

DRISCOPEX® 6500 Series

DRISCOPEX® 6500 Series MDPE Gas Distribution Pipe



DRISCOPEX® MDPE Pipe is manufactured to meet your needs in compliance with ASTM D2513, NSF Gas and DOT 49 CFR 192.

Selected sizes conform to CSA B137.4 and UPC product standards.

Produced from only the highest rated MDPE pipe material, DRISCOPEX® 6500 Series Pipe is manufactured from a PE 2708 and PE 80 resin listed in PPI-TR4.

DRISCOPEX® MDPE Pipe Advantages:

- ✓ Durable
- ✓ Leak Tight
- ✓ Excellent Flow
- ✓ Abrasion Resistant
- ✓ Fatigue Free
- ✓ Impact Resistant
- ✓ Trenchless Install
- ✓ Bend Radius
- ✓ Chemical Resistant
- ✓ UV Protection
- ✓ Flexibility
- ✓ Environmental

DriscoPlex MDPE Series Pipe Material Physical Properties

Property	Standard	Typical Value†
Material Designation Code	ASTM D2513	PE 2708
Cell Classification	ASTM D3350	234373E; 234375E
Density [2]	ASTM D1505	0.939 g/cm ³ (Yellow)
Melt Index [3]	ASTM D1238	0.18 g/10 min
Flexural Modulus [4]	ASTM D790	>90,000 psi
Tensile Strength [3]	ASTM D638 Type IV	2,800 psi
SCG (PENT) [7]	ASTM F1473	>2,000 hours
HDB at 73°F (23°C) [3]	ASTM D2837	1,250 psi
Color; UV Stabilizer [E]	ASTM D3350	Yellow; UV Stabilized
RCP, Full Scale, at 32°F (0°C)	ISO 13478	>123 psi (>8.5 bar)

This is not a product specification and does not guarantee or establish specific minimum or maximum values or manufacturing tolerance for material or tubing products to be supplied. Values obtained from tests of specimens taken from tubing product may vary from these typical values. The RCP properties were determined on 8" SDR 11 pipe.

DRISCOPLEX® 6500 Series

CTS = Copper Tube Size

Nominal Size (Inches)	Dimension Ratio	Outside Diameter (Inches)	Minimum Wall (Inches)	MAOP @ 73°F per CFR Part 192.121 (psi)	Weight (lbs) per 100 ft.	Coil/Joint (feet)	Nominal Packing Dimensions ID / OD / Width	Number Coils / Joints Per Pallet or Bundle	Pallet/ Bundle Footage	Number Pallet / Bundles Per Truck	48 ft. Truck
1/2"	*NA	0.625	0.09	125	6.5	1,000'	30"/44"/6"	12	12,000'	26	312,000'
1"	*NA	1.125	0.099	77	14	500'	30"/42"/11"	8	4,000'	26	104,000'

*N/A - The wall thickness is minimum per D2513 and not a function of DR.

IPS = Iron Pipe Size

Nominal Size (Inches)	Dimension Ratio	Outside Diameter (Inches)	Minimum Wall (Inches)	MAOP @ 73°F per CFR Part 192.121 (psi)	Weight (lbs) per 100 ft.	Coil/Joint (feet)	Nominal Packing Dimensions ID / OD / Width	Number Coils / Joints Per Pallet or Bundle	Pallet/ Bundle Footage	Number Pallet / Bundles Per Truck	48 ft. Truck
3/4"	DR 11	1.05	0.095	80	12	500'	30"/44"/10"	7	3,500'	26	91,000'
1"	DR 11	1.315	0.120	80	19	500'	30"/44"/12"	6	3,000'	26	78,000'
1 1/4"	DR 10	1.66	0.166	89	33	500'	48"/72"/7-1/2"	12	6,000'	7	42,000'
1 1/2"	DR 11	1.9	0.173	80	40	500'	48"/75"/8-1/2"	8	4,000'	7	28,000'
2"	DR 11	2.375	0.216	80	63	500'	52"/78"/13"	7	3,500'	7	24,500'
3"	DR 11	3.5	0.318	80	136	500'	70"/96"/23-3/4"	4	2,000'	6	12,000'
	DR 11.5		0.304	76	131	40'	soft bundles	50	2,000'	14	28,000'
	500'		70"/96"/23-3/4"	4	2,000'	6	12,000'				
4"	DR 11	4.5	0.409	80	225	500'	70"/93"/41"	2	1,000'	6	6,000'
	DR 11.5		0.391	76	217	40'	soft bundles	29	1,160'	14	16,240'
			600'	70"/93"/49-1/2"	upright	12	7,200'				
			1,000'	84"/116"/49"	upright	8 coils	8,000'				
DR 13.5	0.333	64	187	40'	soft bundles	29	1160'	14	16,240'		
6"	DR 11	6.625	0.602	80	489	40'	soft bundles	13	520'	14	7,280'
	DR 11.5		0.576	76	471	40'	soft bundles	13	520'	14	7,280'
			500'	84"/120"/50"	upright	8 coils	4,000'				
			40'	soft bundles	13	14	7,280'				
DR 13.5	0.491	64	407	500'	84"/120"/50"	upright	8 coils	4,000'			
8"	DR 11	8.625	0.784	80	828	40'	soft bundles	9	360'	10	3,600'
	DR 11.5		0.75	76	798	40'	soft bundles	9	360'	10	3,600'
	DR 13.5		0.639	64	690						
10"	DR 11	10.75	0.977	80	1287	40'	soft bundles	9	360'	7	2,520'
	DR 11.5		0.935	76	1237	40'	soft bundles	9	360'	7	2,520'
12"	DR 13.5	12.75	0.944	64	1507	40'	bulk packs	8 joints/layer	320'	6	1,920'

