



Designation: C 1277 – 9703

Standard Specification for Shielded Couplings Joining Hubless Cast Iron Soil Pipe and Fittings¹

This standard is issued under the fixed designation C 1277; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers the material and testing of the performance of shielded hubless couplings to join hubless cast iron soil pipe and fittings.

1.2 Several different types of hubless couplings are available for use in hubless cast iron sanitary and storm drain, waste and vent piping applications to connect hubless cast iron soil pipe and fittings by using a sleeve-type, or some other type coupling device. It is the purpose of this specification to furnish information as to the characteristics of one such sleeve type couplings when applied to cast iron soil pipe and fittings manufactured in accordance with Specification A 888, latest revision, and CISPI Designation 301, latest revision.

1.3 The values stated in inch-pound units are to be regarded as the standard. The SI units given in parentheses are for information only.

1.4 The committee with jurisdiction over this standard is aware of other comparable standard published by the Cast Iron Soil Pipe Institute, CISPI-310, FM 1680 published by Factory Mutual, and Specification C 1540 published by ASTM.

1.5 The following precautionary caveat pertains only to the test method portion, Section 7, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:*

¹ This specification is under the jurisdiction of ASTM Committee C-24 on Building Seals and Sealants and is the direct responsibility of Subcommittee C24.75 on Gaskets and Couplings for Plumbing and Sewer Piping.

Current edition approved ~~Dec. 10, 1997~~ 2003. Published June ~~1998~~ 2003. Originally published as C 1277 – 94. Last previous edition C 1277 – 94~~7~~.

~~A 4888 Specification for Gray Hubless Cast Iron Soil Pipe and Fittings for Sanitary and Storm Drain, Waste, and Vent Piping Applications²~~

~~A 888 Specification for Hubless Cast Iron Soil Pipe and Fittings for Sanitary and Storm Drain, Waste, and Vent Piping Applications²~~

C 564 Specification for Rubber Gaskets for Cast Iron Soil Pipe and Fittings³

C 717 Terminology of Building Seals and Sealants³

C 1540 Specification for Heavy Duty Shielded Couplings Joining Hubless Cast Iron Soil Pipe and Fittings

2.2 *CISPI Standard:*

CISPI-301 Specification for Hubless Cast Iron Soil Pipe and Fittings for Sanitary and Storm Drain, Waste and Vent Piping Applications⁴

CISPI-310 Specification for Couplings for Use in Connection with Hubless Cast Iron Soil Pipe and Fittings for Sanitary and Storm Drain, Waste, and Vent Piping Applications⁴

FM 1680 Couplings Used in Hubless Cast Iron Systems for Drain, Waste or Vent, Sewer, Rainwater or Storm Water System, Above or Below Ground, Industrial, Commercial and Residential⁵

3. Terminology

3.1 *Definitions:*

3.1.1 Definitions of the following terms used in this specification are found in Terminology C 717, paragraph 4.1: elastomeric, durometer and dynamic.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 Descriptions of the following terms used in this specification are found in Terminology C 717, paragraph 4.2: durometer, dynamic:

3.2.2 The following descriptions of terms are applicable to this specification only:

~~3.2.2.1~~

3.2.1 *center stop, n*—an integral part of the gasket centered on the axial length of the gasket intended to limit the insertion depth of the pipe to be coupled.

3.2.2 *clamp assembly (n), n*—that portion of the coupling excluding the gasket and shield.

3.2.3 *corrugated, n*—any method of embossing.

3.2.4 *coupling (, n)*—the complete assembly.

~~3.2.2.4~~

3.2.5 *fitting (, n)*—parts of a pipeline other than straight pipes, valves, or couplings.

~~3.2.2.5~~

3.2.6 *gasket (n), n*—the elastomeric portion of the coupling.

~~3.2.2.6~~

3.2.7 *joint (n), n*—the point of assembly consisting of the coupling and the joined pipes or fittings, or both.

~~3.2.2.7~~

3.2.8 *shield (n), n*—an external metallic protective device designed to protect the sealing gasket from external elements that could cause failure of the sealing assembly-gasket.

4. Materials and Manufacture

4.1 Physical properties of gaskets shall comply with Specification C 564 using and the applicable Durometer hardness requirement of the column of dimensions, material specifications, physical and chemical properties as shown in Fig. 1, Fig. 2, Table 1 of that document as specified by the manufacturer.

4.2 All cast iron parts shall be made of a minimum class 25 gray cast iron, and shall show compliance to this requirement using test methods contained in Specification A 48.

4.2.1 ~~Clamp Table 2.~~

4.2 Clamp assembly screws or bolts shall not have screwdriver slots.

5. Elastomeric Gasket Requirements

5.1 The elastomeric gasket shall consist of one piece conforming to the physical requirements of Specification C 564.

5.1.1 The elastomeric gasket shall have an inside center stop that does not create an enlargement chamber or recess with a ledge, shoulder, or reduction of pipe area or offer an obstruction to flow.

