

# S4.01 Injection Molded Fitting Specification

## Scope

This specification describes 4- through 12-inch (100 to 300 mm) Injection Molded Fittings for use in joining gravity-flow drainage and sewer pipe. Available fittings include tees, wyes, bends, couplers, and reducing fittings.

## Fitting Requirements

Injection molded fittings shall have a smooth interior and exterior.

- 4- through 10-inch (100 to 250mm) shall meet the fitting requirements of AASHTO M252.
- 12- inch (900 mm) pipe shall meet AASHTO M294 or ASTM F2306.

## Joint Performance

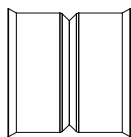
The fittings shall provide a joint meeting AASHTO M252, AASHTO M294 or ASTM F2306. For non-gasketed fittings, dimples in the bell shall engage the corrugation to provide a soil-tight connection. For gasketed fittings, the joint shall be watertight according to the requirements of ASTM D3212. Gaskets shall be made of EPDM meeting the requirements of ASTM F477. Gaskets shall be supplied by the pipe manufacturer. A joint lubricant supplied by the manufacturer shall be used on the gasket and bell during assembly.

## Material Properties

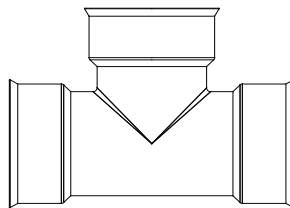
Material for fitting production shall be high density polyethylene conforming with the minimum requirements of cell classification 314420C or 314420E for 4- through 12-inch (100 to 300mm) diameters, as defined and described in the latest version of ASTM D3350, except that carbon black content should not exceed 4%.

## Build America, Buy America (BABA)

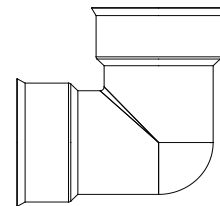
Injection Molded Fittings, manufactured in accordance with AASHTO M252, AASHTO M294 or ASTM F2306, complies with the requirements in the Build America, Buy America (BABA) Act.



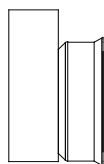
SIZE-ON-SIZE OR REDUCING  
BELL-BELL COUPLER



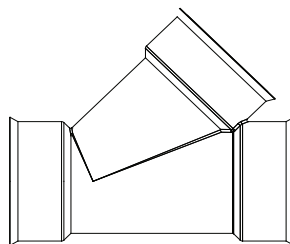
SIZE-ON-SIZE OR REDUCING TEE



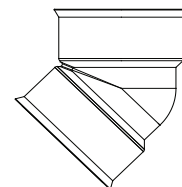
90-DEG BEND



SPIGOT-BELL REDUCER



SIZE-ON-SIZE OR REDUCING  
45-DEG WYE



45-DEG BEND

Refer to the Water Management Product Catalog for a complete list of available fittings. Availability may vary for each fitting type based on diameter or joint performance.

## Injection Molded Fittings Joint System

(Joint configuration and availability subject to change without notice. Product detail may differ slightly from actual product appearance.)