This product flyer is intended for reference purposes. It should not be used in place of the advice from a licensed Professional Engineer. Pressure Rating is based on an operating temperature of 73°F per 49 CFR 192. Pipe weights are calculated in accordance with PPI TR-7. Nominal OD and Minimum wall plus 6% is used in estimating fluid flow. Actual ID will vary. When designing components to fit the pipe ID, refer to pipe dimensions and tolerances in the applicable pipe manufacturing specification. - These wall thicknesses are minimum per D2513 and not a function of DR.



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DRISCOPLEX® 6500

MDPE PIPE and FITTINGS DATA SHEET

DriscoPlex® 6500 Pipe and Fittings meet or exceed:

ASTM D2513, D2683, D3261
 CAN/CSA-B137.4
 UPC
 ASTM D3350, cell classification PE234373E and PE234375E
 PPI TR-4 designations PE2708 (PE2406) and PE80
 PPI TN-30

DriscoPlex® 6500 Yellow MDPE Pipe and Fittings for

Natural Gas Distribution, LPG and
 Propane Gas Distribution, Yard Gas
 Iron Pipe Size OD (IPS) ½" to 24",
 Copper Tube Size OD (CTS) ½" to 1 ¼"
 Coils available up through 6"

Outdoor Storage up to Three (3) Years per ASTM D2513

NOMINAL PIPE PROPERTIES ⁽¹⁾	UNIT	TEST METHOD	VALUE
Density	gms / cm ³	ASTM D1505	0.939 (yellow)
Melt Index (MI) Condition 190°C / 2.16kg	gms / 10 min	ASTM D1238	0.18
Hydrostatic Design Basis 73°F (23°C)	psi	ASTM D2837	1250
Hydrostatic Design Basis 140°F (60°C)	psi	ASTM D2837	1000
Minimum Required Strength	MPa (psi)	ISO 9080	8.0 (116)
Rapid Crack Propagation (Pc) 0°C (32°F) ⁽³⁾	Bar (psi)	ISO 13478	8.5 (123)
Color; UV Stabilizer [E]	--	ASTM D3350	Yellow; UV stabilized
Pipe Test Category	--	ASTM D2513	CEE
NOMINAL MATERIAL PROPERTIES ^{(1) (2)}	UNIT	TEST METHOD	VALUE
Flexural Modulus at 2% secant	psi	ASTM D790	>90,000
Tensile Strength at Yield	psi	ASTM D638 Type IV	2,800
Elongation at Break 2 in / min., Type IV bar	%	ASTM D638	>800
Hardness	Shore D	ASTM D2240	63
PENT	hrs	ASTM F1473	>2,000
Vicat Softening Temperature	°F	ASTM D1525	227
Brittleness Temperature	°F	ASTM D746	< -103

1. This is not a product specification and does not guarantee or establish specific minimum or maximum values or manufacturing tolerances for material or piping products to be supplied.
2. Values obtained from tests of specimens taken from piping product may vary from these typical values.
3. Determination made on 8" DR-11 pipes for Full Scale test. Pc calculated in accordance with ISO 13478.

When Performance Matters Rely on
Performance Pipe

Bulletin: PP107 / March 2010

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Performance Pipe, a division of Chevron Phillips Chemical Company LP | 5085 W. Park Blvd | Suite 500 | Plano, TX 75093 | Phone: 800-527-0662 | Fax: 972-599-7348

This data sheet provides typical properties for Performance Pipe DriscoPlex® pipe and fittings. Before using this product, the user is advised and cautioned to make their own determination and assessment of the safety and suitability of the product for the specific use in question and is further advised against relying on the information contained herein as it may relate to any specific use or application. It is the ultimate responsibility of the user to ensure that the product is suited and the information is applicable to the user's specific application. Chevron Phillips Chemical Company LP does not make, and expressly disclaims, all warranties, including warranties of merchantability or fitness for a particular purpose, regardless of whether oral or written, express or implied, allegedly arising from any usage of any trade or from any course of dealing in connection with the use of information contained herein or the product itself. The user expressly assumes all risk and liability, whether based in contract, tort or otherwise, in connection with the use of the information contained herein or the product itself. Further, information contained herein is given without reference to any intellectual property issues, as well as federal, state or local laws which may be encountered in the use thereof. Such questions should be investigated by the user. The data sheet may change periodically. Visit www.PerformancePipe.com for the most current data sheet.



