (1107)	50.8 (1290)	57.4 (1458)	73.7 (1872)
Pitch, in. (mm)	2.0 (51)	2.4 (61)	3.0 (76)	4.0 (102)	4.0 (102)	4.6 (117)	5.8 (147)	5.8 (147)	7.8 (198)
Approx. Weight* lb/20 ft. stick (kg/6m stick)	70 (32)	100 (46)	130 (59)	220 (100)	330 (150)	400 (182)	500 (227)	597 (260)	861 (315)

*One stick is 20' (6m) for 12"-30" (300-750mm) diameter pipe and 20.5' (6.24m) for 36"-60" (900-1500mm) diameter pipe.

All sales of Hancor product are subject to a limited warranty and purchasers are solely responsible for installation and use of Hancor products and determining whether a product is suited for any specific needs. Please consult a full copy of Hancor's Terms and Conditions for Sale for further details.