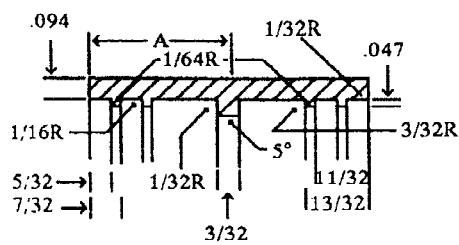
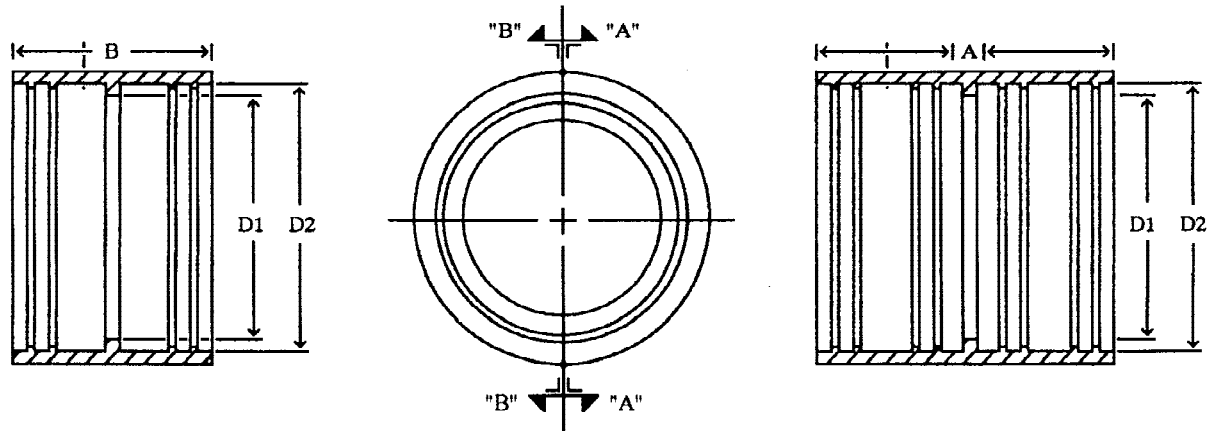
5.1.2 The elastomeric gasket shall be free of defects that affect the use and serviceability.

² Annual Book of ASTM Standards, Vol 01.02.

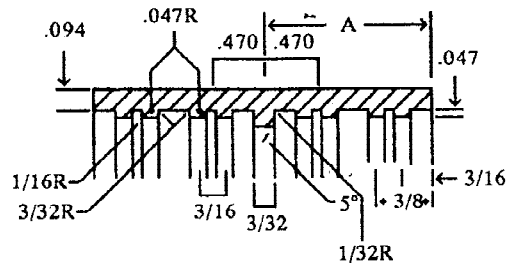
³ Annual Book of ASTM Standards, Vol 04.07.

⁴ Available from Cast Iron Soil Pipe Institute, 5959 Shallowford Rd., Suite 419, Chattanooga, TN 37421.

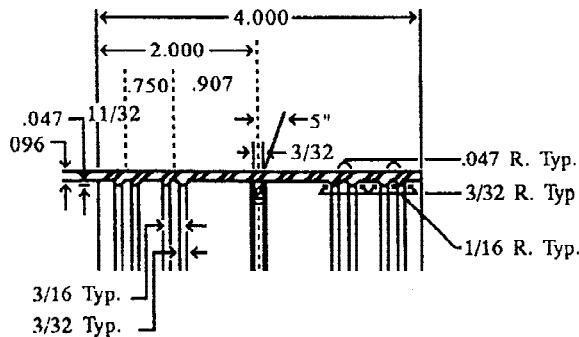
⁵ Available from Factory Mutual Research, 1151 Boston Providence Turnpike, Norwood, MA, 02062.