Please visit www.performancepipe.com for the most up-to-date information

NOTE: The sizes and packaging shown represent typical Performance Pipe products. Other sizes and/or packaging may be available. Contact Performance Pipe for additional information. Pipe weights are calculated in accordance with PPI TR-7. Dimensions and weights are subject to change without notice.

CTS = COPPER TUBE SIZE

Part Number	Nominal Size (Inches)	Minimum Wall (Inches)	Nominal Outside Diameter (Inches)	Dimension Ratio	MAOP (psig per CFR Part 192 @ 73.4° F or less)	Weight per 100 ft.	Coil/ Joint (feet)	Nominal Packing Dimensions ID/OD/Width	Number Coils/Joints Per Pallet or Bundle	Pallet / Bundle Footage	Number Pallet / Bundles Per Truck	48 ft. Truck
1002425	1/2"	0.090	0.625	7.0	100	6.5	1,000'	30" / 44" / 6"	12	12,000'	26	312,000'
1002445	1"	0.099	1.125	11.5	76	14.0	500'	30" / 42" / 11"	8	4,000'	26	104,000'

IPS = IRON PIPE SIZE

Part Number	Nominal Size (Inches)	Minimum Wall (Inches)	Nominal Outside Diameter (Inches)	Dimension Ratio	MAOP (psig per CFR Part 192 @ 73.4° F or less)	Weight per 100 ft.	Coil/ Joint (feet)	Nominal Packing Dimensions ID/OD/Width	Number Coils/Joints Per Pallet or Bundle	Pallet / Bundle Footage	Number Pallet / Bundles Per Truck	48 ft. Truck
1002239	3/4"	0.095	1.050	11	80	12	500'	30" / 44" / 10"	7	3,500'	26	91,000'
1002249	1"	0.120	1.315	11	80	19	500'	30" / 44" / 12"	6	3,000'	26	78,000'
1002263	1 1/4"	0.166	1.660	10	89	33	500'	48" / 72" / 7½"	12	6,000'	7	42,000'
1002284	2"	0.216	2.375	11	80	63	500'	52" / 78" / 13"	7	3,500'	7	24,500'
1002323	3"	0.304	3.500	11.5	76	131	40'	soft bundles	50	2,000'	14	28,000'
1002318							500'	70" / 96" / 23¾"	4	2,000'	6	12,000'
1002349	4"	0.391	4.500	11.5	76	217	40'	soft bundles	29	1,160'	14	16,240'
1088779							600'	70" / 93" / 49½"	upright		12	7,200'
1010590							1,000'	84" / 116" / 49"	upright		8 coils	8,000'
1002367	6"	0.576	6.625	11.5	76	471	40'	soft bundles	13	520'	14	7,280'
1002363							500'	84" / 120" / 50"	upright		8 coils	4,000'
1002373		0.491	13.5	64	407	40'	soft bundles	13	520'	14	7,280'	
1002368						500'	84" / 120" / 50"	upright		8 coils	4,000'	
1002384	8"	0.750	8.625	11.5	76	798	40'	soft bundles	9	360'	10	3,600'
1071013		0.639		13.5	64	690						
1007003	12"	0.944	12.750	13.5	64	1507	40'	bulk packs	8 jts/layer	320'	6	1,920'

NOTE: The August revision was strictly for ease in reading columns for minimum wall and DR. No specific data was changed.

DRISCOPLEX[®] 6500

MODEL SPECIFICATION

The user may choose to adopt part or all of this Model Specification; however, the user should ensure that all parts used are appropriate for the user's purpose. See notice below.

1 General Terms and Conditions

- 1.1 **Scope.** This specification covers requirements for DriscoPlex[®] 6500 PE2708 (PE2406) polyethylene pipe and fittings for underground gas distribution systems. All work shall be performed in accordance with these specifications.
- 1.2 **Engineered and Approved Plans.** Underground gas distribution piping construction shall be performed in accordance with engineered construction plans for the work prepared under the direction of a Professional Engineer. Plans shall conform to the standards and regulations for gas distribution piping. Pipe, fittings, and the installation shall meet the applicable requirements of the U. S. Department of Transportation, Pipeline Safety Regulations, Title 49, Code of Federal Regulations, and Part 192. Private systems shall meet relevant requirements of NFPA 54/ANSI Z223.1, or NFPA 58, or ASME B31.8.
- 1.3 **Referenced Standards.** Where all or part of a Federal, ASTM, ANSI, NFPA, etc., standard specification is incorporated by reference in these Specifications, the reference standard shall be the latest edition and revision.
- 1.4 **Licenses and Permits.** A licensed and bonded Contractor shall perform all underground gas distribution piping construction work. The Contractor shall secure all necessary permits before commencing construction.
- 1.5 **Inspections.** All work shall be inspected by an Authorized Representative of the Owner or Operator who shall have the authority to halt construction if, in his opinion, these specifications or standard construction practices are not being followed. Whenever any portion of these specifications is violated, the Project Engineer or his Authorized Representative shall, by written notice, order further construction to cease until all deficiencies are corrected. A copy of the order shall be filed with the Contractor's license application for future review. If the deficiencies are not corrected, performance shall be required of the Contractor's surety.

