

APPENDIX C

TYPICAL PIPE SPECIFICATIONS

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Agrément Certificate
02/H069
Product Sheet 1

JFC CORRIPIPE TWINWALL DRAINAGE SYSTEM

**JFC CORRIPIPE TWINWALL HIGH-DENSITY POLYETHYLENE FILTER AND
CARRIER PIPES AND COUPLINGS**

This Certificate is issued under the Highway Authorities' Product Approval Scheme (HAPAS) by the British Board of Agrément (BBA) in conjunction with the Highways Agency (HA) (acting on behalf of the overseeing organisations of the Department for Transport; the Scottish Executive; the Welsh Assembly Government and the Department for Regional Development, Northern Ireland), the Association of Directors of Environment, Economy, Planning and Transport (ADEPT), the Local Government Technical Advisers' Group and industry bodies. HAPAS Agrément Certificates are normally each subject to a review every five years.

PRODUCT SCOPE AND SUMMARY OF CERTIFICATE

This Certificate relates to JFC CorriPipe Twinwall High-Density Polyethylene Filter and Carrier Pipes and Couplings, in a range of sizes for use in highway drainage for the collection and disposal of surface and sub-surface water.

AGRÉMENT CERTIFICATION INCLUDES:

- factors relating to compliance with HAPAS requirements
- factors relating to compliance with Regulations where applicable
- independently verified technical specification
- assessment criteria and technical investigations
- design considerations
- installation guidance
- regular surveillance of production
- formal five-yearly review.



KEY FACTORS ASSESSED

Strength — the fittings have adequate strength to resist loads associated with installation and service (see section 5).

Performance of joints — the system will remain watertight under normal service conditions (see section 6).

Durability — the system will have a service life in excess of 50 years (see section 10).

The BBA has awarded this Agrément Certificate to the company named above for the system described herein. This system has been assessed by the BBA as being fit for its intended use provided it is installed, used and maintained as set out in this Certificate.

On behalf of the British Board of Agrément

Brian Chamberlain

Brian Chamberlain
Head of Approvals — Engineering

Greg Cooper

Greg Cooper
Chief Executive

Date of First issue: 18 July 2011

Originally certificated on 28 March 2002 (150 mm, 225 mm and 300 mm) and on 23 December 2005 (375 mm, 450 mm and 600 mm).

The BBA is a UKAS accredited certification body — Number 113. The schedule of the current scope of accreditation for product certification is available in pdf format via the UKAS link on the BBA website at www.bbacerts.co.uk

Readers are advised to check the validity and latest issue number of this Agrément Certificate by either referring to the BBA website or contacting the BBA direct.

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HAPAS Requirements

Requirements

The general requirements for drains are contained in the Manual of Contract Documents for Highway Works (MCHW), Volume 1.

The general requirements for structural wall pipes and fittings are contained in the MCHW, Volume 1, Clause 518.

Further information and guidance is given in the MCHW, Volume 2 and Volume 3 (Drawing Numbers F1 and F2).

Additional site requirements may be included on particular contracts.

Regulations

Construction (Design and Management) Regulations 2007

Construction (Design and Management) Regulations (Northern Ireland) 2007

Information in this Certificate may assist the client, CDM co-ordinator, designer and contractors to address their obligations under these Regulations.

See sections: 1 *Description* (1.3), 2 *Delivery and site handling* (2.1), 3 *General* and 11 *General* of the *Installation* part of this Certificate.

General

This Certificate relates to JFC CorriPipe Twinwall 150 mm, 225 mm, 300 mm, 375 mm, 450 mm and 600 mm High-Density Polyethylene Filter and Carrier Pipes and Couplings.

The system is for use in highway drainage for the collection and disposal of surface and sub-surface water in accordance with Highways Agency (HA) requirements, *Manual of Contract Documents for Highway Works* (MCHW), Volume 1, Clause 518, and Volume 2, and the conditions set out in the *Design Considerations* and *Installation* parts of this Certificate.

Technical Specification

1 Description

1.1 JFC CorriPipe Twinwall 150 mm, 225 mm, 300 mm, 375 mm, 450 mm and 600 mm Diameter High-Density Polyethylene Filter and Carrier Pipes and Couplings are manufactured from a blended, black polyethylene by a twin extrusion process. The two high-density polyethylene pipes are extruded simultaneously, one inside the other, and heatwelded together in one continuous process.

1.2 The products tested and covered by this Certificate are manufactured from material with the specification given in Table 1.

