

SECTION 15065

FUSIBLE POLYVINYLCHLORIDE PIPE

PART 1 –GENERAL

1.01 DESCRIPTION

A SCOPE

1. This section specifies fusible polyvinylchloride pipe, including standards for dimensionality, testing, quality, acceptable fusion practice, safe handling and storage.

B PIPE DESCRIPTION

1. Pipe supplier shall furnish fusible polyvinylchloride pipe conforming to all standards and procedures, and meeting all testing and material properties as described in this specification.
2. Pipe shall conform to the following dimensionality and general characteristics table:

<u>Pipe Description</u>	<u>Nominal Diameter (in.)</u>	<u>DR</u>	<u>Color</u>	<u>Pressure Class (psi)</u>	<u>Required Inner Diameter (in.)</u>

1.02 QUALITY ASSURANCE

A REFERENCES:

1. This section contains references to the following documents. They are a part of this section as specified and modified. Where a referenced document contains references to other standards, those other standards are included as references under this section as if referenced directly. In the event of a conflict between the requirements of this section and those of the listed documents, the requirements of this section shall prevail.
2. Unless otherwise specified, references to documents shall mean the documents in effect at the time of design, bid, or construction, whichever is earliest. If referenced documents have been discontinued by the issuing organization, references to those documents shall mean the replacement documents issued or otherwise identified by that organization or, if there are no replacement documents, the last version of the document before it was discontinued.
3. Where document dates are given in the following listing, references to those documents shall mean the specific document version associated with that

date, regardless of whether the document has been superseded by a version with a later date, discontinued or replaced.

Reference	Title
ANSI/AWWA C110/A21.10	American National Standard for Ductile-Iron and Gray-Iron Fittings, 3-inch through 48-inch, for Water and Other Liquids
ANSI/AWWA C111/A21.11	American National Standard for Rubber-Gasket Joints for Ductile-Iron Pressure Pipe and Fittings
ANSI/AWWA C153/A21.53	AWWA Standard for Ductile-Iron Compact Fittings for Water Service
AWWA C605	Standard for Underground Installation of Polyvinyl Chloride (PVC) Pressure Pipe and Fittings for Water
AWWA C651	Standard for Disinfecting Water Mains
AWWA C900	Standard for Polyvinyl Chloride (PVC) Pressure Pipe and Fabricated Fittings, 4 in. through 12 in. (100mm Through 300mm), for Water Distribution
AWWA C905	Standard for Polyvinyl Chloride (PVC) Pressure Pipe and Fabricated Fittings, 14 in. through 48 in. (350mm Through 1200mm), for Water Distribution and Transmission
AWWA M23	AWWA Manual of Supply Practices PVC Pipe—Design and Installation, Second Edition
ASTM C923	Standard Specification for Resilient Connectors Between Reinforced Concrete Manhole Structures, Pipes and Laterals
ASTM D1784	Rigid Poly (Vinyl Chloride) (PVC) Compounds and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds
ASTM D1785	Poly (Vinyl Chloride) (PVC) Plastic Pipe, Schedules 40, 80, and 120
ASTM D2152	Test Method for Degree of Fusion of Extruded Poly(Vinyl Chloride) (PVC) Pipe and Molded Fittings by Acetone Immersion
ASTM D2241	Poly (Vinyl Chloride) (PVC) Plastic Pipe (SDR-PR)
ASTM D2665	Poly (Vinyl Chloride) (PVC) Plastic Drain, Waste, and Vent Pipe and Fittings
ASTM D3034	Standard Specification for Type PSM Poly(Vinyl Chloride) (PVC) Sewer Pipe and Fittings
ASTM F477	Elastomeric Seals (Gaskets) for Joining Plastic Pipe
ASTM F679	Standard Specification for Poly(Vinyl Chloride) (PVC) Large Diameter Plastic Gravity Sewer Pipe and Fittings
ASTM F1057	Standard Practice for Estimating the Quality of Extruded Poly (Vinyl Chloride) (PVC) Pipe by the Heat Reversion Technique