2 Polyethylene Pipe and Fittings

- 2.1 **Qualification of Manufacturers.** The Manufacturer shall have manufacturing and quality control facilities that are capable of producing and assuring the quality of the pipe and fittings required by these Specifications. The Manufacturer's production facilities shall be open for inspection by the Customer or his Authorized Representative. The pipe and fitting manufacturer shall be ISO Certified in accordance with the current edition of ISO 9001 and a documented quality management system that defines product specifications and manufacturing and quality assurance procedures that assure conformance with customer and applicable regulatory requirements. Upon request, the manufacturer shall provide a current Certificate of Compliance form and independent ISO 9000 Registrar.

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- 2.2 Approved Manufacturers. Manufacturers that are qualified and approved by the Project Engineer are listed below. Products from unapproved manufacturers are prohibited. Performance Pipe, a division of Chevron Phillips Chemical Company LP
- 2.3 Materials. Materials used for the manufacture of polyethylene pipe and fittings shall be PE 2708 (PE2406) medium density polyethylene meeting cell classification 234373E per ASTM D 3350; and shall be Listed in PPI (Plastics Pipe Institute) TR-4 with standard grade HDB ratings of 1250 psi at 73°F, and 1000 psi at 140°F. All pipe and fittings materials shall be opaque yellow in color. Materials shall be stabilized against ultraviolet deterioration and shall be suitable for unprotected outdoor storage for at least four (4) years.
- 2.4 Polyethylene Pipe. Pipe shall be DriscoPlex[®] 6500 PE 2708 (PE2406) polyethylene pipe, and shall be manufactured and tested in accordance with the latest published edition of ASTM D 2513.
- 2.5 Polyethylene Fittings. Polyethylene heat fusion fittings shall be manufactured and tested by the pipe manufacturer in accordance with ASTM D 2513 and D.O.T. requirements.
- 2.6 Manufacturer's Quality Control. The pipe and fitting manufacturer shall have an established quality control program responsible for inspecting incoming and outgoing materials. Incoming polyethylene materials shall be inspected for density, melt flow rate, UV protection and contamination. The supplier shall certify the cell classification properties of incoming material. Incoming materials shall be approved by Quality Control before processing into finished goods.
- 2.6.1 Outgoing materials shall be checked for diameter, wall thickness, roundness, concentricity, toe-in, inside and outside surface finish, markings, and end cut. Quality control shall verify production checks, and test for density, melt flow rate, hoop tensile strength and ductility. X-ray inspection procedures shall be used to inspect molded fittings for voids, and knit line strength shall be tested. All fabricated fittings shall be inspected for joint quality and alignment. Representative tests to verify long-term performance shall include slow crack growth, pipe inside surface ductility, and ambient and elevated temperature sustained pressure testing.
- 2.6.2 Permanent Records. The Manufacturer shall maintain records of manufacturing location, pipe production and resin lots for at least 50 years.
- 2.7 Compliance Tests. The Manufacturer shall certify the inspection and testing of the materials and products. In case of conflict with Manufacturer's certifications, the Contractor, Project Engineer, or Operator may request retesting by the Manufacturer or have retests performed by an outside testing service. All retesting shall be at the requestor's expense, and shall be performed in accordance with the Specifications.

3 Joining

- 3.1 Heat Fusion Joining. Butt, socket, and saddle fusion joints in polyethylene gas piping shall be made using procedures that have been qualified and approved by the Operator in accordance with Title 49, CFR, and Part 192.283.