Table 1 Material properties/specification

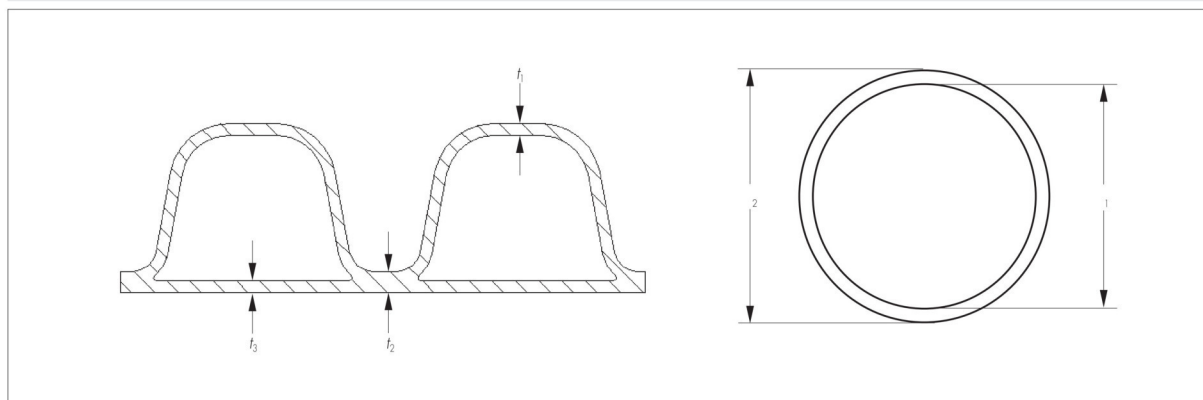
Property	Test method reference	Specification
Tensile properties	EN 638, ISO 527-2	≥18 MPa
Oxygen induction time	EN 728	≥4 mins
Melt flow rate	ISO 1133	≤0.75 g (10 mins) 2.16 kg at 190°C
Density	ISO 1183-3	≥935 kg·m ⁻³
Heat reversion	ISO 12091	N/A

1.3 The outer wall is corrugated and the inner wall is smooth finished. Details and dimensions are given in Table 2 and Figure 1.

Table 2 Pipe dimensions

Nominal internal pipe diameter d_1 (mm)	External pipe diameter d_2 (mm)	t_1 min (mm)	t_2 min (mm)	t_3 min (mm)	Nominal length (m)	Nominal weight (kg·m ⁻¹)	Pitch (mm)
150	178 ± 1.5	0.8	1.8	1.0	6	1.4	20.0
225	265 ± 2	0.9	2.6	1.2	6	3.0	25.5
300	354 ± 2.5	1.2	3.0	1.5	6	5.0	31.0
375	426 ± 3	1.5	3.5	1.5	6	6.0	39.9
450	512 ± 3	1.8	4.0	1.5	6	8.5	50.1
600	680 ± 4	2.1	4.3	1.8	6	14.5	66.9

Figure 1 Twinwall pipe



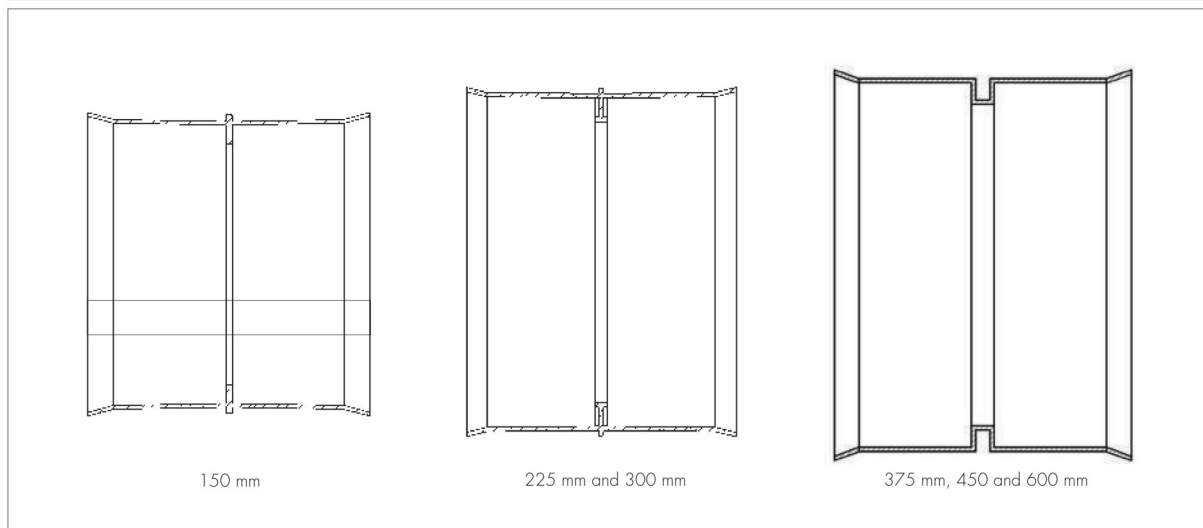
1.4 Black polypropylene couplings are available for the 150 mm, 225 mm and 300 mm sizes of pipe and black polyethylene for the 375 mm, 450 mm and 600 mm sizes (see Table 3 and Figure 2).