Reference	Title
ASTM F1417	Standard Test Method for Installation Acceptance of Plastic Gravity Sewer Lines Using Low-Pressure Air
UNI-B-6	Recommended Practice for Low-Pressure Air Testing of Installed Sewer Pipe
UNI-PUB-08	Tapping Guide for PVC Pressure Pipe
NSF-14	Plastics Piping System Components and Related Materials
NSF-61	Drinking Water System Components--Health Effects
PPI TR-2	PVC Range Composition Listing of Qualified Ingredients

B MANUFACTURER REQUIREMENTS

1. All piping shall be made from PVC compound conforming to cell classification 12454 per ASTM D1784.

C FUSION TECHNICIAN REQUIREMENTS

1. Fusion Technician shall be fully qualified by the pipe supplier to install fusible polyvinylchloride pipe of the type(s) and size(s) being used. Qualification shall be current as of the actual date of fusion performance on the project.

D SPECIFIED PIPE SUPPLIERS

1. Fusible polyvinylchloride pipe shall be used as manufactured under the trade names Fusible C-900®, Fusible C-905®, and FPVC®, for Underground Solutions, Inc., Poway, CA, (858) 679-9551. Fusion process shall be as patented by Underground Solutions, Inc., Poway, CA, Patent No. 6,982,051. Owner and engineer are aware of no other supplier of fusible polyvinylchloride pipe that is an equal to this specified pipe supplier and products.

E WARRANTY

1. The pipe shall be warranted for one year per the pipe supplier's standard terms.
2. In addition to the standard pipe warranty, the fusion services shall be warranted for one year per the fusion service provider's standard terms.

F PRE-CONSTRUCTION SUBMITTALS

1. The following PRODUCT DATA is required from the pipe supplier and/or fusion provider:
 - 1) Pipe Size
 - 2) Dimensionality
 - 3) Pressure Class per applicable standard
 - 4) Color

- 5) Recommended Minimum Bending Radius
- 6) Recommended Maximum Safe Pull Force
- 7) Fusion technician qualification indicating conformance with this specification

G POST-CONSTRUCTION SUBMITTALS

1. The following AS-RECORDED DATA is required from the contractor and/or fusion provider to the owner or pipe supplier upon request:
 - 1) Approved datalogger device reports
 - 2) Fusion joint documentation containing the following information:
 - a) Pipe Size and Thickness
 - b) Machine Size
 - c) Fusion Technician Identification
 - d) Job Identification
 - e) Fusion Joint Number
 - f) Fusion, Heating, and Drag Pressure Settings
 - g) Heat Plate Temperature
 - h) Time Stamp
 - i) Heating and Cool Down Time of Fusion
 - j) Ambient Temperature

PART 2 – PRODUCTS

2.01 FUSIBLE POLYVINYLCHLORIDE PRESSURE PIPE FOR POTABLE WATER

- A Fusible polyvinylchloride pipe shall conform to AWWA C900, AWWA C905, ASTM D2241 or ASTM D1785 for standard dimensions, as applicable. Testing shall be in accordance with the referenced AWWA standards for all pipe types.
- B Fusible polyvinylchloride pipe shall be extruded with plain ends. The ends shall be square to the pipe and free of any bevel or chamfer. There shall be no bell or gasket of any kind incorporated into the pipe.
- C Fusible polyvinylchloride pipe shall be manufactured in a standard 40' nominal length, or custom lengths as specified.
- D Fusible polyvinylchloride pipe shall be blue in color for potable water use.
- E Pipe shall be marked as follows:
 1. Nominal pipe size
 2. PVC
 3. Dimension Ratio, Standard Dimension Ratio, or Schedule

4. AWWA pressure class, or standard pressure rating for non-AWWA pipe, as applicable
 5. AWWA standard designation number, or pipe type for non-AWWA pipe, as applicable
 6. NSF-61 mark verifying suitability for potable water service
 7. Extrusion production-record code
 8. Trademark or trade name
 9. Cell Classification 12454 and/or PVC material code 1120 may also be included
- F Pipe shall be homogeneous throughout and be free of visible cracks, holes, foreign material, blisters, or other visible deleterious faults.