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- 3.1.1 In accordance with CFR. 49, part 192, Section 192.285, the Operator shall ensure that all persons making heat fusion joints have been qualified to make joints in accordance with the Operator's Approved Qualified Fusion Procedures. The Operator shall maintain records of qualified personnel, and shall certify that qualification training was received not more than 12 months before commencing construction. The Contractor shall ensure that all persons making heat fusion joints are qualified in accordance with this section.
- 3.1.2 The Manufacturer shall offer qualified fusion procedures and training materials for the use of the Operator.
- 3.1.3 **Butt Fusion of Unlike Wall Thickness.** Butt fusion shall be performed between pipe ends, or pipe ends and fitting outlets that have the same outside diameter and are not different in wall thickness by more than one Standard DR, for example, SDR 9 (9.3, 9.33) to SDR 11 (11.5), or SDR 11 (11.5) to SDR 13.5. Transitions between unlike wall thickness greater than one SDR shall be made with a transition nipple (a short length of the heavier wall pipe with one end machined to the lighter wall) or by mechanical means or electrofusion. Standard DR's for polyethylene pipe are 7.3, 9, 11, 13.5, 17 and 21.
- 3.2 Joining by Other Means. Polyethylene gas pipe and fittings may be joined together or to other materials by transition fittings, fully restrained mechanical couplings, or electrofusion. These devices shall be designed for joining polyethylene to another material and shall be approved by the Operator for use in his gas distribution system. When joining by other means, the installation instructions of the joining device manufacturer shall be observed.
- 3.2.1 When mechanical OD compression couplings are used, polyethylene gas pipe shall be reinforced with a stiffener in the pipe bore. Stiffeners shall be properly sized for the diameter and wall thickness of polyethylene pipe being joined. For service pipe connections, the stiffener length shall match the pipe end penetration depth into the coupling.

4 Installation

- 4.1 General. Polyethylene gas distribution piping shall be installed be in accordance with CFR 49, Part 192, Subpart G (mains), Subpart H (service lines), applicable codes and regulations and ASTM D 2774.
- 4.1.1 When delivered, a receiving inspection shall be performed, and any shipping damage shall be reported to the Manufacturer within 7 days.
- 4.2 Burial Depth. All polyethylene gas distribution piping shall be installed in accordance with applicable federal, state and local codes and shall have at least 12" of cover in private property, and at least 18 inches of cover in streets and roads.

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- 4.3 Excavation. Trench excavations shall conform to the plans and drawings, as otherwise authorized in writing by the Project Engineer or his Approved Representative, and in accordance with all applicable codes. The Contractor shall remove excess groundwater. Where necessary, trench walls shall be shored or reinforced, and all necessary precautions shall be taken to ensure a safe working environment.
- 4.4 Foundation & Bedding. Pipe shall be laid on grade and on a stable foundation. Unstable trench bottom soils shall be removed, and a 6" foundation or bedding of compacted Class I material shall be installed to pipe bottom grade. A trench cut in rock or stony soil shall be excavated to 6" below pipe bottom grade, and brought back to grade with compacted Class I bedding. All ledge rock, boulders and large stones shall be removed.
- 4.5 Pipe Handling. Pipe shall be handled in a safe manner that avoids damage to the product. When lifting with slings, only wide fabric choker slings capable of safely carrying the load, shall be used to lift, move, or lower pipe and fittings. Wire rope or chain shall not be used. Slings shall be of sufficient capacity for the load and shall be inspected before use. Worn or damaged equipment shall not be used.
- 4.6 Backfilling. Embedment material soil type and particle size shall be in accordance with ASTM D 2774. Embedment shall be placed and compacted to at least 90% Standard Proctor Density in 6" lifts to at least 6" above the pipe crown. During embedment placement and compaction, care shall be taken to ensure that the haunch areas below the pipe springline are completely filled and free of voids.
- 4.7 Protection against shear and bending loads. In accordance with ASTM D 2774, connections shall be protected where an underground polyethylene branch or service pipe is joined to a branch fitting such as a service saddle, branch saddle or tapping tee on a main pipe, and where pipes enter or exit casings or walls. The area surrounding the connection shall be embedded in properly placed, compacted backfill, preferably in combination with a protective sleeve or other mechanical structural support to protect the polyethylene pipe against shear and bending loads.
- 4.8 Final Backfilling. Final backfill shall be placed and compacted to finished grade. Native soils may be used provided the soil is free of debris, stones, boulders, clumps, frozen clods or the like larger than 8" in their largest dimension.

5 Testing

- 5.1 Fusion Quality. The Contractor shall ensure the field set-up and operation of the fusion equipment, and the fusion procedure used by the Contractor's fusion operator while on site. Upon request by the Owner, the Contractor shall verify field fusion quality by making and testing a trial fusion. The trial fusion shall be allowed to cool completely; then test straps shall be cut out and bent strap tested in accordance with ASTM D 2657. If the bent strap test of the trial fusion fails at the joint, the field fusions represented by the trial fusion shall be rejected. The Contractor at his expense shall make all necessary corrections to equipment, set-up, operation and fusion procedure, and shall re-make the rejected fusions.

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- 5.2 Leak Testing. Leak testing shall be conducted in accordance with Performance Pipe Technical Note 802 *Leak Testing*.
- 5.2.1 Polyethylene gas distribution systems that are subject to D.O.T. Pipeline Safety Regulations shall be tested in accordance CFR 49, Part 192, Sections 192.509, 192.511, or 192.513 as applicable.
- 5.2.2 The Contractor shall take all precautions to eliminate hazards to persons near lines being tested. Pipes being tested shall be supervised at all times.