Table 3 Coupling dimensions

Nominal internal/external pipe diameter (mm)	Internal diameter		Nominal length (mm)	Nominal seal height (mm)
	at first dwell (mm)	at second dwell (mm)		
150/178	178	179	180	17.0
225/265	268	269	220	25.5
300/354	356	356.5	245	32.0
375/426	429	429	321	32.5
450/512	514	514	390	36.9
600/680	686	686	675	49.0

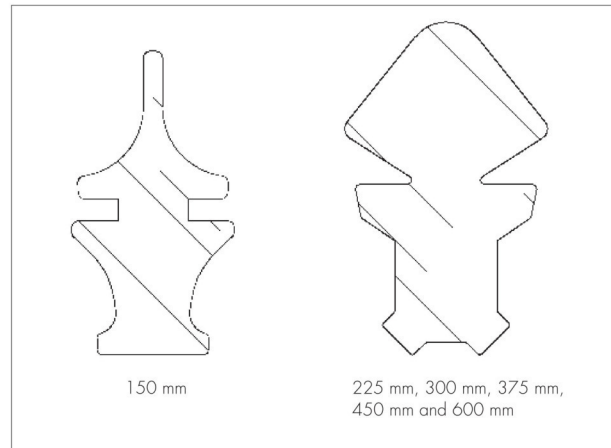
(1) Tapered along coupling length.

Figure 2 Couplings



1.5 Each coupling requires two rubber seals which are manufactured to BS EN 681-1 : 1996 (see Figure 3). The seals must be fitted in accordance with the installation instructions to ensure a watertight joint.

Figure 3 Seals

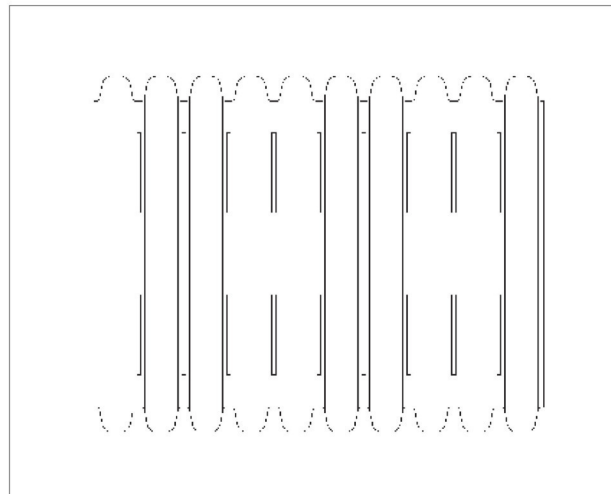


1.6 Pipes can be supplied either slotted or unslotted. Slotted pipe is available with the slots in the dwell between corrugations equally spaced around the circumference (see Table 4 and Figure 4).

Table 4 Slotted pipe details

Internal pipe diameter (nominal) (mm)	No of slots per alternate dwell	No of dwells per metre	Slot length (mm)	Slot width (mm)	Permeable area (minimum) ($\text{mm}^2 \cdot \text{m}^{-1}$)
150	4	51	15 to 20	2.0 to 2.5	6120
225	4	39	15 to 30	2.0 to 2.5	4680
300	4	32	20 to 40	2.0 to 2.5	5120
375	3	25	42 to 85	2.7 to 3.3	4263
450	3	20	48 to 85	2.8 to 3.5	4024
600	3	15	76 to 106	2.9 to 3.5	4942

Figure 4 Details of slots (optional)



1.7 Continuous quality control is exercised during manufacture. Checks include:

Pipes

- dimensional accuracy
- impact resistance
- short-term stiffness

Couplings

- dimensional accuracy/visual check.

1.8 A label bearing the BBA identification mark is attached to each pipe length and fitting or to each pack of pipes.

2 Delivery and site handling

2.1 Handling, storage and transportation should be in accordance with BS 5955-6 : 1980.

2.2 When long-term storage is envisaged, JFC CorriPipe twinwall slotted and unslotted pipes and couplings should be protected from direct sunlight. If protection cannot be provided, consideration must be given to the effects of daily exposure to direct sunlight:

- up to 3 months — negligible UV degradation but possible extreme surface temperatures of up to 80°C may cause some localised distortion
- 3 months to 12 months — may have significant effect on the impact resistance and physical properties
- over 12 months — damage will occur unless protection provided.

2.3 The manufacturer has the option of adding chemicals to provide enhanced UV stability on request.

2.4 Pipes are generally delivered in prepacked bundles and should be retained in their packaging until installation.

Assessment and Technical Investigations

The following is a summary of the assessment and technical investigations carried out on JFC CorriPipe Twinwall 150 mm, 225 mm, 300 mm, 375 mm, 450 mm and 600 mm Diameter High-Density Polyethylene Filter and Carrier Pipes and Couplings.

Design Considerations

3 General

JFC CorriPipe Twinwall 150 mm, 225 mm, 300 mm, 375 mm, 450 mm and 600 mm Diameter High-Density Polyethylene Filter and Carrier Pipes and Couplings comply with the requirements of the Highways Agency (HA) *Manual of Contract Documents for Highway Works* (MCHW), Volume 1, Clause 518.5 for pipe, Clause 518.6 for couplings and Clause 518.7 for the system, and is suitable for use in highways for the collection and disposal of surface and sub-surface water.

4 Practicability of installation

The pipes are installed using traditional drain-laying methods in accordance with HA requirements and the MCHW, Volume 1, Clauses 503, 505, 518.7 and 518.8. Due to the lightweight nature of the pipe material, handling and jointing are easily performed.

5 Strength

5.1 The pipes have a ring stiffness in excess of $6 \text{ kN}\cdot\text{m}^{-2}$, a creep ratio of less than 4 and adequate resistance to static loads.

