
**Plastics piping systems for renovation
of underground non-pressure
drainage and sewerage networks —**

**Part 2:
Lining with continuous pipes**

*Systèmes de canalisations en plastique pour la rénovation des réseaux
de branchements et de collecteurs d'assainissement enterrés sans
pression —*

Partie 2: Tubage par tuyau continu avec espace annulaire



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Contents

	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Symbols and abbreviated terms	2
4.1 Symbols	2
4.2 Abbreviated terms	2
5 Pipes at the “M” stage	2
5.1 Material	2
5.2 General characteristics	2
5.3 Material characteristics	3
5.4 Geometrical characteristics	3
5.5 Mechanical characteristics	3
5.6 Physical characteristics	3
5.7 Jointing	3
5.8 Marking	3
5.9 Regional requirements for pipes	3
6 Fittings at the “M” stage	3
6.1 Requirements	3
6.2 Marking	3
6.3 Regional requirements for fittings	3
7 Ancillary components	3
8 Fitness for purpose of the system for pipes and fittings at the “I” stage	4
9 Installation practice	4
9.1 Preparatory work	4
9.2 Storage, handling and transport	4
9.3 Equipment	4
9.3.1 Butt fusion equipment and de-beading equipment	4
9.3.2 Pipe rollers	5
9.3.3 Winching and rod-pulling equipment	5
9.3.4 Pipe entry guides	5
9.3.5 Electrofusion equipment	5
9.3.6 Inspection equipment	5
9.3.7 Lifting equipment	5
9.4 Installation	5
9.5 Process-related inspection and testing	6
9.6 Lining termination	6
9.7 Reconnection to the existing pipeline system	6
9.8 Final inspection and testing	6
9.9 Documentation	6
Annex A (normative) Layered pipes	7
Bibliography	8

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 8, *Rehabilitation of pipeline systems*.

A list of all parts in the ISO 11296 series can be found on the ISO website.

Introduction

This document is part of a system standard for plastics piping systems of various materials used for renovation of existing pipelines in a specified application area. System standards for renovation dealing with the following applications are either available or in preparation:

- ISO 11296, *Plastics piping systems for renovation of underground non-pressure drainage and sewerage networks (this application)*;
- ISO 11297, *Plastics piping systems for renovation of underground drainage and sewerage networks under pressure*;
- ISO 11298, *Plastics piping systems for renovation of underground water supply networks*;
- ISO 11299, *Plastics piping systems for renovation of underground gas supply networks*.

These system standards are distinguished from system standards for conventionally installed plastics piping systems by the requirement to verify certain characteristics in the “as installed” condition, after site processing. This is in addition to verification of characteristics of plastics piping systems “as manufactured”.

Each of the system standards comprises a:

- *Part 1: General*

and all applicable renovation technique family-related parts, which for non-pressure drainage and sewerage networks include or potentially include the following:

- *Part 2: Lining with continuous pipes (this document)*
- *Part 3: Lining with close-fit pipes*
- *Part 4: Lining with cured-in-place pipes*
- *Part 5: Lining with discrete pipes*
- *Part 7: Lining with spirally-wound pipes*
- *Part 8: Lining with pipe segments*
- *Part 9: Lining with rigidly anchored plastics inner layer*
- *Part 10: Lining with sprayed polymeric materials*

The requirements for any given renovation technique family are specified in ISO 11296-1, applied in conjunction with the relevant other part. For example, both ISO 11296-1 and this document together specify the requirements relating to lining with continuous pipes. For complementary information, see ISO 11295. Not all technique families are pertinent to every area of application and this is reflected in the part numbers included in each System Standard.

A consistent structure of clause headings has been adopted for all parts to facilitate direct comparisons across renovation technique families.

[Figure 1](#) shows the common part and clause structure and the relationship between ISO 11296 and system standards for other applications.