2.02 FUSIBLE POLYVINYLCHLORIDE PRESSURE PIPE FOR NON-POTABLE WATER NOT CONFORMING TO AWWA C905 DIMENSIONALITY

- A Fusible polyvinylchloride pipe shall conform to AWWA C900, ASTM D2241 or ASTM D1785 for standard dimensionality, as applicable. Testing shall be in accordance with the referenced AWWA standard.
- B Fusible polyvinylchloride pipe shall be extruded with plain ends. The ends shall be square to the pipe and free of any bevel or chamfer. There shall be no bell or gasket of any kind incorporated into the pipe.
- C Fusible polyvinylchloride pipe shall be manufactured in a standard 40' nominal length, or custom lengths as specified.
- D Fusible polyvinylchloride pipe shall be purple in color for reclaim, reuse, or other non-potable water distribution or conveyance.
- E Pipe shall be marked as follows:
1. Nominal pipe size
 2. PVC
 3. Dimension Ratio, Standard Dimension Ratio, or Schedule
 4. AWWA pressure class, or standard pressure rating for non-AWWA pipe, as applicable
 5. AWWA standard designation number, or pipe type for non-AWWA pipe, as applicable
 6. Extrusion production-record code
 7. Trademark or trade name
 8. Cell Classification 12454 and/or PVC material code 1120 may also be included
 9. For reclaim water service, the wording: "Reclaimed Water, NOT for Potable Use"

- F Pipe shall be homogeneous throughout and be free of visible cracks, holes, foreign material, blisters, or other visible deleterious faults.
- 2.03 FUSIBLE POLYVINYLCHLORIDE PRESSURE PIPE FOR NON-POTABLE WATER CONFORMING TO AWWA C905 DIMENSIONALITY
- A Fusible polyvinylchloride pipe shall conform to AWWA C905 standard.
- B Fusible polyvinylchloride pipe shall be extruded with plain ends. The ends shall be square to the pipe and free of any bevel or chamfer. There shall be no bell or gasket of any kind incorporated into the pipe.
- C Fusible polyvinylchloride pipe shall be manufactured in a standard 40' nominal length, or custom lengths as specified.
- D Fusible polyvinylchloride pipe shall be purple in color for reclaim, reuse, or other non-potable water distribution or conveyance.
- E Pipe shall be marked as follows:
1. Nominal pipe size
 2. PVC
 3. Dimension Ratio, Standard Dimension Ratio, or Schedule
 4. AWWA pressure class
 5. AWWA standard designation number
 6. Extrusion production-record code
 7. Trademark or trade name
 8. Cell Classification 12454 and/or PVC material code 1120 may also be included
 9. For reclaim water service, the wording: "Reclaimed Water, NOT for Potable Use"
- F Pipe shall be homogeneous throughout and be free of visible cracks, holes, foreign material, blisters, or other visible deleterious faults.
- 2.04 FUSIBLE POLYVINYLCHLORIDE PRESSURE PIPE FOR WASTEWATER NOT CONFORMING TO AWWA C905 DIMENSIONALITY
- A Fusible polyvinylchloride pipe shall conform to AWWA C900, ASTM D2241 or ASTM D1785 for standard dimensionality, as applicable. Testing shall be in accordance with the referenced AWWA standard.
- B Fusible polyvinylchloride pipe shall be extruded with plain ends. The ends shall be square to the pipe and free of any bevel or chamfer. There shall be no bell or gasket of any kind incorporated into the pipe.
- C Fusible polyvinylchloride pipe shall be manufactured in a standard 40' nominal length, or custom lengths as specified.
- D Fusible polyvinylchloride pipe shall be green in color for wastewater use.

- E Pipe shall be marked as follows:
1. Nominal pipe size
 2. PVC
 3. Dimension Ratio, Standard Dimension Ratio, or Schedule
 4. AWWA pressure class, or standard pressure rating for non-AWWA pipe, as applicable
 5. AWWA standard designation number, or pipe type for non-AWWA pipe, as applicable
 6. Extrusion production-record code
 7. Trademark or trade name
 8. Cell Classification 12454 and/or PVC material code 1120 may also be included
- F Pipe shall be homogeneous throughout and be free of visible cracks, holes, foreign material, blisters, or other visible deleterious faults.