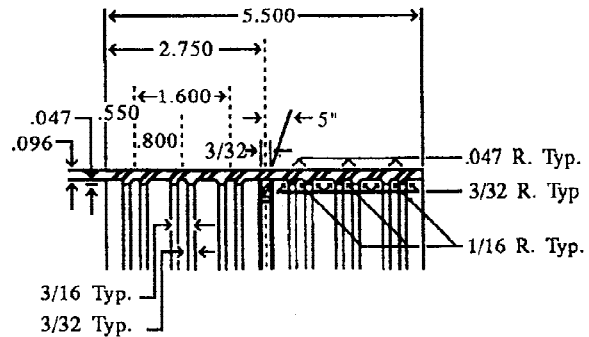
Dimensions for Sizes 1 1/2" - 4"



Dimensions for Sizes 5" - 6"



Dimensions for Sizes 8" and 10"



Dimensions for Sizes 12" and 15"

FIG. 1 Rubbestr Gained Hydrostatic Joint Test

	Dimensions									
	1 1/2 in.	2 in.	3 in.	4 in.	5 in.	6 in.	8 in.	10 in.	12 in.	15 in.
A	1.062	1.062	1.062	1.062	1.500	1.500	2.000	2.000	2.750	2.750
B	2.125	2.125	2.125	2.125	3.000	3.000	4.000	4.000	5.500	5.500
D1	1.531	1.968	2.968	4.000	4.968	5.968	7.968	9.975	12.000	15.200
D2	1.937	2.343	3.343	4.406	5.343	6.343	8.343	10.350	12.430	15.650

Dimensional Tolerances to be RMA Class 3 (See Table 1).

6. Clamp Assembly Requirements

6.1 The shield and clamp assembly shall be made of material conforming to the requirements as outlined in Section 6, Table 3 and Fig. 3.

6.1.1 All-steel parts shall be of 300 series stainless steel. All-steel parts made from round stock shall be of 300 series stainless steel (excluding copper bearing alloys). The shield shall be corrugated or otherwise provided with a mechanism to accommodate maximum and minimum OD's of pipe and fittings and include 2 stainless steel bands for sizes 1 1/2 to 4 in. and 4 bands for 5 to 10 in. and 6 bands for 12 and 15 in. Each tightening device housing shall interlock with a band at the unslotted end. The bands are to be fastened to the shield by riveting or such other method that will insure that the bands will not become separated from

**TABLE 1 Dimensions and Tolerances for Hubless Pipe—
Standard Dimensional Tolerances RMA CLASS 3**

Size, in. (mm)	Fixed, ±	Closure, ±
Outside Diameter, in. (mm)		
0 to 0.499 (mm)		
0.499	1 (38)	1.90 ± 0.06 (48.26 ± 1.52)
0.499	0.010	0.015
2 (51)	2.35 ± 0.09 (59.69 ± 2.29)	
0.500 to 0.999	0.09 (59.69 ± 2.29)	
3 (76.2)	3.35 ± 0.09 (85.09 ± 2.29)	
3 (76.2) 10	0.018	
4 (102)	4.38 ± 0.09 / -0.05 (111.25 ± 2.29 / -1.27)	
1.000 to 1.999	0.015	0.020
5 (127)	5.30 ± 0.09 / -0.05 (134.62 ± 2.29 / -1.27)	
2.000 to 2.999	0.020	0.025
6 (152)	6.30 ± 0.09 / -0.05 (160.02 ± 2.29 / -1.27)	
3.000 to 3.999	0.025	0.030
8 (203)	8.38 ± 0.13 / -0.09 (212.85 ± 3.30 / -2.29)	
4.000 to 4.999	0.030	0.035
10 (254)	10.56 ± 0.09 (268.22 ± 2.29)	
5.000 to 7.999	0.035	0.050

8.000 and over—multiplied by 0.0050. These are commercial tolerances.

TABLE 2 Rubber Gasket Physical Requirements

NOTE 1—Material: The sealing sleeve shall be made from an elastomeric compound that meets the requirements of Specification C 564.

NOTE 2—Physical Tests: The test specimens shall be obtained from finished sleeves and tested pursuant to the methods described in the following table.

Test	Physical Tests, Min or Max Requirements	ASTM Method
Tensile Strength	1500 psi min	D 412
Elongation	250 min	D 412
Durometer (Shore A)	70 ± 5°F at 76 ± 5°F	D 2240
Accelerated Aging	15 % max tensile and 20 % max elongation deterioration, 10 points max; increase in hardness, all determinations after oven aging for 96 h at 158°F	D 573
Compression Set	25 % max after 22 h at 158°F	D 395 Method B
Oil Immersion	80 % max. volume change after immersion in ASTM oil no. IRM903 for 70 h at 212°F	D 471
Ozone Cracking	No visible cracking at 2 times magnification of the gasket after 100 h. Exposure in 1.5 ppm ozone concentration at 100°F. Testing and inspection to be on gasket which is loop mounted to give approximately 20 % elongation of outer surface	D 1149
Tear Resistance	Die C; 150 lb min per inch of thickness	D 624
Water Absorption	20 % max by weight after 7 days at 158°F	D 471

the shield. The shield and clamp assembly shall comply with dimensions and material specifications, as are given in Table 3, Fig. 3, and Fig. 4.

