

ASTM/Uni-Bell Deflection Test Specifications

FIELD CERTIFICATION OF HURCO GAUGES

ASTM D-3034 SDR 35 – Deflection test off of base inside diameter (Ultra-Rib pipe – same dimensions)

PIPE SIZE	BASE I.D.	5% TEST	7.5%TEST
4	3.874	3.68	3.58
6	5.742	5.45	5.31
8	7.665	7.28	7.09
10	9.563	9.08	8.84
12	11.361	10.79	10.51
15	13.898	13.20	12.86

ASTM F-679 (T1 WALL) – Deflection test off of base inside diameter

PIPE SIZE	BASE I.D.	5% TEST	7.5%TEST
18	16.976	16.13	15.70
21	20.004	19.01	18.50
24	22.480	21.36	20.80
27	25.327	24.06	23.44

ASTM D-3034 SDR 26 – Deflection test off of base inside diameter

PIPE SIZE	BASE I.D.	5% TEST	7.5%TEST
6	5.612	5.33	5.19
8	7.488	7.12	6.93
10	9.342	8.87	8.64
12	11.102	10.54	10.27
15	13.575	12.90	12.56

ASTM F-794 for Ribbed Pipe – Deflection test off of base inside diameter (taken from UNI-B-9)

PIPE SIZE	BASE I.D.	5% TEST	7.5%TEST
4	3.869	3.68	3.58
6	5.720	5.43	5.29
8	7.637	7.26	7.07
10	9.529	9.05	8.82
12	11.322	10.75	10.47
15	13.849	13.16	12.81
18	17.003	16.15	15.72
21	19.985	18.99	18.49
24	22.613	21.48	20.91
27	25.490	24.22	23.58
30	28.367	26.95	26.24
33	31.249	29.69	28.91
36	34.126	32.42	31.57
39	37.003	35.15	34.22
42	39.880	37.89	36.89
45	42.762	40.62	39.55
48	45.639	43.36	42.22

ASTM F-789 – Deflection test off of base inside diameter (4" T1 Wall – 6" to 15" T2 Wall) (taken from UNI-B-10)

PIPE SIZE	BASE I.D.	5% TEST	7.5%TEST
4	3.91	3.71	3.62
6	5.80	5.51	5.36
8	7.73	7.34	7.15
10	9.64	9.15	8.92
12	11.46	10.88	10.60
15	14.01	13.30	12.96



ASTM F-894 – Deflection test off of base inside diameter

PIPE SIZE	BASE I.D.	5% TEST	7.5%TEST
18	17.42	16.55	16.11
21	20.34	19.32	18.81
24	23.25	22.09	21.51
27	26.15	24.84	24.19
30	29.07	27.62	26.89
33	31.98	30.98	29.58
36	34.89	33.15	32.27
42	40.72	38.68	37.67
48	46.54	44.21	43.05
54	52.35	49.73	48.24
60	58.18	55.27	53.82
66	63.99	60.79	59.19
72	69.81	66.32	64.57
84	81.46	77.38	75.34
96	93.08	88.43	86.10
120	116.05	110.25	107.35

HURCO

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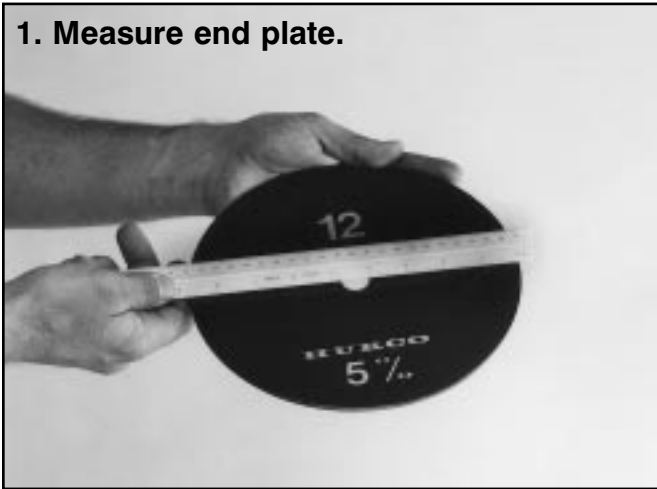
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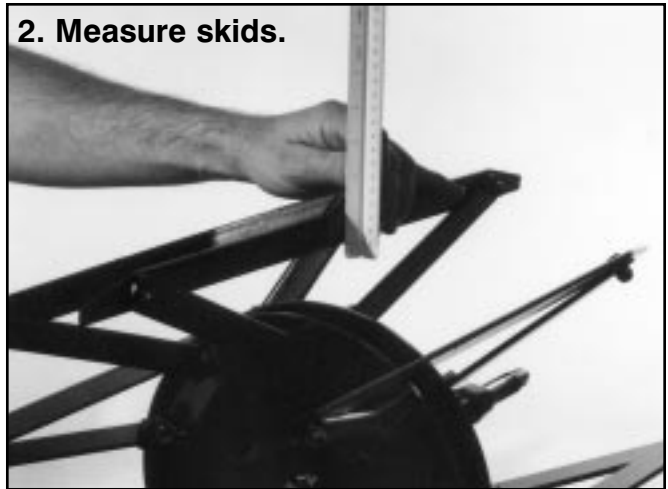
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FIELD CERTIFICATION OF HURCO GAUGES