2.05 FUSIBLE POLYVINYLCHLORIDE PRESSURE PIPE FOR WASTEWATER
CONFORMING TO AWWA C905 DIMENSIONALITY

- A Fusible polyvinylchloride pipe shall conform to AWWA C905 standard.
- B Fusible polyvinylchloride pipe shall be extruded with plain ends. The ends shall be square to the pipe and free of any bevel or chamfer. There shall be no bell or gasket of any kind incorporated into the pipe.
- C Fusible polyvinylchloride pipe shall be manufactured in a standard 40' nominal length, or custom lengths as specified.
- D Fusible polyvinylchloride pipe shall be green in color for wastewater use.
- E Pipe shall be marked as follows:
1. Nominal pipe size
 2. PVC
 3. Dimension Ratio, Standard Dimension Ratio, or Schedule
 4. AWWA pressure class
 5. AWWA standard designation number
 6. Extrusion production-record code
 7. Trademark or trade name
 8. Cell Classification 12454 and/or PVC material code 1120 may also be included
- F Pipe shall be homogeneous throughout and be free of visible cracks, holes, foreign material, blisters, or other visible deleterious faults.

2.06 FUSIBLE POLYVINYLCHLORIDE NON-PRESSURE PIPE FOR WASTEWATER

OR SURFACE WATER

- A Fusible polyvinylchloride pipe shall conform to ASTM D3034 or ASTM F679.
- B Fusible polyvinylchloride pipe may instead conform to AWWA C900 or AWWA C905, ASTM D2241 or ASTM D1785 for standard dimensionality, as applicable.
- C Fusible polyvinylchloride pipe shall be extruded with plain ends. The ends shall be square to the pipe and free of any bevel or chamfer. There shall be no bell or gasket of any kind incorporated into the pipe.
- D Fusible polyvinylchloride pipe shall be manufactured in a standard 40' nominal length, or custom lengths as specified.
- E Fusible polyvinylchloride pipe shall be green in color for wastewater use. Fusible polyvinylchloride pipe shall be white in color for surface or storm water use.
- F Pipe shall be marked as follows:
 - 1. Nominal pipe size
 - 2. PVC
 - 3. Dimension Ratio, Standard Dimension Ratio, or Schedule
 - 4. Pressure class or standard pressure rating
 - 5. Standard designation number or pipe type
 - 6. Extrusion production-record code
 - 7. Trademark or trade name
 - 8. Cell Classification 12454 and/or PVC material code 1120 may also be included
- G Pipe shall be homogeneous throughout and be free of visible cracks, holes, foreign material, blisters, or other visible deleterious faults.

2.07 FUSION JOINTS

- A Unless otherwise specified, fusible polyvinylchloride pipe lengths shall be assembled in the field with butt-fused joints. The Contractor shall follow the pipe supplier's written guidelines for this procedure. All fusion joints shall be completed as described in this specification.

2.08 CONNECTIONS AND FITTINGS FOR PRESSURE APPLICATIONS

- A Connections shall be defined in conjunction with the coupling of project piping, as well as the tie-ins to other piping systems.

B DUCTILE IRON MECHANICAL AND FLANGED FITTINGS

Acceptable fittings for use with fusible polyvinylchloride pipe shall include standard ductile iron fittings conforming to AWWA/ANSI C110/A21.10, or AWWA/ANSI C153/A21.53 and AWWA/ANSI C111/A21.11.

- 1. Connections to fusible polyvinylchloride pipe may be made using a restrained or non-restrained retainer gland product for PVC pipe, as well as

for MJ or flanged fittings.

2. Bends, tees and other ductile iron fittings shall be restrained with the use of thrust blocking or other means as indicated in the construction documents.
3. Ductile iron fittings and glands must be installed per the manufacturer's guidelines.
4. If required, linings for Ductile Iron fittings shall meet the following requirements for the following service environments:
 - 1) Wastewater:
 - a) Ceramic Epoxy shall be Tnemec Perma-Shield 431.
 - b) Polyurethane shall be DuraShield 210 or 310.
 - 2) Potable Water:
 - a) Liquid Epoxy shall be 100% solids liquid epoxy, Tnemec Epoxyline Series FC22.
 - b) Polyurethane shall be DuraShield 210-61 or 310-61.
5. If required, coatings for Ductile Iron fittings shall meet the following requirements for buried and/or immersion service duty:
 - a) Polyurethane shall be DuraShield 210 or 310.
 - b) Liquid Epoxy shall be 100% solids liquid epoxy, Tnemec Epoxyline Series FC22.
 - c) Coal tar epoxy shall be Sherwin Williams Targuard.