6.1.2 Clamp assemblies shall be tested to withstand no less than the 125 % of manufacturers stated installation torque or a minimum of 60 lbf-in. (6.78 N-m) of applied torque, whichever is greater, without visible signs of failure. The clamp assembly shall be tested over a steel mandrel of the appropriate diameter and torqued as required.

6.1.3 The clamped shield shall meet the requirements of Table 3.

6.1.4 The couplings shall meet the dimensional requirements of Fig. 3.

7. Couplings Requirements and Test Methods

7.1 Assemble each coupling tested according to the manufacturer's instructions between two sections of randomly selected hubless cast iron soil pipe meeting the requirements of CISPI-301 or Specification A 888 and conduct the following test: hydrostatic, deflection, and shear. In addition, an unrestrained hydrostatic test will be performed between two sections of machined steel pipe.

7.1.1 Restrained Hydrostatic Joint Test:

7.1.1.1 Support the pipe assemblies in a manner that restrains joint movement as shown in Fig. 1.

7.1.1.2 Fill the assemblies with water, expel all air and apply a hydrostatic pressure in increments of 1 psi (6.9 kPa) at approximately 30 s intervals until a pressure of 13 psi (89.6 kPa) is reached and maintain 30 min. Any leakage shall mean failure.

7.1.2 Deflection Test:

7.1.2.1 A test apparatus such as the one shown in Fig. 2 is suggested. Other testing apparatus that provide restraint to the assembly shall also be permitted. Close the outboard ends of the pipe with test plugs.

7.1.2.2 Fill the assembly with water, expel all air, and hydrostatically pressurize to 4.3 psi (29.6 kPa) for the duration of the test. One pipe shall be rigidly supported and while the assembly is under pressure, raise the opposite end of the other pipe 1/2 in.

TABLE 3 Material Specifications

<u>Band</u>	Type 301 AISI Stainless Steel—Minimum Tensile 165 000 psi for 1½ to 15 in.; Type 304 AISI Stainless Steel is permitted Type 304 AISI Stainless Steel—Minimum Tensile 140 000 psi
<u>Eyelets/Rivets</u>	Type 300 AISI Stainless Steel
<u>Screw Housing</u>	Type 301 AISI Stainless Steel for 1½ to 15 in.; Type 304 AISI Stainless Steel is permitted
<u>Screw</u>	Type 305 AISI Stainless Steel— $\frac{5}{16}$ Hex Head/Shoulder for 1½ to 10 in.; $\frac{3}{8}$ Hex Head/Shoulder for 12 and 15 in. is required for couplings which require installed torque greater than 60 in.-lb When other than $\frac{3}{8}$ in. hex head screw is used on 12 and 15 in. couplings, the coupling shall be labeled with the required installation torque
<u>Shield</u>	Type 301 AISI Stainless Steel—Bright Annealed Only (Annealed and Pickled Not Acceptable) Hardness—Rockwell B-85 Max (Max Burr Height Not to Exceed 25 % of Thickness) for Type 301 AISI Stainless Steel; Rockwell B-95 Max (Max Burr Height Not to Exceed 25 % of Thickness) for Type 304 AISI Stainless Steel

- (1) Construction for sizes 1½ thru 10 in. shields have corrugations tapering in height from 0.000 to 0.030 in. at dimension “Y.” Y equals maximum of 1 in. (Type A Only)
- (2) Position clamps on shield as shown from inside end of clamp. Shield overlap to be as shown or reversed on 5, 6, 8, 10, 12, and 15 in. only.
- (3) Securely fasten each clamp to shield, two places for sizes 1½ to 4 in., three places for sizes 5, 6, 8, 10, 12, and 15 in.
- (4) Details of detent on 5, 6, 8, and 10 in. bands are shown in Fig. 4 (optional for 12 and 15 in.).
- (5) Max “X” is that dimension to which the clamp must open and still maintain positive engagement of the screw in the slots of the clamping band. Min. “X” is that dimension to which the clamping band must close and still maintain positive engagement of the screw in the slots of the clamping band.

(12.7 mm) per lineal foot of pipe. Maintain the pressure for 5 min. Any leakage shall mean failure.

7.1.32 Shear Test:

7.1.32.1 Support two joined lengths of randomly selected hubless cast iron soil pipe on blocks, a minimum of 1½ in. (38.1 mm) high, at three locations. One length shall be a minimum of 24 in. (609.6 mm) in length, supported on blocks, one near the uncoupled end, and the other immediately adjacent to the couplings. Firmly restrain this length in position as shown in Fig.-3 6. The other coupled length shall be a minimum of 5 ft (1.52 m) in length and supported by a single block 6 in. (152.4 mm) from the end of the pipe.