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- 1.5 **Inspections.** All work shall be inspected by an Authorized Representative of the Owner or Operator who shall have the authority to halt construction if, in his opinion, these specifications or standard construction practices are not being followed. Whenever any portion of these specifications is violated, the Project Engineer or his Authorized Representative shall, by written notice, order further construction to cease until all deficiencies are corrected. A copy of the order shall be filed with the Contractor's license application for future review. If the deficiencies are not corrected, performance shall be required of the Contractor's surety.

2 Polyethylene Pipe and Fittings

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- 2.3 Materials. Materials used for the manufacture of polyethylene pipe and fittings shall be PE 2708 (PE2406) medium density polyethylene meeting cell classification 234373E per ASTM D 3350; and shall be Listed in PPI (Plastics Pipe Institute) TR-4 with standard grade HDB ratings of 1250 psi at 73°F, and 1000 psi at 140°F. All pipe and fittings materials shall be opaque yellow in color. Materials shall be stabilized against ultraviolet deterioration and shall be suitable for unprotected outdoor storage for at least four (4) years.
- 2.4 Polyethylene Pipe. Pipe shall be DriscoPlex[®] 6500 PE 2708 (PE2406) polyethylene pipe, and shall be manufactured and tested in accordance with the latest published edition of ASTM D 2513.
- 2.5 Polyethylene Fittings. Polyethylene heat fusion fittings shall be manufactured and tested by the pipe manufacturer in accordance with ASTM D 2513 and D.O.T. requirements.
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3 Joining

- 3.1 Heat Fusion Joining. Butt, socket, and saddle fusion joints in polyethylene gas piping shall be made using procedures that have been qualified and approved by the Operator in accordance with Title 49, CFR, and Part 192.283.

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- 3.1.1 In accordance with CFR. 49, part 192, Section 192.285, the Operator shall ensure that all persons making heat fusion joints have been qualified to make joints in accordance with the Operator's Approved Qualified Fusion Procedures. The Operator shall maintain records of qualified personnel, and shall certify that qualification training was received not more than 12 months before commencing construction. The Contractor shall ensure that all persons making heat fusion joints are qualified in accordance with this section.
- 3.1.2 The Manufacturer shall offer qualified fusion procedures and training materials for the use of the Operator.
- 3.1.3 **Butt Fusion of Unlike Wall Thickness.** Butt fusion shall be performed between pipe ends, or pipe ends and fitting outlets that have the same outside diameter and are not different in wall thickness by more than one Standard DR, for example, SDR 9 (9.3, 9.33) to SDR 11 (11.5), or SDR 11 (11.5) to SDR 13.5. Transitions between unlike wall thickness greater than one SDR shall be made with a transition nipple (a short length of the heavier wall pipe with one end machined to the lighter wall) or by mechanical means or electrofusion. Standard DR's for polyethylene pipe are 7.3, 9, 11, 13.5, 17 and 21.
- 3.2 Joining by Other Means. Polyethylene gas pipe and fittings may be joined together or to other materials by transition fittings, fully restrained mechanical couplings, or electrofusion. These devices shall be designed for joining polyethylene to another material and shall be approved by the Operator for use in his gas distribution system. When joining by other means, the installation instructions of the joining device manufacturer shall be observed.
- 3.2.1 When mechanical OD compression couplings are used, polyethylene gas pipe shall be reinforced with a stiffener in the pipe bore. Stiffeners shall be properly sized for the diameter and wall thickness of polyethylene pipe being joined. For service pipe connections, the stiffener length shall match the pipe end penetration depth into the coupling.

4 Installation

- 4.1 General. Polyethylene gas distribution piping shall be installed be in accordance with CFR 49, Part 192, Subpart G (mains), Subpart H (service lines), applicable codes and regulations and ASTM D 2774.
- 4.1.1 When delivered, a receiving inspection shall be performed, and any shipping damage shall be reported to the Manufacturer within 7 days.
- 4.2 Burial Depth. All polyethylene gas distribution piping shall be installed in accordance with applicable federal, state and local codes and shall have at least 12" of cover in private property, and at least 18 inches of cover in streets and roads.

