



Designation: C479 – 04 (Reapproved 2022)

Standard Specification for Vitrified Clay Liner Plates¹

This standard is issued under the fixed designation C479; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification establishes the criteria for the acceptance of vitrified clay liner plates used to protectively line or face pipe, culverts, abutments, structures, or appurtenances.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

C43 Terminology of Structural Clay Products (Withdrawn 2009)³

C301 Test Methods for Vitrified Clay Pipe

3. Terminology

3.1 *Definitions*—Clay, fire clay, shale, and surface clay are defined in Terminology **C43**.

4. Classification

4.1 Liner plates manufactured in accordance with this specification shall be known as curved liner plates or flat liner plates.

5. Materials and Manufacture

5.1 Liner plates shall be manufactured from fire clay, shale, surface clay, or a combination of these materials that, when

¹ This specification is under the jurisdiction of ASTM Committee **C04** on Vitrified Clay Pipe and is the direct responsibility of Subcommittee **C04.20** on Methods of Test and Specifications.

Current edition approved Sept. 1, 2022. Published September 2022. Originally approved in 1961. Last previous edition approved in 2017 as C479 – 04(2017). DOI: 10.1520/C0479-04R22.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

formed into liner plates and fired to suitable temperatures, yield a product that is strong, durable, serviceable, free of objectionable defects, and conform to this specification.

6. Physical and Chemical Requirements

6.1 *Absorption*—The absorption of liner plates shall not exceed 6 %.

6.2 *Acid Resistance:*

6.2.1 This test is used to determine the resistance of liner plates to the action of acids. The test shall be performed only when specified.

6.2.2 Liner plates shall be acceptable if the acid-soluble matter does not exceed 0.25 %.

7. Dimensions and Permissible Variations

7.1 *Tenon Ribs:*

7.1.1 Liner plates shall have either three or five longitudinal, monolithic, dovetail tenon ribs uniformly and symmetrically spaced on the back of the plate (see **Note 1**). When five tenon ribs are used, the outer fin of the exterior tenons shall be eliminated so that parallel jointing faces between abutting plates may be achieved.

NOTE 1—Special liner plates are available for linings where tenon ribs are not desired. They are furnished in the same thickness, length, and width as standard liner plates.

7.1.2 Tenon ribs shall be of trapezoidal cross section to firmly key or attach the plate into the backup material with a mortising type of fastening. The ratio of the dimension of the larger base to the smaller base shall be about 8 to 5, with the smaller base dimension to be $\frac{5}{8} \pm \frac{1}{8}$ in. (16 ± 3.2 mm). The smaller base of the trapezoid shall be adjacent to the liner plate.

7.2 *Length:*

7.2.1 Length is the overall dimension of the liner plate when measured in the same direction as the tenon ribs.

7.2.2 Liner plates shall be available in standard lengths of 6 in. (150 mm), 9 in. (230 mm), 12 in. (305 mm), 18 in. (460 mm), or 24 in. (610 mm), with a tolerance of $+0, -\frac{1}{4}$ in./ft of length ($+0, -21$ mm/m of length).

7.3 *Width:*

7.3.1 The width of curved liner plates shall be $9\frac{1}{4} \pm \frac{1}{8}$ in. (235 ± 3.2 mm) measured along the radial arc.

7.3.2 The width of flat liner plates shall be $9 \pm \frac{1}{8}$ in. (230 ± 3.2 mm).