C PVC GASKETED, PUSH-ON FITTINGS

Acceptable fittings for use with fusible polyvinylchloride pipe shall include standard PVC pressure fittings conforming to AWWA C900 or AWWA C905.

1. Acceptable fittings for use joining fusible polyvinylchloride pipe other sections of fusible polyvinylchloride pipe or other sections of PVC pipe shall include gasketed PVC, push-on type couplings and fittings, including bends, tees, and couplings as shown in the drawings.
2. Bends, tees and other PVC fittings shall be restrained with the use of thrust blocking or other restraint products as indicated in the construction documents.
3. PVC gasketed, push-on fittings and mechanical restraints, if used, must be installed per the manufacturer's guidelines.

D FUSIBLE POLYVINYL CHLORIDE SWEEPS OR BENDS

1. Fusible polyvinyl chloride sweeps or bends shall conform to the same sizing convention, diameter, dimensional tolerances and pressure class of the pipe being joined using the sweep or bend.
2. Fusible polyvinyl chloride sweeps or bends shall be manufactured from the

same fusible polyvinyl chloride pipe being used for the installation, and shall have at least 2 feet of straight section on either end of the sweep or bend to allow for fusion of the sweep to the pipe installation. There shall be no gasketed connections utilized with a fusible polyvinyl chloride sweep.

3. Standard fusible polyvinyl chloride sweep or bend angles shall not be greater than 22.5 degrees, and shall be used in nominal diameters ranging from 4 inch through 16 inch.

E SLEEVE-TYPE COUPLINGS

1. Sleeve-type mechanical couplings shall be manufactured for use with PVC pressure pipe, and may be restrained or unrestrained as indicated in the construction documents.
2. Sleeve-type couplings shall be rated at the same or greater pressure carrying capacity as the pipe itself.

F EXPANSION AND FLEXIBLE COUPLINGS

1. Expansion-type mechanical couplings shall be manufactured for use with PVC pipe, and may be restrained or unrestrained as indicated in the construction documents.
2. Expansion-type mechanical couplings shall be rated at the same or greater pressure carrying capacity as the pipe itself.

G CONNECTION HARDWARE

Bolts and nuts for buried service shall be made of non-corrosive, high-strength, low-alloy steel having the characteristics specified in ANSI/AWWA C111/A21.11, regardless of any other protective coating.

2.09 CONNECTIONS FOR GRAVITY SANITARY SEWER AND NON-PRESSURE APPLICATIONS

A The following connections are to be used in conjunction with tie-ins to other non-pressure, gravity sewer piping and/or structures, and shall be as indicated in the construction documents.

B PVC GASKETED, PUSH-ON COUPLINGS

1. Acceptable couplings for joining fusible polyvinylchloride pipe to other sections of fusible polyvinylchloride pipe or other sections of PVC pipe shall include gasketed PVC, push-on type couplings as indicated in the construction documents.
2. PVC gasketed, push-on fittings and/or restraint hardware must be installed per the manufacturer's guidelines.

C FUSIBLE POLYVINYL CHLORIDE SWEEPS OR BENDS

1. Fusible polyvinyl chloride sweeps or bends shall conform to the same sizing convention, diameter, dimensional tolerances and pressure class of the pipe being joined using the sweep or bend.

2. Fusible polyvinyl chloride sweeps or bends shall be manufactured from the same fusible polyvinyl chloride pipe being used for the installation, and shall have at least 2 feet of straight section on either end of the sweep or bend to allow for fusion of the sweep to the pipe installation. There shall be no gasketed connections utilized with a fusible polyvinyl chloride sweep.
3. Standard fusible polyvinyl chloride sweep or bend angles shall not be greater than 22.5 degrees, and shall be used in nominal diameters ranging from 4 inch through 16 inch.

D SLEEVE-TYPE COUPLINGS

1. Sleeve-type mechanical couplings shall be manufactured for use with PVC pipe, and may be restrained or unrestrained as indicated in the construction documents.