5.2 The pipes have adequate resistance to impact loads to which they may be subjected during installation and in service.

6 Performance of joints

6.1 Joints on filter pipes made from pipe and couplings without the rubber seals are not partially watertight as defined in the MCHW, Volume 1, Clause 504.3.

6.2 Correctly made, the joints constructed from pipe and couplings with rubber seals remain watertight when subjected to deflection and distortion, and comply with the MCHW, Volume 1, Clauses 504.3 and 518.7 (see section 14).

7 Water infiltration

The slot area for the pipes exceeds the minimum requirement of 1000 mm^2 per metre length as given in the MCHW, Volume 1, Clause 518.3 (see Table 3).

8 Flow characteristics

8.1 The pipes will have normal flow characteristics associated with thermoplastics pipes.

8.2 Full-bore velocities are available from the *Tables for the Hydraulic Design of Pipes, Sewers and Channels*, Volume 2, 8th Edition, by H R Wallingford and D I H Barr. Appropriate values are based on the Colebrook-White equation. An appropriate value of roughness coefficient should be selected when designing the drainage system. For new pipes, a value of 0.006 is applicable, but for designs a value of 0.6 is generally used.

9 Maintenance

9.1 The slots are designed to restrict the ingress of silt into the drains.

9.2 Access to the system for cleaning should be provided by conventional methods.

9.3 The system can be rodded using flexible drain rods. In common with other standard plastic drainage systems, toothed root cutters and rods with metal ferrules, as used with some mechanical clearing systems, could damage the pipes and couplings and should not be used.

9.4 Tests indicate that the pipes have adequate resistance to cleansing using pressure jetting equipment (see section 13.1). It is recommended that low-pressure, high-volume systems are utilised in accordance with MCHW, Clause 520.

10 Durability

In the opinion of the BBA, the material from which the pipes and couplings are manufactured will not significantly deteriorate and the anticipated life of the system will be in excess of 50 years.

Installation

11 General

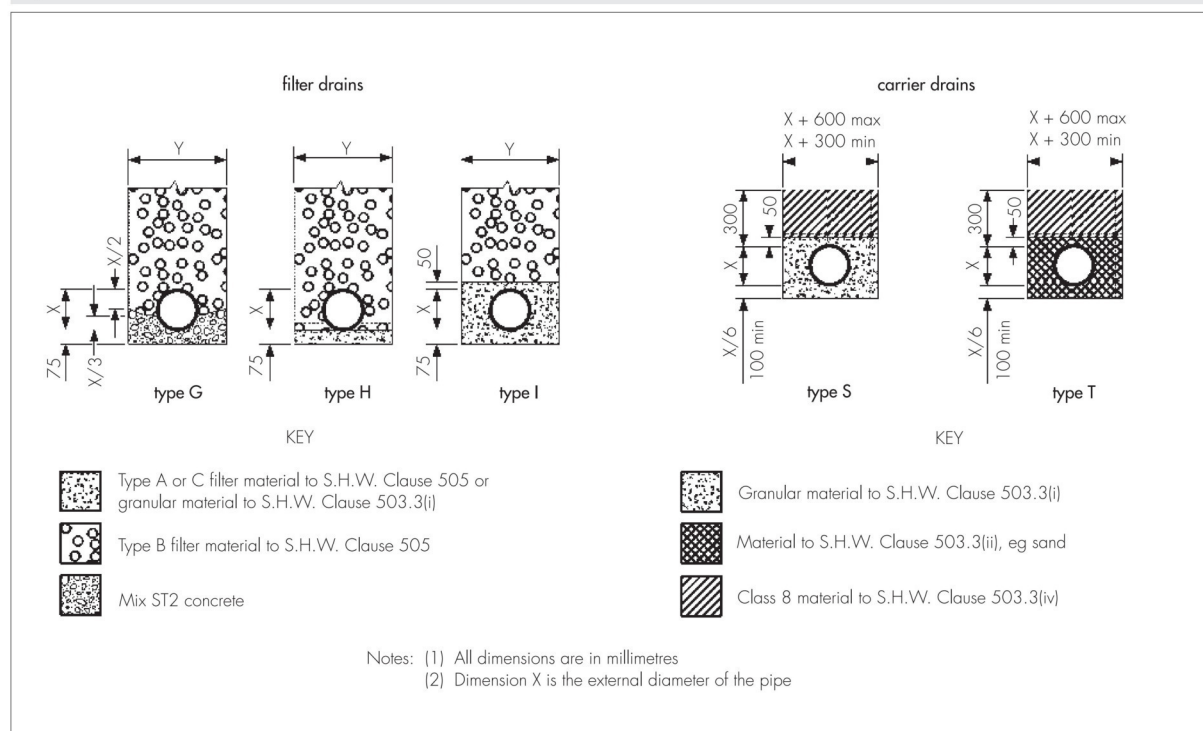
11.1 JFC CorriPipe Twinwall 150 mm, 225 mm, 300 mm, 375 mm, 450 mm and 600 mm Diameter High-Density Polyethylene Filter and Carrier Pipes and Couplings must be installed in accordance with HA requirements and the MCHW, Volume 1, Clauses 503, 505, 518.7 and 518.8.