7.1.32.2 Fill the assembly with water and expel all air. Apply a load of 50 lb/in. of nominal diameter at a point 6 in. (152.4 mm) from the edge of the coupling upon a 12 in. (304.8 mm) length of (3 by 3) angle iron or load distribution pad located on the top of the pipe immediately adjacent to the coupling of the pipe having one support only. Under this loading there shall be no visible leakage or displacement of more than $\frac{3}{8}$ in. (9.53 mm) from true alignment adjacent to the coupling, when an internal pressure equivalent to a 10 ft (3.05 m) head of water-(4.3 psi (29.6 kPa)) is applied. Maintain the load and internal pressure for 15 min.

7.2 Thrust

7.1.3 Unrestrained Hydrostatic Test :

7.21.3.1 Assemble each coupling tested according to the manufacturer’s instruction between two sections of machined steel pipe and conduct the thrust test.

7.21.3.2 The assembly shall consist of a maximum outside diameter pipe connected to a minimum outside diameter pipe with diameters as referenced in Table-4 4 and lengths as shown in Fig.-4 7. Machine the plain ends of the pipe to be used for the thrust test to the correct diameters. Plain ends shall have 0.015 in. (0.38 mm) deep grooves machined circumferentially around them at $\frac{1}{8}$ in. (3.18 mm) intervals down the pipe section for a distance equal to that covered by the elastomeric sleeve of the coupling being tested. The tool used to machine the grooves shall have a 60° inclined angle and cut into the pipe from a perpendicular position. The surface between the grooves shall be a lathe turned surface of 125 RMS.

7.21.3.3 The plain ends of the pipe for the thrust test shall be uncoated and cleaned with acetone and thoroughly dried before each assembly.

7.21.4 Test Method:

7.21.4.1 Support the pipe assemblies in a manner that does not restrain joint movement as shown in Fig.-4 7.

7.21.4.2 Fill the pipe assembly (as required in 7.21.3) with water, expelling all air. Increase the hydrostatic pressure at a rate of 1 psi (6.9 kPa) every 30 s until the specified test pressure is reached. The specified test pressure shall be 20 psi (137.9 kPa) for 1½ in. (38.1 mm) through 5 in. (127 mm), 18 psi (124.1 kPa) for 6 in. (152.4 mm), 10 psi (68.9 kPa) for 8 in. (203.2 mm), and 6 psi (41.4 kPa) for 10 in. (254 mm) pipe, 12 in. (305 mm), and 15 in. (380 mm). When the specified test pressure is reached, hold it for 10 min. Any leakage or axial joint movement of more than 0.150 in. (3.81 mm) shall mean failure.

8. Markings and Identification

8.1 PMarking—The gasket shall be marked with raised letters. This marking shall consist of pipe size, country of origin, manufacturer’s identifying mark, and Specification C 564, latest revision. Such marking shall not exceed 0.02 in. in relief.