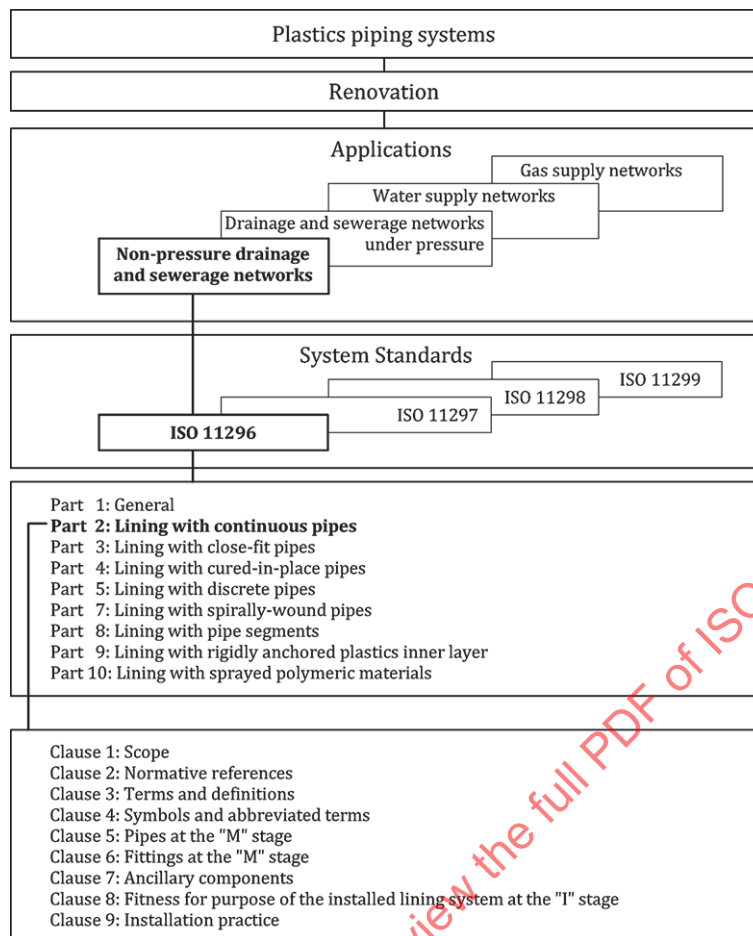


Figure 1 — Format of the renovation system standards

Plastics piping systems for renovation of underground non-pressure drainage and sewerage networks —

Part 2: Lining with continuous pipes

1 Scope

This document, in conjunction with ISO 11296-1, specifies requirements and test methods for pipes and fittings which are part of plastics piping systems installed as continuous pipes in the renovation of underground non-pressure drainage and sewerage networks. It is applicable to polyethylene (PE) pipes of three different types:

- PE solid wall single layered pipes (nominal outside diameter, d_n), including any identification stripes;
- PE pipes with co-extruded layers on either or both the outside and inside of the pipe (total outside diameter, d_n), as specified in [Annex A](#), where all layers have the same MRS rating;
- PE coated pipes (outside diameter, d_n) having a peelable, contiguous, thermoplastics additional layer on the outside of the pipe ("coated pipe"), see [Annex A](#).

In addition it covers:

- jointing of pipe lengths by means of butt fusion;
- fabricated and injection-moulded fittings made of PE.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 8772, *Plastics piping systems for non-pressure underground drainage and sewerage — Polyethylene (PE)*

ISO 11296-1:2018, *Plastics piping systems for renovation of underground non-pressure drainage and sewerage networks — Part 1: General*

ISO 12176-1, *Plastics pipes and fittings — Equipment for fusion jointing polyethylene systems — Part 1: Butt fusion*

ISO 12176-2, *Plastics pipes and fittings — Equipment for fusion jointing polyethylene systems — Part 2: Electrofusion*

EN 12666-1, *Plastics piping systems for non-pressure underground drainage and sewerage — Polyethylene (PE) — Part 1: Specifications for pipes, fittings and the system*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 11296-1 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>

— ISO Online browsing platform: available at <http://www.iso.org/obp>

3.1 compound formulation
clearly defined homogenous mixture of base polymer with additives e.g. anti-oxidants, pigments, stabilisers and others, at a dosage level necessary for the processing and intended use of the final product

3.2 coated pipe
pipe with a peelable, contiguous thermoplastic additional layer on the outside of the pipe

3.3 solid wall single layered pipe
pipe with smooth internal and external surface, extruded from the same compound/formulation throughout the wall

3.4 pipe with co-extruded layers
pipe with smooth internal and external surface, having co-extruded layers on either or both the outside and inside of the pipe, where all layers have the same MRS rating

3.5 out-of-roundness
difference between the measured maximum and the measured minimum outside diameter in the same cross-sectional plane of the pipe

4 Symbols and abbreviated terms

4.1 Symbols

d_n nominal outside diameter

e_{coating} nominal thickness of the coating

4.2 Abbreviated terms

MFR melt mass-flow rate

CCTV closed-circuit television

MRS minimum required strength

OIT oxidation induction time

PE polyethylene

5 Pipes at the “M” stage

5.1 Material

Pipes shall be of PE conforming to the requirements of ISO 8772.