E EXPANSION AND FLEXIBLE COUPLINGS

1. Expansion-type mechanical couplings shall be manufactured for use with PVC pipe, and may be restrained or unrestrained as indicated in the construction documents.

F CONNECTION HARDWARE

1. Bolts and nuts for buried service shall be made of non-corrosive, high-strength, low-alloy steel having the characteristics specified in ANSI/AWWA C111/A21.11, regardless of any other protective coating.

G CONNECTION TO SANITARY SEWER MANHOLES AND STRUCTURES

1. Fusible polyvinylchloride pipe shall be connected to manholes and other structures to provide a leak-free, properly graded flow into or out of the manhole or structure.
2. Connections to existing manholes and structures shall be as indicated in the construction documents.
 - 1) For a cored or drilled opening provide a flexible, watertight connection that meets and/or exceeds ASTM C923.
 - 2) For a knock out opening, provide a watertight connection (waterstop or other method) meeting the material requirements of ASTM C923 that is securely attached to the pipe with stainless steel bands or other means.
 - 3) Grout opening in manhole wall with non-shrink grout. Pour concrete collar around pipe and outside manhole opening. Provide flexible pipe joint or flexible connector within 2 feet of the collar.
3. Connections to a new manhole or structure shall be as indicated in the construction documents.
 - 1) A flexible, watertight gasket per ASTM C 923 shall be cast integrally with riser section(s) for all precast manhole and structures.
 - 2) Drop connections shall be required where shown on drawings.

3) Grout internal joint space with non-shrink grout.

PART 3 - EXECUTION

3.01 DELIVERY AND OFF-LOADING

- A All pipe shall be bundled or packaged in such a manner as to provide adequate protection of the ends during transportation to the site. Any pipe damaged in shipment shall be replaced as directed by the owner or engineer.
- B Each pipe shipment should be inspected prior to unloading to see if the load has shifted or otherwise been damaged. Notify owner or engineer immediately if more than immaterial damage is found. Each pipe shipment should be checked for quantity and proper pipe size, color, and type.
- C Pipe should be loaded, off-loaded, and otherwise handled in accordance with AWWA M23, and all of the pipe supplier's guidelines shall be followed.
- D Off-loading devices such as chains, wire rope, chokers, or other pipe handling implements that may scratch, nick, cut, or gouge the pipe are strictly prohibited.
- E During removal and handling, be sure that the pipe does not strike anything. Significant impact could cause damage, particularly during cold weather.
- F If appropriate unloading equipment is not available, pipe may be unloaded by removing individual pieces. Care should be taken to insure that pipe is not dropped or damaged. Pipe should be carefully lowered, not dropped, from trucks.

3.02 HANDLING AND STORAGE

- A Any length of pipe showing a crack or which has received a blow that may have caused an incident fracture, even though no such fracture can be seen, shall be marked as rejected and removed at once from the work. Damaged areas, or possible areas of damage may be removed by cutting out and removing the suspected incident fracture area. Limits of the acceptable length of pipe shall be determined by the owner or engineer.
- B Any scratch or gouge greater than 10% of the wall thickness will be considered significant and can be rejected unless determined acceptable by the owner or engineer.
- C Pipe lengths should be stored and placed on level ground. Pipe should be stored at the job site in the unit packaging provided by the manufacturer. Caution should be exercised to avoid compression, damage, or deformation to the ends of the pipe. The interior of the pipe, as well as all end surfaces, should be kept free from dirt and foreign matter.
- D Pipe shall be handled and supported with the use of woven fiber pipe slings or approved equal. Care shall be exercised when handling the pipe to not cut, gouge, scratch or otherwise abrade the piping in any way.
- E If pipe is to be stored for periods of 1 year or longer, the pipe should be shaded or otherwise shielded from direct sunlight. Covering of the pipe which allows for temperature build-up is strictly prohibited. Pipe should be covered with an

opaque material while permitting adequate air circulation above and around the pipe as required to prevent excess heat accumulation.

F Pipe shall be stored and stacked per the pipe supplier's guidelines.