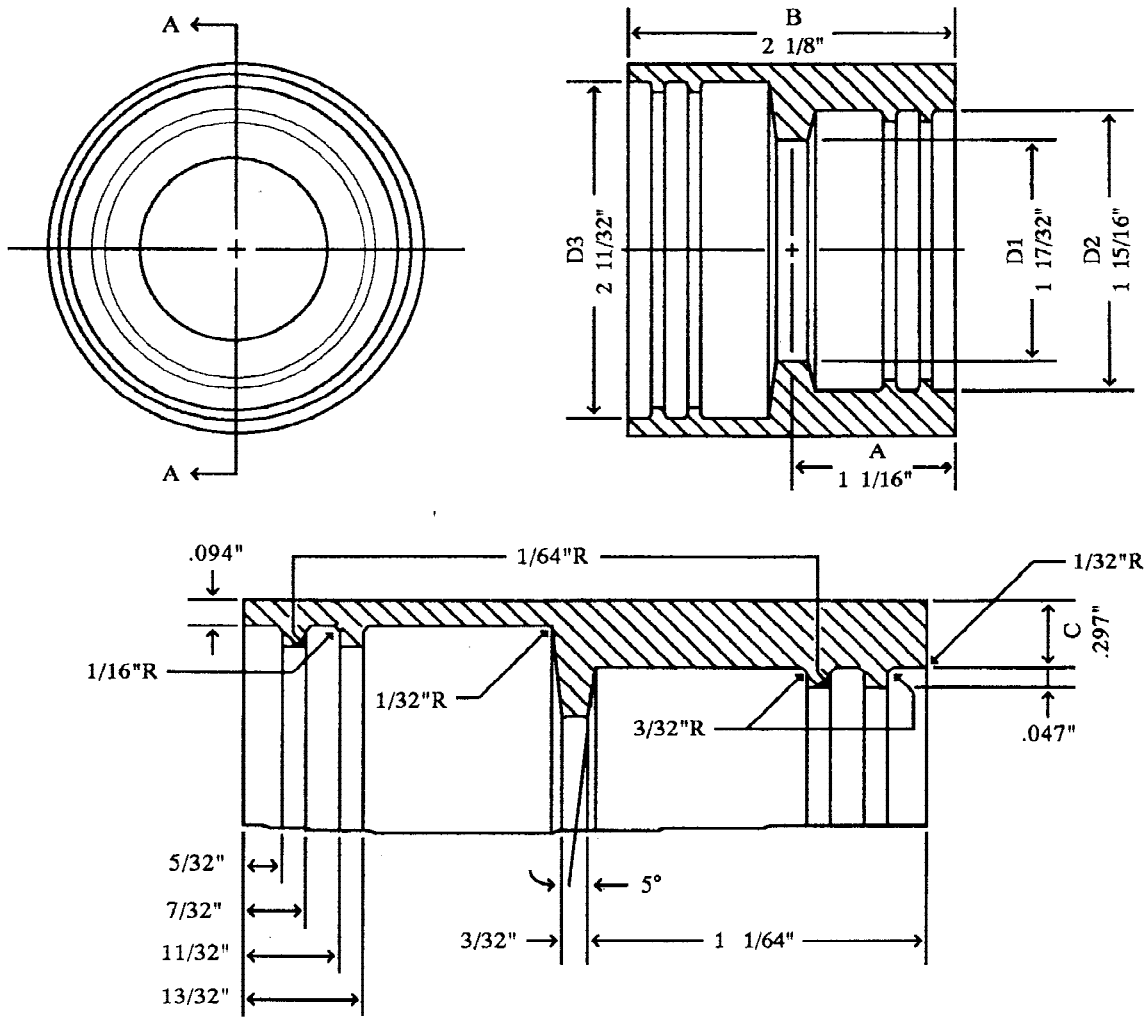


FIG. 2-D Refreduction Tg Rubber Gasket

	Dimensions for Reducing Sleeves		
	$2 \times 1\text{-}1/2$	3×2	4×3
A	1.062	1.062	1.062
B	2.125	2.125	2.125
C	0.297	0.594	0.625
D1	1.531	1.968	2.968
D2	1.937	2.343	3.343
D3	2.343	3.343	4.406

Dimensional Tolerances to be RMA Class 3 (See Table 1).

8.2 The shield and clamp assembly and gasket shall be marked with indented letters. All marking shall be placed on the band assemblies. Marking on the band shall consist of pipe size. Marking on the screw housing shall consist of coupling manufacturer's name or registered trademark, with a national registry of origin, and trademarks in the pipe size for country in which it is designed.

8.2 The the product shall also have any other markings required by law and may include this designation (ASTM C 1277). is installed, the words ALL STAINLESS, country of origin. No marking is permitted on couplings with corrugated shield.

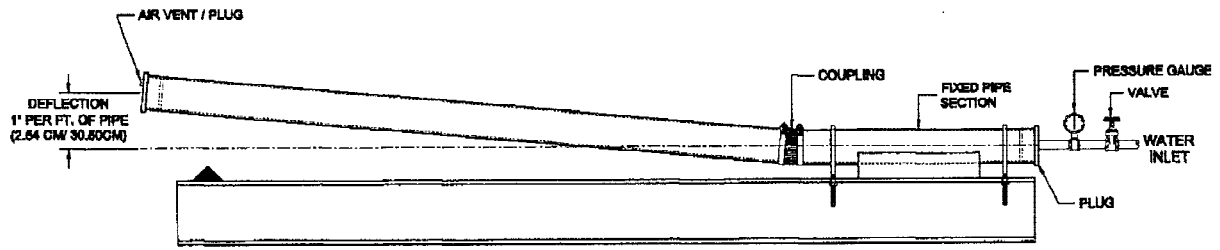
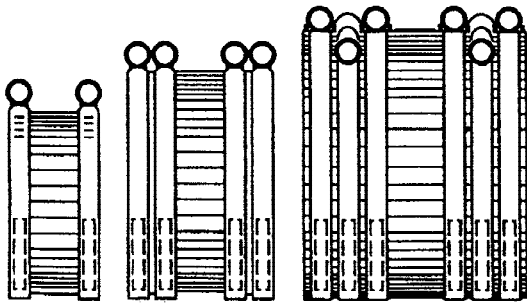


FIG. 5 Deflection Test

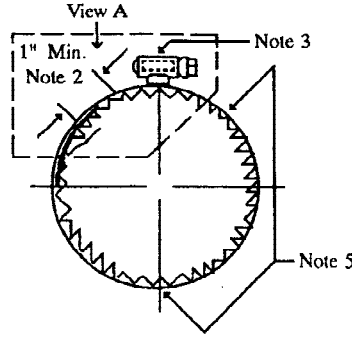
No Permanent Marking Allowed On Shield



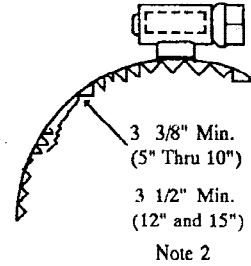
Sizes 1 1/2" Thru 4"