1. Measure end plate.

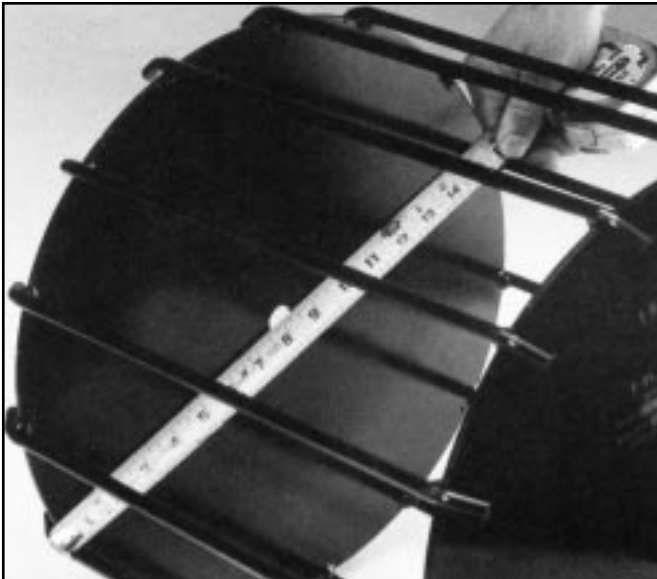


2. Measure skids.



Field Certification of Multi-Size Gauge

$2 \times \text{the skid measurement} + \text{the plate measurement} = \text{outside diameter}$

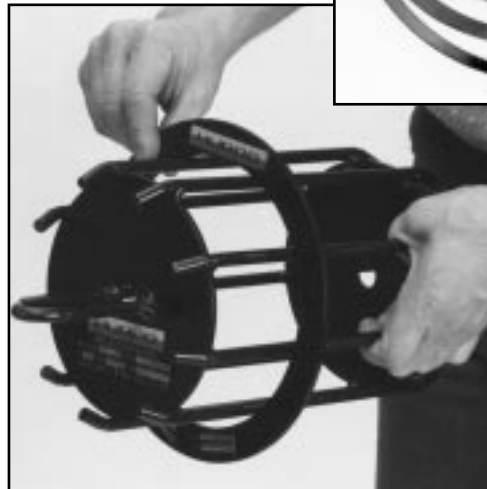
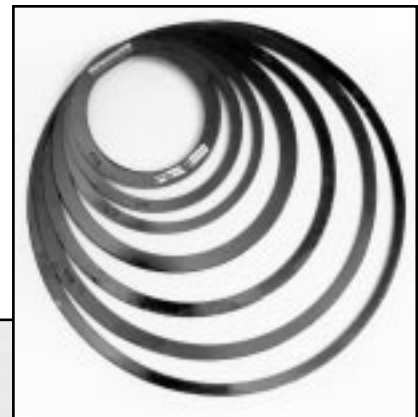


Field Certification of Stationary-Type Gauge

The measurement from outside of skid to edge of center hole, + 3/8" (1/2 the diameter of center hole) X 2 = outside diameter.

Use HURCO Proving Rings for a More Precise Measurement

Although HURCO Gauges can be certified in the field with a + (plus) or - (minus) accuracy of 1/16 of an inch, some engineers and municipalities will require an even more precise form of measure. HURCO has a full line of proving rings from 4" to 27" with a + (plus) or - (minus) accuracy of 0.020. HURCO Proving Rings are the best way to determine the accuracy of deflection test gauges.



Available in single sizes or full sets.