11.2 The pipes and couplings must be protected against damage from site construction traffic.

12 Procedures

12.1 For typical laying, trench and backfilling specification details, reference should be made to Figure 5 and the MCHW, Volume 3, Drawings No F1 (Type T and S) and No F2 (Type G, H and I).

Figure 5 Installation details



12.2 Pipes are cut easily using conventional hand tools, and should be cut square between the corrugations.

12.3 For a watertight joint, the pipe ends and coupling should be cleaned and the rubber seal fitted externally in the first or second dwell. The seal and inside of the coupling should be lubricated and the pipe pushed fully home to the central register either by hand, or using a lever if necessary.

12.4 Care should be taken during backfill to maintain the line and level of the pipeline. If necessary, the pipe should be restrained to prevent uplift.

13 Tests

13.1 Tests were carried out on the pipe in accordance with the MCHW, Volume 1, Clause 518.5 to determine:

- ring stiffness to BS EN ISO 9969 : 1995
- creep ratio to BS EN ISO 9967 : 1995
- longitudinal bending to the MCHW, Volume 1, Clause 518.11
- rodding resistance to the MCHW, Volume 1, Clause 518.12
- impact resistance at 0°C and 23°C to BS EN 1411 : 1996 with a striker of 1.0 kg mass and 25 mm diameter conical head
- water jetting WRc method.

13.2 Tests were carried out on the system to establish:

- leaktightness of joint to BS EN 1277 : 2003, Method 4, Conditions A, B and C
- insertion force (ease of jointing).

13.3 Tests were carried out to establish the dimensional accuracy of the pipe, coupling and ring seal.

14 Investigations

14.1 An examination was made of data in relation to the effect of the production tolerances on the performance of the products.

14.2 An evaluation of existing data was made to assess material properties, chemical resistance and durability.

14.3 Calculations were carried out to determine slot area.

14.4 The manufacturing process was examined, including the methods adopted for quality control, and details were obtained of the quality and composition of the materials used.

Bibliography

BS 5955-6 : 1980 *Plastics pipework (thermoplastics materials) — Code of practice for the installation of unplasticized PVC pipework for gravity drains and sewers*

BS EN 681-1 : 1996 *Elastomeric seals — Material requirements for pipe joint seals used in water and drainage applications — Vulcanized rubber*

BS EN 763 : 1995 *Plastics piping and ducting systems — Injection-moulded thermoplastics fittings — Test method for visually assessing effects of heating*

BS EN 1277 : 2003 *Plastics piping systems — Thermoplastics piping systems for buried non-pressure applications — Test methods for leaktightness of elastomeric sealing ring type joints*

BS EN 1411 : 1996 *Plastics piping and ducting systems — Thermoplastics pipes — Determination of resistance to external blows by the staircase method*

BS EN ISO 9967 : 1995 *Thermoplastics pipes — Determination of creep ratio*

BS EN ISO 9969 : 1995 *Thermoplastics pipes — Determination of ring stiffness*

EN 638 : 1994 *Plastics piping and ducting systems — Thermoplastics pipes — Determination of tensile properties*

EN 728 : 1997 *Plastics piping and ducting systems — Polyolefin pipes and fittings — Determination of oxidation induction time*

ISO 527-2 : 1993 *Plastics — Determination of tensile properties — Test conditions for moulding and extrusion plastics*

ISO 1133 : 1997 *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics*

ISO 1183-3 : 1999 *Plastics — Methods for determining the density of non-cellular plastics — Gas pycnometer method*

ISO 4440-1 : 1994 *Thermoplastics pipes and fittings — Determination of melt mass-flow rate — Test method*

ISO 4451 : 1980 *Polyethylene (PE) pipes and fittings — Determination of reference density of uncoloured and black polyethylenes*

ISO 12091 : 1995 *Structural wall thermoplastics pipes — Oven test*

Manual of Contract Documents for Highway Works, Volume 1 Specification for Highway Works, August 1998 (as amended)

Manual of Contract Documents for Highway Works, Volume 2 Notes for Guidance on the Specification for Highway Works, August 1998 (as amended)

Manual of Contract Documents for Highway Works, Volume 3 Highway Construction Details, March 1998 (as amended)

Conditions of Certification

15 Conditions

15.1 This Certificate:

- relates only to the product/system that is named and described on the front page
- is issued only to the company, firm, organisation or person named on the front page — no other company, firm, organisation or person may hold or claim that this Certificate has been issued to them
- is valid only within the UK
- has to be read, considered and used as a whole document — it may be misleading and will be incomplete to be selective
- is copyright of the BBA
- is subject to English Law.

15.2 Publications, documents, specifications, legislation, regulations, standards and the like referenced in this Certificate are those that were current and/or deemed relevant by the BBA at the date of issue or reissue of this Certificate.

15.3 This Certificate will remain valid for an unlimited period provided that the product/system and its manufacture and/or fabrication, including all related and relevant parts and processes thereof:

- are maintained at or above the levels which have been assessed and found to be satisfactory by the BBA
- continue to be checked as and when deemed appropriate by the BBA under arrangements that it will determine
- are reviewed by the BBA as and when it considers appropriate
- remain in accordance with the requirements of Highway Authorities' Product Approval Scheme.