Sizes 5" Thru 10"

Sizes 12" Thru 15"

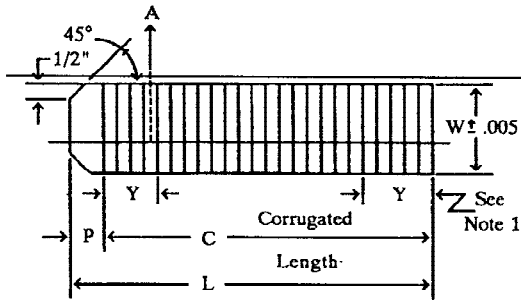


Sizes 1 1/2" Thru 4"

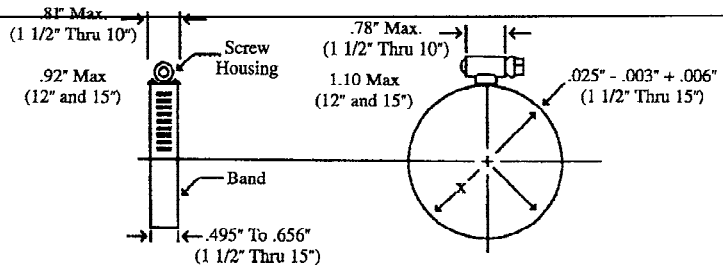
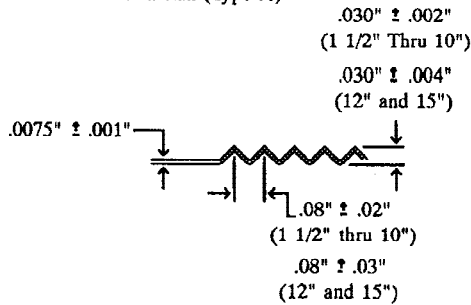


View A (sizes 5" Thru 15")

Shield And Clamp Assembly



Shield Detail (Type A)



Clamp Detail

Single corrugations are shown in drwg, other corrugations unique to individual manufacturers are acceptable. The "P" dimension may not apply to all coupling designs.

NOTE—Marking allowed of couplings using non-corrugated shields

Pipe Size, in.	Dimensions, in.					
	P	C	L	W	X ⁷ , min	X ⁷ , max
1 1/2	0.813 ± 0.188	6.688	7.5 ± 0.125	2.125	1.50	2.50
2	0.813 ± 0.188	8.188	9.0 ± 0.125	2.125	2.00	3.00
3	0.813 ± 0.188	11.438	12.25 ± 0.125	2.125	3.00	4.00
4	0.813 ± 0.188	14.813	15.63 ± 0.125	2.125	4.00	5.00
5	2.375 ± 0.125	17.563	19.94 ± 0.125	3.000	5.30	6.20
6	2.375 ± 0.125	20.250	22.63 ± 0.125	3.000	6.30	7.20
8	3.000 ± 0.125	26.000	29.00 ± 0.125	4.000	8.30	9.20
10	3.000 ± 0.125	33.250	36.25 ± 0.250	4.000	10.45	11.35
12	3.500 ± 0.125	39.100	42.60 ± 0.250	5.500	12.53	13.27
15	3.500 ± 0.125	49.200	52.70 ± 0.250	5.500	15.75	16.49

