



APPLICATION:

Corrosion resistant CLEAR pressure pipe, IPS sizes 1/4" through 8", for use at temperatures up to and including 140°F. Pressure rating (130 psi to 570 psi) varies with schedule, pipe size, and temperature as stated on page 2 of this specification and in Harvel Plastics, Inc. Clear bulletin (Product Bulletin HPB-107). Generally resistant to most acids, bases, salts, aliphatic solutions, oxidants, and halogens. Chemical resistance data should be referenced for proper material selection. Pipe exhibits excellent physical properties and flammability characteristics. Typical applications include process, sight glass, and dual containment piping for: chemical processing, high purity applications, food processing, pharmaceuticals, laboratory use, waste treatment, plating, and other applications involving fluid transfer where visual monitoring of process lines is warranted.

SCOPE:

This specification outlines minimum manufacturing requirements for CLEAR Polyvinyl Chloride (PVC) schedule 40 & schedule 80 iron pipe size (IPS) pressure pipe. This pipe is intended for use in systems where the fluid conveyed does not exceed 140° F. This pipe meets and or exceeds applicable industry standards and requirements as set forth by the American Society for Testing and Materials (ASTM).

PVC MATERIALS:

The material used in the manufacture of the pipe shall be a rigid polyvinyl chloride (PVC) compound, with a Cell Classification of 12454 as defined in ASTM D1784. This compound shall comply with the provisions of Title 21 United States FDA Code of Federal Regulations and shall be safe for use with food contact applications. This compound shall be transparent in color, and shall be approved by NSF International for use with potable water (NSF Std 61).

DIMENSIONS:

PVC Clear Schedule 40 and Schedule 80 pipe shall be manufactured in strict accordance with the dimensional requirements of ASTM D1785 to schedule 40 or schedule 80 dimensions and tolerances as applicable. All PVC Clear pipe shall meet the minimum burst pressure requirements and water pressure rating requirements of PVC Type II, Grade I, established for PVC 2110 as defined in ASTM D1785. Each production run of pipe shall also meet or exceed the test requirements for materials, workmanship, flattening, and extrusion quality defined in ASTM D1785. All belled-end pipe shall have tapered sockets to create an interference-type fit, which meet or exceed the dimensional requirements and the minimum socket length for pressure-type sockets as defined in ASTM D2672.

MARKING:

All Clear PVC Schedule 40 & Sch 80 pipe shall be permanently embossed with the manufacturers name or (or the manufacturers trademark when privately labeled).

SAMPLE SPECIFICATION:

All PVC Schedule 40 & Schedule 80 CLEAR pipe shall be manufactured from a Type I, Grade I Polyvinyl Chloride (PVC) compound with a Cell Classification of 12454 per ASTM D1784. The pipe shall be manufactured in strict compliance to ASTM D1785, consistently meeting and/or exceeding the applicable Quality Assurance test requirements of this standard with regard to material, dimensions, workmanship, burst pressure, flattening, and extrusion quality. The pipe shall be manufactured in the USA by an ISO 9002 certified manufacturer. All PVC CLEAR pipe shall be packaged immediately after its manufacture to prevent damage, and shall then be stored indoors at the manufacturing site until shipped from factory. All pipe shall be manufactured by HARVEL PLASTICS, INC.



PRODUCT SPECIFICATION CLEAR PVC Pipe Schedule 40 and Schedule 80

Schedule 40

Pipe Size (in.)	O.D.	Avg. I.D.	Min. Wall	Nominal Wt./ft.	Max. W.P. PSI
1/4	0.540	0.344	0.088	0.086	390
3/8	0.675	0.473	0.091	0.115	310
1/2	0.840	0.602	0.109	0.170	300
3/4	1.050	0.804	0.113	0.226	240
1	1.315	1.029	0.133	0.333	220
1-1/4	1.660	1.360	0.140	0.450	180
1-1/2	1.900	1.590	0.145	0.537	170
2	2.375	2.047	0.154	0.720	140
2-1/2	2.875	2.445	0.203	1.136	150
3	3.500	3.042	0.216	1.488	130
3-1/2	4.000	3.521	0.226	1.789	120
4	4.500	3.998	0.237	2.118	110
6	6.625	6.031	0.280	3.733	90
6x1/8*	6.625	6.335	0.125	1.647	45
8	8.625	7.942	0.322	5.619	80