3.03 FUSION PROCESS

A GENERAL

1. Fusible polyvinylchloride pipe will be handled in a safe and non-destructive manner before, during, and after the fusion process and in accordance with this specification and pipe supplier's guidelines.
2. Fusible polyvinylchloride pipe will be fused by qualified fusion technicians, as documented by the pipe supplier.
3. Each fusion joint shall be recorded and logged by an electronic monitoring device (data logger) connected to the fusion machine.
4. Only appropriately sized and outfitted fusion machines that have been approved by the pipe supplier shall be used for the fusion process. Fusion machines must incorporate the following elements:
 - a) HEAT PLATE - Heat plates shall be in good condition with no deep gouges or scratches. Plates shall be clean and free of any debris or contamination. Heater controls shall function properly; cord and plug shall be in good condition. The appropriately sized heat plate shall be capable of maintaining a uniform and consistent heat profile and temperature for the size of pipe being fused, per the pipe supplier's guidelines.
 - b) CARRIAGE – Carriage shall travel smoothly with no binding at less than 50 psi. Jaws shall be in good condition with proper inserts for the pipe size being fused. Insert pins shall be installed with no interference to carriage travel.
 - c) GENERAL MACHINE - Overview of machine body shall yield no obvious defects, missing parts, or potential safety issues during fusion.
 - d) DATA LOGGING DEVICE – An approved datalogging device with the current version of the pipe supplier's recommended and compatible software shall be used. Datalogging device operations and maintenance manual shall be with the unit at all times. If fusing for extended periods of time, an independent 110V power source shall be available to extend battery life.
5. Other equipment specifically required for the fusion process shall include the following:
 - a) Pipe rollers shall be used for support of pipe to either side of the machine
 - b) A weather protection canopy that allows full machine motion of the heat plate, fusion assembly and carriage shall be provided for fusion in

inclement, extreme temperatures, and /or windy weather, per the pipe supplier's recommendations.

- c) An infrared (IR) pyrometer for checking pipe and heat plate temperatures.
- d) Fusion machine operations and maintenance manual shall be kept with the fusion machine at all times.
- e) Facing blades specifically designed for cutting fusible polyvinylchloride pipe shall be used.

B JOINT RECORDING

Each fusion joint shall be recorded and logged by an electronic monitoring device (data logger) connected to the fusion machine. The fusion data logging and joint report shall be generated by software developed specifically for the butt-fusion of fusible polyvinyl chloride pipe. The software shall register and/or record the parameters required by the pipe supplier and these specifications. Data not logged by the data logger shall be logged manually and be included in the Fusion Technician's joint report.

3.04 GENERAL INSTALLATION

- A Installation guidelines from the pipe supplier shall be followed for all installations.
- B The fusible polyvinylchloride pipe will be installed in a manner so as not to exceed the recommended bending radius.
- C Where fusible polyvinylchloride pipe is installed by pulling in tension, the recommended Safe Pulling Force established by the pipe supplier shall not be exceeded.

3.05 PREPARATION PRIOR TO MAKING CONNECTIONS INTO EXISTING PIPING SYSTEMS

- A Approximate locations for existing piping systems are shown in the construction documents. Prior to making connections into existing piping systems, the contractor shall:
 - 1. Field verify location, size, piping material, and piping system of the existing pipe.
 - 2. Obtain all required fittings, which may include saddles, sleeve type couplings, flanges, tees, or others as shown in the construction documents.
 - 3. Have installed all temporary pumps and/or pipes in accordance with established connection plans.
- B Unless otherwise approved, new piping systems shall be completely assembled and successfully tested prior to making connections into existing pipe systems.

3.06 PIPE SYSTEM CONNECTIONS

- A Pipe connections shall be installed per applicable standards and regulations, as

well as per the connection manufacturer's guidelines and as indicated in the construction documents. Pipe connections to structures shall be installed per applicable standards and regulations, as well as per the connection manufacturer's guidelines.