15.4 The BBA has used due skill, care and diligence in preparing this Certificate, but no warranty is provided.

15.5 In issuing this Certificate, the BBA is not responsible and is excluded from any liability to any company, firm, organisation or person, for any matters arising directly or indirectly from:

- the presence or absence of any patent, intellectual property or similar rights subsisting in the product/system or any other product/system
- the right of the Certificate holder to manufacture, supply, install, maintain or market the product/system
- individual installations of the product/system, including their nature, design, methods, performance, workmanship and maintenance
- any works and constructions in which the product/system is installed, including their nature, design, methods, performance, workmanship and maintenance
- any loss or damage, including personal injury, howsoever caused by the product/system, including its manufacture, supply, installation, use, maintenance and removal.

15.6 Any information relating to the manufacture, supply, installation, use, maintenance and removal of this product/system which is contained or referred to in this Certificate is the minimum required to be met when the product/system is manufactured, supplied, installed, used, maintained and removed. It does not purport in any way to restate the requirements of the Health and Safety at Work etc. Act 1974, or of any other statutory, common law or other duty which may exist at the date of issue or reissue of this Certificate; nor is conformity with such information to be taken as satisfying the requirements of the 1974 Act or of any statutory, common law or other duty of care.



CorriPipe™

Technical Specification



www.jfc.ie

CorriPipe™ Technical Specification

1. Introduction

CorriPipe™ is a twin wall high density polyethylene pipe manufactured from a blended black polyethylene by a twin extrusion process.

Two high density polyethylene walls are extruded simultaneously, one inside the other, and heat-welded together in one continuous process. The outer wall is corrugated and the inner wall is smooth finished.

It is a combination of the corrugations, and the heat-welding of the two walls, that give CorriPipe™ its excellent structural strength while its smooth inner wall ensures increased flow capacity.

Its applications include surface and storm water drainage in civil engineering, construction, sports amenity, agricultural and other sub-soil applications.

CorriPipe™ is fully BBA (British Board of Agrément) approved and HAPAS (Highways Agency Product Approval Scheme) certified.



Figure 1. – CorriPipe™

2. Dimensions

CorriPipe™ comes in a complete range between 100mm and 600mm and is available in either carrier or filter pipe. CorriPipe™ also has a complete range of fittings and junctions as detailed below.

Nominal Size (mm)	Inside Diameter (mm)	Outside Diameter (mm)	Pipe Length (m)
94	94	110	6
150	149	176	6
225	221	265	6
300	295	354	6
375	370	426	6
450	445	512	6
600	590	680	6

Table 1. – CorriPipe™ Dimensions

Nominal Size (mm)	No. of slots per alternate dwell	Nom. Slot Width (mm)	Perforated Area (mm²/m)
94	4	1.5	7920
150	4	2	6120
225	4	2	4680
300	4	2	5120
375	3	3	4263
450	3	3	4024
600	3	3	4942

Table 2. – Perforated Pipe Detail

Note: CorriPipe also available in various perforation specification. e.g. half perforated, double perforated.

Nominal Size (mm)	Code	Fitting Type
150	150TB30	30° Bend
150	150TB45	45° Bend
150	150TB90	90° Bend
150	150TT90	Equal Tee
150	150TY45	Equal Wye
150	150SWSTT90	Single Wall Tee
225	225TB30	30° Bend
225	225TB45	45° Bend
225	225TB90	90° Bend
225	225TT90	Equal Tee
225	225TY45	Equal Wye
225	225/150TT90	Unequal Tee 150
225	225/150TY45	Unequal Wye 150
225	225SWSTT90	Single Wall Tee
300	300TB30	30° Bend
300	300TB45	45° Bend
300	300TB90	90° Bend
300	300TT90	Equal Tee
300	300TY45	Equal Wye
300	300/150TT90	Unequal Tee 150
300	300/150TY45	Unequal Wye 150
300	300/225TT90	Unequal Tee 225
300	300/225TY45	Unequal Wye 225
300	300SWSTT90	Single Wall Tee

Table 3. – CorriPipe™ Fittings

Note: Larger fitting sizes fabricated on request

CorriPipe™ Technical Specification

3. Hydraulic Capacity

There are two main formulas used in hydraulic calculations of gravity flow pipelines – Manning's and Colebrook-White:

Manning's

Manning's is the most popular equation for stormwater design because it is simple to apply and it generally provides an acceptable level of accuracy.

$$Q = \frac{1}{n} AR^{\frac{2}{3}} S^{\frac{1}{2}}$$

Q = Water Discharge [m³/s]

n = Manning's roughness factor [s/m¹/³]

A = Cross-sectional area [m²]

R = Hydraulic radius [m]

S = Surface Water Slope [m/m]

Colebrook-White

A more accurate method for calculations involving FRC™ pipes is to utilize the Colebrook-White formula. The Colebrook-White design chart for FRC™ should allow quick and easy estimates without involved calculations.

$$V = -2\sqrt{2gDS} \log\left(\frac{k}{3.7D} + \frac{2.51v}{d\sqrt{2gDS}}\right)$$

V = Velocity (m/s)

S = Hydraulic gradient (m/m)

k = Hydraulic roughness (m)

R = Hydraulic radius = D/4 (m)

D = Pipe internal diameter (m)

g = Gravitational acceleration (m/s²)

v = Kinematic viscosity of water (m²/s)

4. Cover Depths

Minimum Cover Depths

JFC Manufacturing Limited recommends the following minimum cover depths.