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- 4.3 Excavation. Trench excavations shall conform to the plans and drawings, as otherwise authorized in writing by the Project Engineer or his Approved Representative, and in accordance with all applicable codes. The Contractor shall remove excess groundwater. Where necessary, trench walls shall be shored or reinforced, and all necessary precautions shall be taken to ensure a safe working environment.
- 4.4 Foundation & Bedding. Pipe shall be laid on grade and on a stable foundation. Unstable trench bottom soils shall be removed, and a 6" foundation or bedding of compacted Class I material shall be installed to pipe bottom grade. A trench cut in rock or stony soil shall be excavated to 6" below pipe bottom grade, and brought back to grade with compacted Class I bedding. All ledge rock, boulders and large stones shall be removed.
- 4.5 Pipe Handling. Pipe shall be handled in a safe manner that avoids damage to the product. When lifting with slings, only wide fabric choker slings capable of safely carrying the load, shall be used to lift, move, or lower pipe and fittings. Wire rope or chain shall not be used. Slings shall be of sufficient capacity for the load and shall be inspected before use. Worn or damaged equipment shall not be used.
- 4.6 Backfilling. Embedment material soil type and particle size shall be in accordance with ASTM D 2774. Embedment shall be placed and compacted to at least 90% Standard Proctor Density in 6" lifts to at least 6" above the pipe crown. During embedment placement and compaction, care shall be taken to ensure that the haunch areas below the pipe springline are completely filled and free of voids.
- 4.7 Protection against shear and bending loads. In accordance with ASTM D 2774, connections shall be protected where an underground polyethylene branch or service pipe is joined to a branch fitting such as a service saddle, branch saddle or tapping tee on a main pipe, and where pipes enter or exit casings or walls. The area surrounding the connection shall be embedded in properly placed, compacted backfill, preferably in combination with a protective sleeve or other mechanical structural support to protect the polyethylene pipe against shear and bending loads.
- 4.8 Final Backfilling. Final backfill shall be placed and compacted to finished grade. Native soils may be used provided the soil is free of debris, stones, boulders, clumps, frozen clods or the like larger than 8" in their largest dimension.

5 Testing

- 5.1 Fusion Quality. The Contractor shall ensure the field set-up and operation of the fusion equipment, and the fusion procedure used by the Contractor's fusion operator while on site. Upon request by the Owner, the Contractor shall verify field fusion quality by making and testing a trial fusion. The trial fusion shall be allowed to cool completely; then test straps shall be cut out and bent strap tested in accordance with ASTM D 2657. If the bent strap test of the trial fusion fails at the joint, the field fusions represented by the trial fusion shall be rejected. The Contractor at his expense shall make all necessary corrections to equipment, set-up, operation and fusion procedure, and shall re-make the rejected fusions.

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- 5.2 Leak Testing. Leak testing shall be conducted in accordance with Performance Pipe Technical Note 802 *Leak Testing*.
- 5.2.1 Polyethylene gas distribution systems that are subject to D.O.T. Pipeline Safety Regulations shall be tested in accordance CFR 49, Part 192, Sections 192.509, 192.511, or 192.513 as applicable.
- 5.2.2 The Contractor shall take all precautions to eliminate hazards to persons near lines being tested. Pipes being tested shall be supervised at all times.



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DRISCOPLEX® 6500

MDPE PIPE and FITTINGS DATA SHEET

DriscoPlex® 6500 Pipe and Fittings meet or exceed:

ASTM D2513, D2683, D3261
 CAN/CSA-B137.4
 UPC
 ASTM D3350, cell classification PE234373E and PE234375E
 PPI TR-4 designations PE2708 (PE2406) and PE80
 PPI TN-30

DriscoPlex® 6500 Yellow MDPE Pipe and Fittings for

Natural Gas Distribution, LPG and
 Propane Gas Distribution, Yard Gas
 Iron Pipe Size OD (IPS) ½" to 24",
 Copper Tube Size OD (CTS) ½" to 1 ¼"
 Coils available up through 6"

Outdoor Storage up to Three (3) Years per ASTM D2513

NOMINAL PIPE PROPERTIES ⁽¹⁾	UNIT	TEST METHOD	VALUE
Density	gms / cm ³	ASTM D1505	0.939 (yellow)
Melt Index (MI) Condition 190°C / 2.16kg	gms / 10 min	ASTM D1238	0.18
Hydrostatic Design Basis 73°F (23°C)	psi	ASTM D2837	1250
Hydrostatic Design Basis 140°F (60°C)	psi	ASTM D2837	1000
Minimum Required Strength	MPa (psi)	ISO 9080	8.0 (116)
Rapid Crack Propagation (Pc) 0°C (32°F) ⁽³⁾	Bar (psi)	ISO 13478	8.5 (123)
Color; UV Stabilizer [E]	--	ASTM D3350	Yellow; UV stabilized
Pipe Test Category	--	ASTM D2513	CEE
NOMINAL MATERIAL PROPERTIES ^{(1) (2)}	UNIT	TEST METHOD	VALUE
Flexural Modulus at 2% secant	psi	ASTM D790	>90,000
Tensile Strength at Yield	psi	ASTM D638 Type IV	2,800
Elongation at Break 2 in / min., Type IV bar	%	ASTM D638	>800
Hardness	Shore D	ASTM D2240	63
PENT	hrs	ASTM F1473	>2,000
Vicat Softening Temperature	°F	ASTM D1525	227
Brittleness Temperature	°F	ASTM D746	< -103

1. This is not a product specification and does not guarantee or establish specific minimum or maximum values or manufacturing tolerances for material or piping products to be supplied.
2. Values obtained from tests of specimens taken from piping product may vary from these typical values.
3. Determination made on 8" DR-11 pipes for Full Scale test. Pc calculated in accordance with ISO 13478.

