



Standard Specification for Lap-Joint Type Flange Adapters for Polyethylene Pressure Pipe in Nominal Pipe Sizes $\frac{3}{4}$ in. to 65 in.¹

This standard is issued under the fixed designation F2880; 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 covers the polyethylene material and dimensions applicable to flange adapters (FAs) used to connect polyethylene pipes to other flanged pipe and components such as valves and flanged fittings. This standard describes outside diameter controlled polyethylene (PE) pipe flange adapters (FAs) in diameters ranging from $\frac{3}{4}$ in. through 65 in. (12 mm through 1600 mm). The flange adapters may be manufactured by various methods including injection molding, compression molding, and machining from billet or thick-wall polyethylene pipe.

1.2 The flange adapter (FA) is the principal component of the lap-joint flanged assembly widely used for several decades in low-pressure to high-pressure polyethylene pipe systems for all types of pressurized flow (gas and liquid) applications. The flange adapter's physical shape consists of the pipe-like Neck which is monolithic with its Hub. The Neck is intended to be butt-fused or fusion coupled to the pipe-line; while the Hub face is intended to affect the seal when subjected to the distributed load from the back up ring with its properly torqued bolt-studs and nuts.

NOTE 1—Polyethylene pipe flange adapters with slip on bolt rings are intended for use being bolted to each other or to be bolted to metal flanges having (primarily) Class 150 bolt hole patterns such as those presented in metal flange standards ASME B16.5, ASME B16.47 and AWWA C207.

1.3 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.

1.4 The use of gaskets and gasket selection are often an integral component of the flange adapter assembly. See the Plastic Pipe Institute Technical Note TN-38 for more information regarding HDPE flanged joints.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appro-*

priate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.

1.6 *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

- D2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings
- D2513 Specification for Polyethylene (PE) Gas Pressure Pipe, Tubing, and Fittings
- D2837 Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products
- D3035 Specification for Polyethylene (PE) Plastic Pipe (DR-PR) Based on Controlled Outside Diameter
- D3261 Specification for Butt Heat Fusion Polyethylene (PE) Plastic Fittings for Polyethylene (PE) Plastic Pipe and Tubing
- D3350 Specification for Polyethylene Plastics Pipe and Fittings Materials
- F714 Specification for Polyethylene (PE) Plastic Pipe (DR-PR) Based on Outside Diameter
- F2206 Specification for Fabricated Fittings of Butt-Fused Polyethylene (PE)
- F3034 Specification for Billets made by Winding Molten Extruded Stress-Rated High Density Polyethylene (HDPE)

2.2 ASME Standards:³

- B16.5 "Pipe Flanges and Flanged Fittings"
- B16.47 "Large Diameter Steel Flanges: NPS 26 through

¹ This specification is under the jurisdiction of ASTM Committee F17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.10 on Fittings.

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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 Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

- NPS 60" Class #150 – Series A
 B36.10M Welded and Seamless Wrought Steel Pipe
 B36.19M Stainless Steel Pipe
 2.3 AWWA Standards:⁴
 C207 "Standard for Steel Pipe Flanges for Waterworks Service, Sizes 4 In. Through 144 In. (100 mm Through 3,600 mm) ; Class #150 /Series B, D & E.
 C901 "Standard for Polyethylene (PE) pressure pipe and tubing, ½ " through 3" for Water Service."
 C906 Standard for Polyethylene (PE) Pressure Pipe and Fittings, 4 In. (100 mm) Through 63 In. (1,600 mm), for Water Distribution and Transmission
 M55 Polyethylene Pipe - Design and Installation
 2.4 NSF Standards:⁵
 NSF/ANSI Standard No. 14 for Plastic Piping Components and Related Materials
 NSF/ANSI Standard No. 61 for Drinking Water System Components—Health Effects
 2.5 PPI Documents:⁶
 TN-38 "Bolt Torque for Polyethylene Flanged Joints"
 TR-3 "Policies and Procedures for Developing Hydrostatic Design Basis (HDB), Pressure Design Basis (PDB), Strength Design Basis (SDB), and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe
 TR-4 "HDB/HDS/SDB/PDB/MRS Listed Materials"
 PPI Handbook of Polyethylene Pipe and Fittings

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *billet, n*—a mass formed from a single polyethylene compound in the approximate shape of a thick-walled cylindrical shell (see Specification F3034).