*This size does not meet Schedule 40 criteria.
Pressure ratings shown are for water, non-shock @ 73°F

Schedule 80

Pipe Size (in.)	O.D.	Avg. I.D.	Min. Wall	Nominal Wt./ft.	Max. W.P. PSI
1/4	0.540	0.282	0.119	0.105	570
3/8	0.675	0.403	0.126	0.146	460
1/2	0.840	0.526	0.147	0.213	420
3/4	1.050	0.722	0.154	0.289	340
1	1.315	0.936	0.179	0.424	320
1-1/4	1.660	1.255	0.191	0.586	260
1-1/2	1.900	1.476	0.200	0.711	240
2	2.375	1.913	0.218	0.984	200
3	3.500	2.864	0.300	2.010	190
4	4.500	3.786	0.337	2.938	160
6	6.625	5.709	0.432	5.610	140

Physical Properties

Property	value	test method
Cell Classification	12454	ASTM D1784
Specific Gravity	1.337 g/cu.cm @ 73°F	ASTM D792
Izod Impact	.76 ft-lbs / inch notch @ 73°F	ASTM D256
Tensile Strength @ yield	7094 psi @ 73°F	ASTM D638
Modulus of Elasticity	435,000 psi	ASTM D638
Flexural Strength	13,500 @ 75°F	ASTM D790
Flexural Modulus	458,000 @ 75°F	ASTM D790
Compressive Strength	8,300 @ 75°F	ASTM D695
Compressive Modulus	307,000 @ 75°F	ASTM D695
Coefficient of Linear Expansion	3.77×10^{-5} in / in °F	ASTM D696
Flammability	V-0	UL-94
Heat Distortion Temperature	158°F	ASTM D256
Glass Transition Temperature	176°F	
Hardness, Shore D	76 ± 3	ASTM D2240
Hardness, Rockwell	76/79R	ASTM D785

Chemical resistance data should be referenced for proper material selection and possible de-rating when working with fluids other than water. Refer to Harvel Plastics 112/401 Product Bulletin for chemical resistance and installation data.

The pressure ratings given are for water, non-shock, @ 73°F. The following temperature de-rating factors are to be applied to the working pressure ratings (WP) listed when operating at elevated temperatures.

De-rating Factor	
Operating Temp. (°F)	De-rating Factor
73	1.00
80	0.88
90	0.75
100	0.62
110	0.51
120	0.40
130	0.31
140	0.22

Multiply the working pressure rating of the selected pipe at 73°F, by the appropriate de-rating factor to determine the maximum working pressure rating of the pipe at the elevated temperature chosen.

EX: 4" PVC SCH 40 CLEAR @ 120°F = ?

$$110 \text{ psi} \times 0.40 = 44 \text{ psi max. @ } 120^\circ\text{F}$$

THE MAXIMUM SERVICE TEMPERATURE FOR PVC CLEAR IS 140°F.

Solvent cemented joints should be utilized when working at or near maximum temperatures. Harvel Plastics does not recommend the use of PVC for threaded connections at temperatures above 110°F; use flanged joints, unions, or roll grooved couplings where disassembly is necessary at elevated temperatures.

Threading of Sch 40 PVC Clear pipe is not a recommended practice due to insufficient wall thickness.

Note: Although Harvel Clear maintains its physical properties when exposed to many substances, exposure to certain chemicals can affect the clarity of the product overtime. Certain nitrogen containing organics, bleaches, oxidative agents and acids may result in discoloration. Testing under actual use conditions is recommended.

Exposure to sunlight (U.V.R.) will also affect clarity. Clear products do not contain U.V. stabilizers and are not recommended for outdoor use unless adequate protection is applied.

Contact Harvel Tech Services for additional information.