

**STATE OF OHIO
DEPARTMENT OF TRANSPORTATION
SUPPLEMENTAL SPECIFICATION 937
POLYETHYLENE LINER PIPE**

April 20, 2007

937.01 Type A Polyethylene Liner Pipe

937.02 Type B Polyethylene Liner Pipe

937.01 Type A Polyethylene Liner Pipe. This specification covers Type A polyethylene liner pipe with interlocking or butt-fused non-protruding joints. The outside diameters range from 10 to 63 inches (250 mm to 1600 mm). Furnish pipe and fittings that conform to ASTM F 714 with the following additions:

4.2 Compound. Ensure the resin compound for the pipe and fittings meets the requirements of ASTM D 3350 with a cell classification of PE345464C and a Plastic Pipe Institute designation of PE 3408. Compounds that have higher cell classifications in one or more properties are acceptable if the specified property value is exceeded.

8.1 Furnish the manufacturer's certified test results in accordance to CMS 101.03.

X2.1 Ensure the liner pipe has a maximum standard dimension ratio (SDR) of 32.5.

Furnish butt-fusion joints per the pipe manufacturer's recommendations.

Ensure the method of attaching the joint to the polyethylene liner pipe is in accordance with the manufacturer's recommendations.

937.02 Type B Polyethylene Liner Pipe. This specification covers Type B polyethylene liner pipe with heat fusion or plain end extrusion weld joints. The inside diameters range from 18 to 132 inches (460 to 3350 mm). Furnish pipe and fittings that conform to ASTM F 894 with the following additions and deletions.

Table 2 Closed Profile Pipe Dimensions and Tolerances				
Nominal Pipe Size, in. (mm)	Average Inside Diameter, in. (mm)	Tolerance on Average Inside Diameter, in. (mm)	Min Wall Thickness in Pipe Waterway, W, All RSC, in. (mm)	Min Bell Thickness, Tb, in. (mm)
132 (3350)	132 (3350)	+/- 1.32 inches (33.5)	0.18 (4.5)	0.8 (20.3)

4.3 Provide only heat fusion and plain end extrusion weld joints.

7.2 Ensure the liner pipe has a minimum ring stiffness constant (rsc) of 100.

10.1 Furnish the manufacturer's certified test results in accordance to CMS 101.03

Designer Note: This specification should be used in conjunction with SS 837