5.2 General characteristics

General characteristics of pipes shall conform to the requirements of ISO 8772.

5.3 Material characteristics

Material characteristics shall conform to the requirements of ISO 8772.

5.4 Geometrical characteristics

Geometrical characteristics of pipes shall conform to the requirements of ISO 8772. In addition, any combination of nominal diameter and wall thickness shall be permitted, provided this is validated by design calculations that take account of both installation and operational loadings on the pipe for a specific application.

5.5 Mechanical characteristics

The mechanical characteristics of pipes shall conform to the requirements of ISO 8772.

5.6 Physical characteristics

The physical characteristics of pipes shall conform to the requirements of ISO 8772.

5.7 Jointing

When pipes are assembled to each other or to components the joints shall conform to ISO 8772. All butt fusions shall be externally de-beaded and, if required by the client, internally de-beaded.

5.8 Marking

All pipes shall be marked either in accordance with ISO 11296-1 or ISO 8772. Where the pipe is coated (see [A.3](#)) the coating shall be marked to clearly distinguishing the pipe from non-coated pipe in service (e.g. by broad colour bands).

5.9 Regional requirements for pipes

In countries of the Single European Market, ISO 8772 specified as normative reference in [5.1](#) to [5.8](#) is replaced by EN 12666-1.

6 Fittings at the “M” stage

6.1 Requirements

Fittings shall fulfil the requirements in ISO 8772.

NOTE Wide tolerance fittings can be required for compatibility with pipe dimensions as specified in [5.4](#).

6.2 Marking

Each fitting shall be marked either in accordance with ISO 11296-1 or ISO 8772.

6.3 Regional requirements for fittings

In countries of the Single European Market, ISO 8772 specified as normative reference in [6.1](#) to [6.2](#) is replaced by EN 12666-1.

7 Ancillary components

This document does not cover any ancillary components.

8 Fitness for purpose of the system for pipes and fittings at the “I” stage

Pipes and fittings shall conform to the requirements of ISO 11296-1.

Out-of-roundness of the lining system after installation (including any caused by grouting of the annular space) shall not exceed any maximum value agreed between the client and installer.

9 Installation practice

9.1 Preparatory work

The preparatory work shall conform to ISO 11296-1.

NOTE Depending on the condition of the existing pipeline, cleaning can be necessary to remove encrustation.

9.2 Storage, handling and transport

Precautions shall be taken to ensure that no excessive damage is caused to the lining pipe during unloading, site handling and storage. In this context, excessive damage shall mean any scratch which is more than 10 % of the wall thickness in depth or the imposition of any severe bending operation, which results in a permanent kink, crease or fold.

When assessing damage to the pipe wall caused by scratches, the installer should be aware that further scratch damage can occur during installation.

The lining pipe shall be stored on reasonably level ground, free of large sharp stones, debris or litter, to avoid potentially damaging point-loading.

In general, and in the absence of any specific handling requirements, these precautions shall include the use of webbing slings in place of wire rope or chains, and the use of spreader beams for pipe lengths in excess of 12 m. Where the system designer specifies handling requirements, these shall prevail.

The lining pipe shall be transported on a flat-bed vehicle, free of nails or other projections or on a purpose-built trailer designed to carry the lining pipe as a free-standing coil or wound on to a drum. Before being loaded, the lining pipe shall be visually checked for any damage.

Pipe ends shall be securely sealed to prevent contamination of the pipe by moisture and/or dirt under storage, handling and transport.

For pipes of 600 mm diameter or larger, a suitable plug or other closure, which also prevents ovalization or other deformation, is recommended.

9.3 Equipment

9.3.1 Butt fusion equipment and de-beading equipment

Butt fusion equipment shall be capable of producing joints between PE pipes or PE pipes and fittings under site conditions and shall comply with ISO 12176-1.

In addition to the heater plate, the equipment shall include such clamping, re-rounding and trimming systems as ensure alignment and matching of the pipe ends, and an external de-beader capable of removing the bead cleanly in one continuous strip without damage to the pipe surface. If an internal de-beader is used, this shall not cause damage to the internal pipe surface.

A shelter shall be provided to avoid fusion joint contamination from water and dust and to generally maintain a clean and warm working environment. The ends of the lining pipe string shall be plugged to prevent cold air blowing through, which could otherwise adversely affect the fusion joint.