⁴ Available from American Water Works Association (AWWA), 6666 W. Quincy Ave., Denver, CO 80235, <http://www.awwa.org>.

⁵ Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, <http://www.nsf.org>.

⁶ Available from Plastics Pipe Institute (PPI), 105 Decker Court, Suite 825, Irving, TX 75062, <http://www.plasticpipe.org>.

3.1.2 *dimension ratio (DR)*—The ratio of a pipe's specified nominal outside diameter to its specified minimum wall thickness. DR as applied to Flange Adapters is Neck OD ÷ neck minimum wall.

3.1.3 *DIPS*—Ductile-Iron Pipe Size; the outside diameter (OD) of plastic pipe that matches the nominal standard diameters of metal ductile iron, or, cast-iron pipes; also commonly referred to as DIOD, Ductile Iron Outside Diameter, previously known as CIOD or cast-iron OD.

3.1.4 *flange adapter*—One component of the two piece lap-joint flange assembly; It is a one piece polyethylene device whose geometry consists of two shapes: the wide, circular, seal-face disk, with central hole, which transitions along its length into pipe of smaller diameter and wall thickness, matched to the pipe-main to which it is to be joined. (Refer to Fig. 1).

3.1.5 *Hub*—The disk ring, or collar, extending radially outward from the pipe OD at the pipe termination.

3.1.6 *Hydrostatic design stress (HDS)*—The maximum allowable hoop stress in the pipe wall for pipe that is subjected to sustained long-term hydrostatic pressure. The hydrostatic design stress is determined by multiplying the hydrostatic design basis by the PPI recommended design factor for water service. HDS ratings for PE materials are published by PPI in TR-4.

3.1.7 *IPS*—Iron Pipe Size (steel pipe) outside diameters; replaced with nominal pipe sizes (NPS) per as listed with the plastic pipe standards and B36.10M and B36.19M.

3.1.8 *lap-joint flange ring*—the loose metal ring that transfers the load from the bolts through the hub to the seal face.

3.1.9 *neck*—The long barrel of the flange adapter with OD and wall thickness matched to the pipeline dimensions. The neck length must be sufficient for fusion joining in the fusion machine used.

3.1.10 *seal face*—The front of the Hub, which contacts the mating flange, which radially confines fluid pressure by compressive stress when subjected to distributed load from torqued bolts.

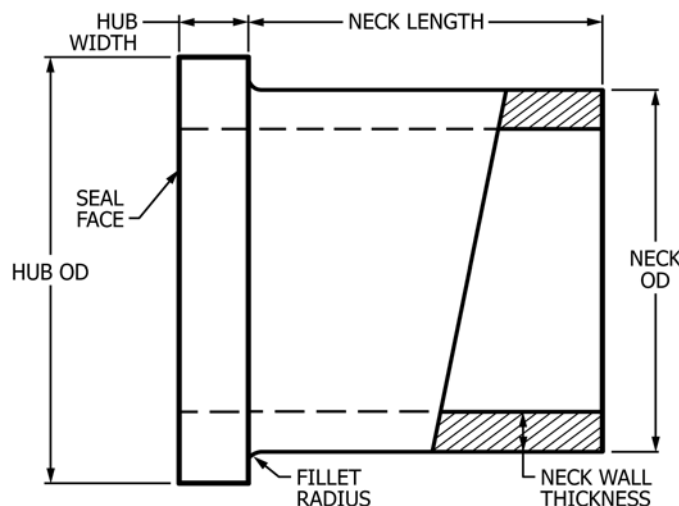


FIG. 1 Polyethylene Flange Adapter Geometry