- 0.6m for non trafficked green areas
- 0.9m to finished surface for trafficked areas not subject to Highways Agency or National Roads Authority requirements
- 1.2m to finished surface for trafficked areas subject to Highways Agency or National Roads Authority requirements.

In certain circumstances lower minimum cover levels may be allowed. e.g. installation with rigid pavement, concrete surround etc. Please contact JFC for more information.

Maximum Cover Depths

The maximum cover depth for CorriPipe™ is normally between 6-10 meters when installed in accordance with series 500 of the MCDHW Volume 1 as detailed in the CorriPipe™ BBA certificate.

The actual maximum allowable cover level is dependent on the following installation parameters and is often well in excess of 6-10 meters:

- The native soil stiffness
- The pipe bed and surround stiffness
- The size of the trench
- The density of the overburden
- Hydrostatic loading
- Factor of Safety
- Maximum allowable deflection limit

For specific site conditions JFC can calculate the maximum pipe deflection based on the above parameters. Contact JFC for more details.

CorriPipe™ Technical Specification

4. Installation

JFC CorriPipe is to be installed in accordance with the following national guidelines. In countries outside that specified contact JFC for more details.

Ireland

The Manual of Contract Documents for Road Works, Volume 1 series 500, clauses 503 and 505 as published by the NRA.

United Kingdom

The Manual of Contract Documents for Highway Works, Volume 1 series 500, clauses 503, 505, 518.7 and 518.8 as published by the Highways Agency

Trench Preparation

The trench width is generally between OD+300mm and OD+600mm but larger trenches are permissible. The trench should provide for a minimum of 150mm pipe bed and local soft spots must be removed and replaced with hardcore. The pipe must sit evenly on the bed and must be free of voids under the pipe. The trench should not be excavated too far in advance of pipe installation. All trenches are to be excavated in accordance with national health and safety regulations and local building regulations.

Sidefill

CorriPipe™ is to be backfilled as described in the MCDHW, Volume 1, Series 500. Sidefill material is dependent on specification but is normally a well graded granular material or small single size aggregate. The pipe surround material must fully support the pipe. Compaction may be required depending on ground conditions and sidefill material used. If compaction is required the compaction equipment must not come in contact with the pipe. The sidefill material should extend to 100mm over the crown of the pipe.

Backfill

Backfill is to continue to a minimum of 300mm above the crown of the pipe with suitable material as per specification. The material should be free of any stone particles greater than 50mm. Compaction should not be carried out until a minimum cover of 300mm is achieved. Compaction equipment should be sized so as not to exert any undue stress in the pipe. Further backfill to the required level should be carried out in layer no greater than 300mm.

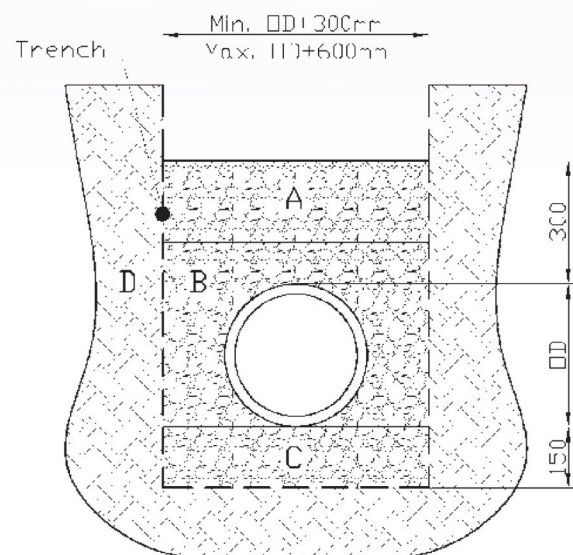


Figure 2. – Typical Installation Details

A = Backfill

B = Sidefill

C = Bed

D = Earth

OD = Outside Diameter of Pipe

CorriPipe™ Technical Specification

5. Jointing

CorriPipe™ is manufactured in 6 meter lengths and is joined with straight couplers or suitable fittings (e.g. tees, wyes, bends etc.)

CorriPipe™ provides a fully watertight seal when installed in accordance with JFC recommendations.

Leak tightness is in accordance with BS EN 1277:1997. The maximum permitted angular deflection is 2°.

Rubber seals used in watertight applications are in accordance with BS EN 681-1:1996

JFC recommends the following procedure for joining CorriPipe™ and associated fittings / couplers.

