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TECHNICAL SPECIFICATION

4" Royal Seal™ Gasketed Sewer Pipe SDR 35 Custom Perforation Pattern

Cell classification 12364

SCOPE

This specification covers the requirements for 4" PVC (polyvinyl chloride) gravity sewer pipe with integral locked-in gasket bell and spigot joints and custom perforation pattern. This pipe is manufactured to meet the requirements of the American Society for Testing and Materials (ASTM) standard D3034 and certified to Canadian Standards Association (CSA) Standard B182.2.

MATERIALS

The pipe is manufactured from PVC compound meeting the cell classification requirements of 12364 as defined by the American Society of Testing and Materials (ASTM) Standard D1784: *Standard Specification for Rigid PVC Compounds and CPVC Compounds*.

MARKING

Pipe markings are as specified in CSA B182.2 and ASTM D3034.

PIPE

The pipe is manufactured for use in gravity flow sanitary and storm sewer. The pipe is produced with a wall thickness corresponding to the dimension ratio of SDR 35, with a pipe stiffness value of minimum 46 psi (320 kPa) when tested in accordance with ASTM D3034 and D2412, *Standard Test Method for Determination of External Loading*. Standard length of pipe is 13 ft plus the bell length.

GASKETS

The pipe utilizes a double seal locked-in gasket system (DSLII) design which meets the requirements of ASTM D3212, *Standard Specifications for Joints for Drain and Sewer Plastic Pipes Using Flexible Elastomeric Seals*. The gaskets are reinforced with a steel band and conform to the requirements of ASTM F477: *Standard Specification for Elastomeric Seals (Gaskets) for Joining Plastic Pipe*.

TEST REQUIREMENTS

Quality testing is as per Royal's Quality Control program and in accordance with CSA B182.2 and ASTM D3034.

PIPE DIMENSIONS

Nominal Size in (mm)	Outside Diameter (OD) in (mm)	Wall Thickness (t) in (mm)	Minimum Bell Depth (BD) in
4 (100)	4.206 – 4.222 (106.8 – 107.2)	0.120 – 0.132 (3.0 – 3.3)	4"

CUSTOM PERFORATIONS

The custom perforation pattern consists of 3 rows of 3/8" diameter holes, 120 degrees apart, on 12" centres as per Royal SO # 237275.