9.3.2 Pipe rollers

Pipe rollers shall be used for all pipe handling operations except by means of a crane. The rollers shall minimize frictional loads and prevent damage to the pipe as it is moved during the butt-fusion and installation processes.

9.3.3 Winching and rod-pulling equipment

Winching equipment usually consists of a powered winch connected to the lining pipe by a winch cable and appropriate nose cone connection.

Rod pulling equipment usually consists of a hydraulic ram driven carriage, connected to the lining pipe by a string of rods which screw or hook together, and an appropriate nose cone connection.

All pulling equipment shall have a means of displaying in real time, and recording graphically or numerically, the force applied to the pipe during installation. In the case of a winch, this shall be by directly measuring the load on the winch wire. In the case of a rod puller, this shall be by directly measuring either the load applied to the rods, or the load applied to the nose cone.

WARNING — All pulling operations are potentially dangerous and any exposed winch cable or puller rods should be guarded.

Attention is drawn to any national health and safety regulations applicable to pulling equipment and operations.

9.3.4 Pipe entry guides

Pipe entry guides shall be designed to prevent damage to the lining pipe during insertion.

9.3.5 Electrofusion equipment

Electrofusion equipment shall conform to ISO 12176-2. The power supply/controller and associated alignment and fixing clamps shall be such as to ensure fusion when following the manufacturer's guidelines for surface preparation and fusion.

9.3.6 Inspection equipment

Closed-circuit television (CCTV) shall provide a full colour picture and recording/replay facilities complete with slow motion and frame by frame replay and shall provide a clear picture of all parts of the installed pipe. The recording shall be labelled on screen with full location, metreage, liner type, nominal size and date information.

Laser profiling equipment shall additionally report mean internal diameter and pipe ovality, with graphical images of pipe cross section, at metreage intervals of one diameter or less.

All equipment to be introduced into the installed pipe, including proving pigs, shall be constructed and maintained so as to prevent any damage or contamination to the installed pipe.

9.3.7 Lifting equipment

All lifting equipment shall be covered by current test certification and shall be operated only by trained personnel.

Attention is drawn to any legislation applicable to lifting equipment.

9.4 Installation

Installation shall follow the procedures detailed in the installation manual.

The installation manual shall specify the method of installation, including the use of pipe entry guides, liner termination and reconnection to existing manholes and laterals, inspection and testing, and all necessary parameters according to the requirements of the method described.

The manual shall also include:

- a) maximum allowable pulling force as declared by the pipe manufacturer as a function of temperature;

NOTE The maximum pulling force is usually calculated to limit the maximum stress to not more than 50 % of the tensile yield stress of the material.

- b) minimum allowable longitudinal bending radius during installation, as declared by the pipe manufacturer as a function of SDR and temperature, and the associated minimum length of access pit as a function of excavation depth;
- c) details of the type of fittings to be used.

Where pipes are jointed to form one pipe string on site using butt-fusion, a method statement for internal de-beading, where required, and external de-beading shall be provided and shall specify at least:

- how the bead is removed;
- how the bead and related joint are identified;
- how the bead is to be examined for quality control purposes, and stored for future reference.

Where there is a peelable layer this shall be removed prior to jointing.

9.5 Process-related inspection and testing

Process-related inspection and testing shall conform to ISO 11296-1.

9.6 Lining termination

The ends of the lining pipe shall be anchored and sealed in such a way as to provide a leaktight connection to the existing pipeline. The method of anchoring the liner pipe ends shall take account of the maximum longitudinal force that can be safely transmitted onto the existing network pipes.

9.7 Reconnection to the existing pipeline system

Reconnections to existing manholes and laterals shall conform to ISO 11296-1.

9.8 Final inspection and testing

In addition to verifying leaktightness by hydrostatic pressure testing in accordance with ISO 11296-1:2018, 8.2, internal visual inspection where specified by the client in accordance with ISO 11296-1:2018, 9.8 shall verify that the finished liner is continuous over the length of the installation and exhibits a cross-section complying with the requirements of ISO 11296-1:2018, 8.4 throughout.

Inspection shall be made at the leading end, and where possible, at other places along the installed lengths when the pipe is exposed (e.g. service connections windows), to verify that the external surface of the pipe is not scratched to a depth greater than 10 % of the wall thickness. Where the pipe wall has scratches greater than 10 % of the wall thickness, the affected section shall be cut out and replaced.

9.9 Documentation

Installation parameters shall be documented in accordance with ISO 11296-1:2018, 9.9. The ambient temperature and the maximum recorded pulling force on the pipe shall be documented.