- Cut the pipe to the require length with a conventional handsaw.
- Clean the end of the pipe and accompanying coupler / fitting.
- Install a ring seal in the first dwell of the pipe for watertight joints.
- Ring seals are bi directional
- Lubricate the ring seal and accompanying coupler / fitting.
- Offer the fitting / coupler up to the pipe
- Lever the fitting / coupler onto the pipe with a piece of timber ensuring not to damage the pipe. Larger pipes may require mechanical assistance.
- Ensure the fitting / coupler is butted fully against the pipe.
- For joining pipes to the opposite side of the fitting / coupler follow the same steps as outlined above.

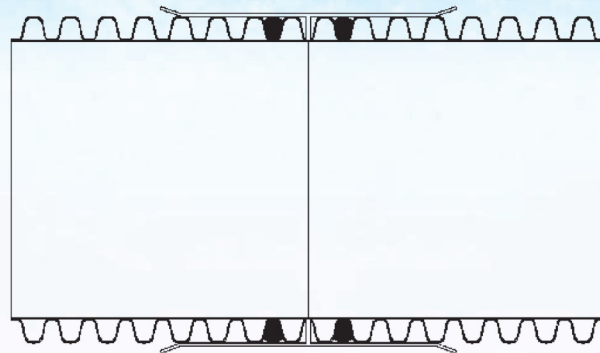


Figure 3. – Typical Joint Details

6. Pressure Testing

There are two methods of pressure testing, the air test method and the water test method. The most common method is the air test method and the test procedure is outlined below.

- Block the ends of the pipe / fitting with a suitable expanding stopper, ensuring both plug and pipe are cleaned prior to fitting.
- Fill a U-Tube manometer with water to the correct level, ensuring there are no trapped air bubbles in the water.
- Connect the u-tube to the fitting on the expandable stopper.
- Increase the pressure in the pipe until a head of water of 100mm is reached.
- Allow the pressure to stabilise for a number of minutes, increasing the pressure if it drops.
- Record the pressure drop over a five minute period.
- To pass the test the pressure should not drop below a 75mm head of water.

Note: Temperature has a critical effect on the test, a 1°C change in air temperature inside the pipe is sufficient for the test to fail.

CorriPipe™ Technical Specification

6. Transportation, Handling and Storage

General

Handling should be done carefully and in accordance with national health and safety guidelines. Dragging of pipes and fittings must be avoided. HDPE pipes and fittings become slippery in wet or in cold weather and extra precautions may be necessary.

Pipes up to 450mm in size are palletised with wooden frames and steel straps. 600mm pipes are generally steel banded in two's but can also be supplied loose.

Nominal Size (mm)	Number of Pipes per Pallet
100	100
150	33
225	14
300	8
375	5
450	4
600	2 / steel banded

Table 4. – CorriPipe™ Pallet Quantities

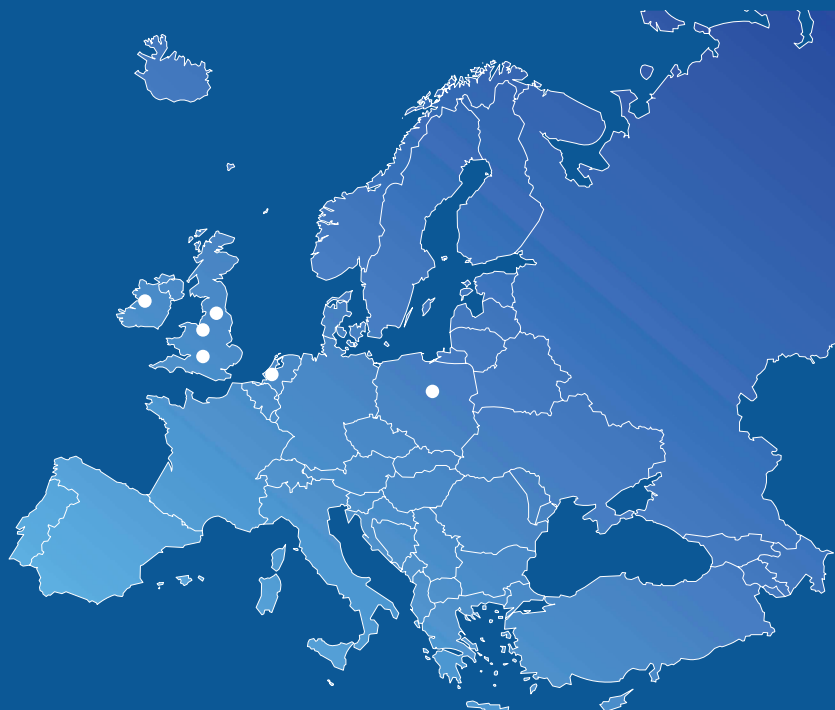
Storage

All materials should be carefully inspected at the time of delivery and any defects should be notified and reported immediately. All pipe stacks should be made on firm, flat ground to support the weight of the pipes and lifting equipment. For safety and Pipes and fittings should be transported and stored in their packaging.

Delivery vehicles should be provided with a clean, flat bed, free from sharp objects. Care must be taken to prevent slippage or excessive bowing of the pipes. Tie the load well to prevent rubbing. Use nylon straps, not chains or ropes.

The stacking height for pipes should be limited to not more than 3 meters. Pipes should be not be stored in open areas subject to high winds.

It is recommended that CorriPipe™ is not stored in direct sunlight for more than 3 months.



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