When Performance Matters Rely on
Performance Pipe

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This data sheet provides typical properties for Performance Pipe DriscoPlex® pipe and fittings. Before using this product, the user is advised and cautioned to make their own determination and assessment of the safety and suitability of the product for the specific use in question and is further advised against relying on the information contained herein as it may relate to any specific use or application. It is the ultimate responsibility of the user to ensure that the product is suited and the information is applicable to the user's specific application. Chevron Phillips Chemical Company LP does not make, and expressly disclaims, all warranties, including warranties of merchantability or fitness for a particular purpose, regardless of whether oral or written, express or implied, allegedly arising from any usage of any trade or from any course of dealing in connection with the use of information contained herein or the product itself. The user expressly assumes all risk and liability, whether based in contract, tort or otherwise, in connection with the use of the information contained herein or the product itself. Further, information contained herein is given without reference to any intellectual property issues, as well as federal, state or local laws which may be encountered in the use thereof. Such questions should be investigated by the user. The data sheet may change periodically. Visit www.PerformancePipe.com for the most current data sheet.



HDPE Pipe Suppliers in Pennsylvania, New Jersey 215-256-1715 <http://www.deaconind.com> sales@deaconind.com

Please visit www.performancepipe.com for the most up-to-date information

CTS = COPPER TUBE SIZE

Nominal Size (Inches)	Dimension Ratio	Outside Diameter (Inches)	Minimum Wall (Inches)	MAOP (psig per CFR Part 192 @100 F or less)	Weight (lbs) per 100 ft.	Coil/Joint (feet)	Nominal Packing Dimensions ID / OD / Width	Number Coils / Joints Per Pallet or Bundle	Pallet/ Bundle Footage	Number Pallet / Bundles Per Truck	48 ft. Truck
1/2"	7	0.625	0.09	100	6.5	1,000'	30"/44"/6"	12	12,000'	26	312,000'
1"	11.5	1.125	0.099	76	14	500'	30"/42"/11"	8	4,000'	26	104,000'

IPS = IRON PIPE SIZE

Nominal Size (Inches)	Dimension Ratio	Outside Diameter (Inches)	Minimum Wall (Inches)	MAOP (psig per CFR Part 192 @100 F or less)	Weight (lbs) per 100 ft.	Coil/Joint (feet)	Nominal Packing Dimensions ID / OD / Width	Number Coils / Joints Per Pallet or Bundle	Pallet/ Bundle Footage	Number Pallet / Bundles Per Truck	48 ft. Truck
3/4"	11	1.05	0.095	80	12	500'	30"/44"/10"	7	3,500'	26	91,000'
1"	11	1.315	0.12	80	19	500'	30"/44"/12"	6	3,000'	26	78,000'
1 1/4"	10	1.66	0.166	89	33	500'	48"/72"/7-1/2"	12	6,000'	7	42,000'
1 1/2"	11	1.9	0.173	80	40	500'	48"/75"/8-1/2"	8	4,000'	7	28,000'
2"	11	2.375	0.216	80	63	500'	52"/78"/13"	7	3,500'	7	24,500'
3"	11	3.5	0.318	80	136	500'	70"/96"/23-3/4"	4	2,000'	6	12,000'
	11.5	3.5	0.304	76	131	40'	soft bundles	50	2,000'	14	28,000'
						500'	70"/96"/23-3/4"	4	2,000'	6	12,000'
4"	11	4.5	0.409	80	225	500'	70"/93"/41"	2	1,000'	6	6,000'
	11.5	4.5	0.391	76	217	40'	soft bundles	29	1,160'	14	16,240'
						600'	70"/93"/49-1/2"	upright		12	7,200'
						1,000'	84"/116"/49"	upright		8 coils	8,000'
6"	11.5	6.625	0.576	76	471	40'	soft bundles	13	520'	14	7,280'
						500'	84"/120"/50"	upright		8 coils	4,000'
	13.5		0.491	64	407	40'	soft bundles	13		14	7,280'
						500'	84"/120"/50"	upright		8 coils	4,000'
8"	11.5	8.625	0.75	76	798	40'	soft bundles	9	360'	10	3,600'
	13.5		0.639	64	690						
12"	13.5	12.75	0.944	64	1507	40'	bulk packs	8 joints/layer	320'	6	1,920'

Pressure Rating is based on an operating temperature of 73°F per 49 CFR 192. Pipe weights are calculated in accordance with PPI TR-7. Nominal OD and Minimum wall plus 6% is used in estimating fluid flow. Actual ID will vary. When designing components to fit the pipe ID, refer to pipe dimensions and tolerances in the applicable pipe manufacturing specification.