3.07 TAPPING FOR POTABLE AND NON-POTABLE WATER APPLICATIONS

- A Tapping shall be performed using standard tapping saddles designed for use on PVC piping in accordance with AWWA C605. Tapping shall be performed only with use of tap saddles or sleeves. **NO DIRECT TAPPING WILL BE PERMITTED.** Tapping shall be performed in accordance with the applicable sections for Saddle Tapping per Uni-Pub-8.
- B All connections requiring a larger diameter than that recommended by the pipe supplier, shall be made with a pipe connection as specified and indicated on the drawings.
- C Equipment used for tapping shall be made specifically for tapping PVC pipe:
 - 1. Tapping bits shall be slotted "shell" style cutters, specifically made for PVC pipe. 'Hole saws' made for cutting wood, steel, ductile iron, or other materials are strictly prohibited.
 - 2. Manually operated or power operated drilling machines may be used.
- D Taps may be performed while the pipeline is filled with water and under pressure ('wet' tap,) or when the pipeline is not filled with water and not under pressure ('dry' tap).

3.08 TESTING

- A Testing shall comply with all applicable jurisdictional building codes, statutes, standards, regulations, and laws.
- B **HYDROSTATIC TESTING AND LEAKAGE TESTING FOR PRESSURE PIPING**
 - 1. Hydrostatic and leakage testing for piping systems that contain mechanical jointing as well as fused PVC jointing shall comply with AWWA C605.
 - 2. Unless agreed to or otherwise designated by the owner or engineer, for a simultaneous hydrostatic and leakage test following installation, a pressure equal to 150% of working pressure at point of test, but not less than 125% of normal working pressure at highest elevation shall be applied. The duration of the pressure test shall be for two (2) hours.
 - 3. If hydrostatic testing and leakage testing are performed at separate times, follow procedures as outlined in AWWA C605.
 - 4. In preparation for pressure testing the following parameters must be followed:
 - 1) All air must be vented from the pipeline prior to pressurization. This may be accomplished with the use of the air relief valves or corporation stop valves, vent piping in the testing hardware or end caps, or any other

method which adequately allows air to escape the pipeline at all high points. Venting may also be accomplished by ‘flushing’ the pipeline in accordance with the parameters and procedures as described in AWWA C605.

- 2) The pipeline must be fully restrained prior to pressurization. This includes complete installation of all mechanical restraints per the restraint manufacturer’s guidelines, whether permanent or temporary to the final installation. This also includes the installation and curing of any and all required thrust blocking. All appurtenances included in the pressure test, including valves, blow-offs, and air-relief valves shall be checked for proper installation and restraint prior to beginning the test.
- 3) Temporary pipeline alignments that are being tested, such as those that are partially installed in their permanent location shall be configured to minimize the amount of potentially trapped air in the pipeline.

C LEAKAGE TESTING FOR NON-PRESSURE PIPING

1. Gravity sanitary sewers that contain mechanical jointing in addition to fused PVC joints may need to be tested for excessive leakage.
2. Gravity sanitary sewer leakage testing may include appropriate water or low pressure air testing. The leakage outward or inward (exfiltration or infiltration) shall not exceed 25 gallons per inch of pipe diameter per mile per day for any section of the system. An exfiltration or infiltration test shall be performed with a minimum positive head of two feet. The air test, if used, shall be conducted in accordance with one of the following Standards:
 - 1) ASTM F1417
 - 2) UNI-B-6
3. The testing method selected shall properly consider the existing groundwater elevations during the test.

D DEFLECTION TESTING FOR NON-PRESSURE PIPING

1. After completion of the backfill, the engineer or owner may require that a deflection test be performed.
2. Deflection tests should be conducted using a go/no-go mandrel. The mandrel’s outside dimension shall be sized to permit no more than 7.5 percent deflection. The percent deflection shall be established from the base inside diameter of the pipe. If the internal beading of the fused joints for the pipe is not required to be removed, the mandrel shall account for this clearance as well. The mandrel shall be approved by the owner or engineer prior to use. Lines that permit safe entry may allow other deflection test options, such as direct measurements.

E DISINFECTION OF THE PIPELINE FOR POTABLE WATER PIPING

1. After installation, the pipeline, having passed all required testing, shall be disinfected prior to being put into service. Unless otherwise directed by the

owner or engineer, the pipeline will be disinfected per AWWA C651.

F PARTIAL TESTING

1. Segments of the pipe may be tested separately in accordance with standard testing procedure, as approved by the owner and engineer.

****END OF SECTION****