FIG. 3 Shield and Clamp Assembly

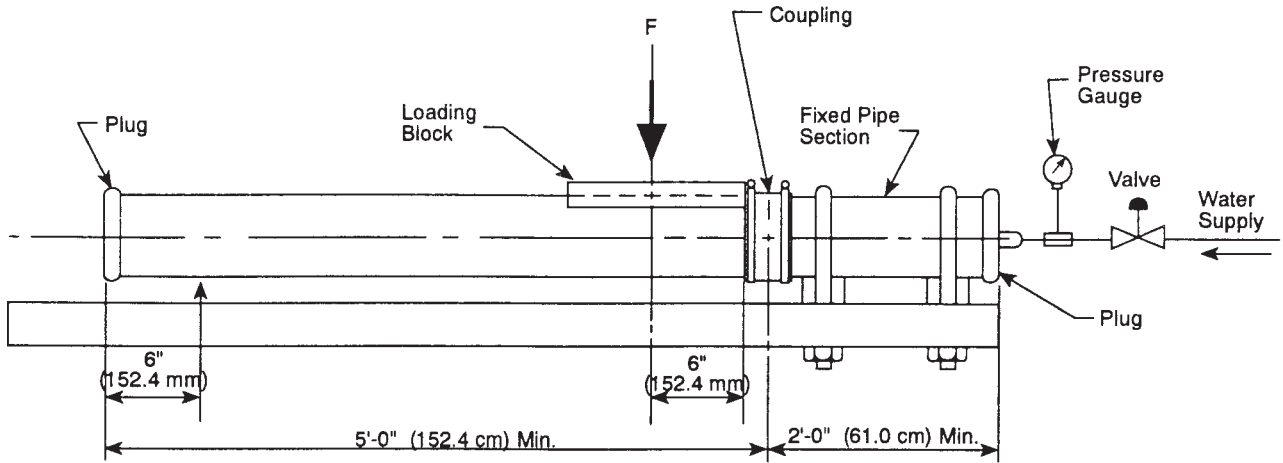
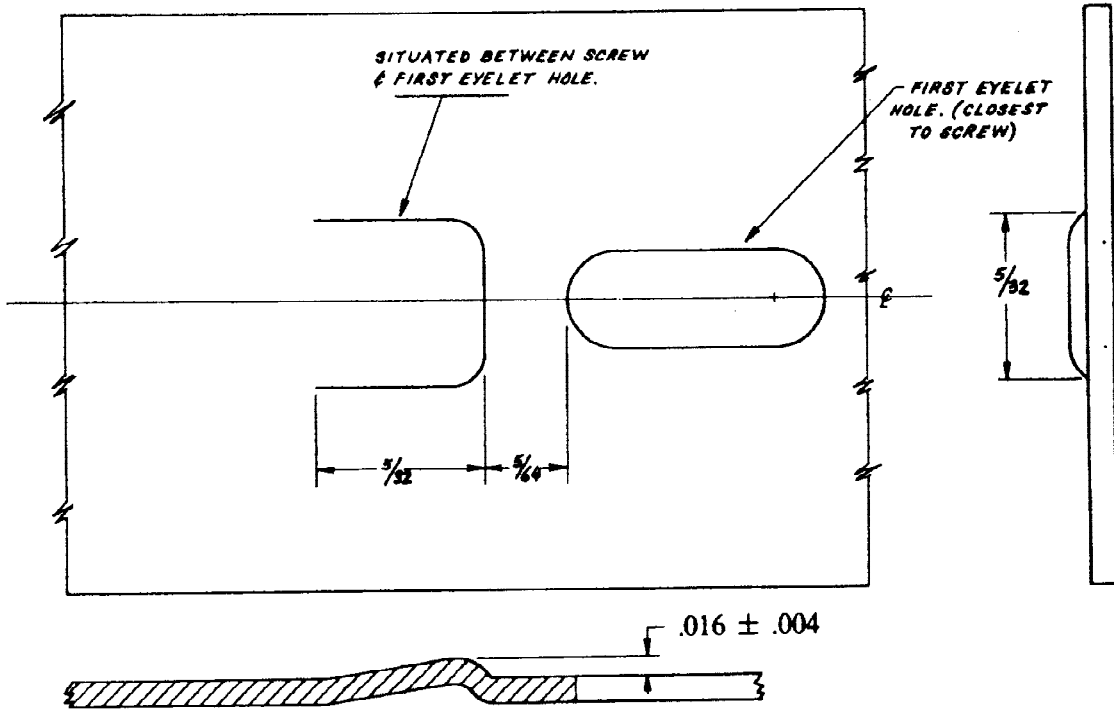


FIG. 6 Shear Test

TABLE 4 Dimensions and Tolerances for Hubless Pipe and Fittings

Size, in. (mm)	Outside Diameter, in. (mm)
1½ (38)	1.90 ± 0.06 (48.26 ± 1.52)
2 (51)	2.35 ± 0.09 (59.69 ± 2.29)
3 (76.2)	3.35 ± 0.09 (85.09 ± 2.29)
4 (102)	4.38 ± 0.09/-0.05 (111.25 + 2.29/-1.27)
5 (127)	5.30 ± 0.09/-0.05 (134.62 + 2.29/-1.27)
6 (152)	6.30 ± 0.09/-0.05 (160.02 + 2.29/-1.27)
8 (203)	8.38 ± 0.13/-0.09 (212.85 + 3.30/-2.29)
10 (254)	10.56 ± 0.09 (268.22 ± 2.29)
12 (305)	12.50 ± 0.09 (317.5 ± 2.29)
15 (380)	15.83 ± 0.09 (402.8 ± 2.29)



NOTE—Detail of typical coupling is shown. Other couplings are allowed to have different designs such as spot welding.
 FIG. 4 Details of Detent on 5, 6, 8, and 10 in. Bands (Optional on 12 and 15 in.)

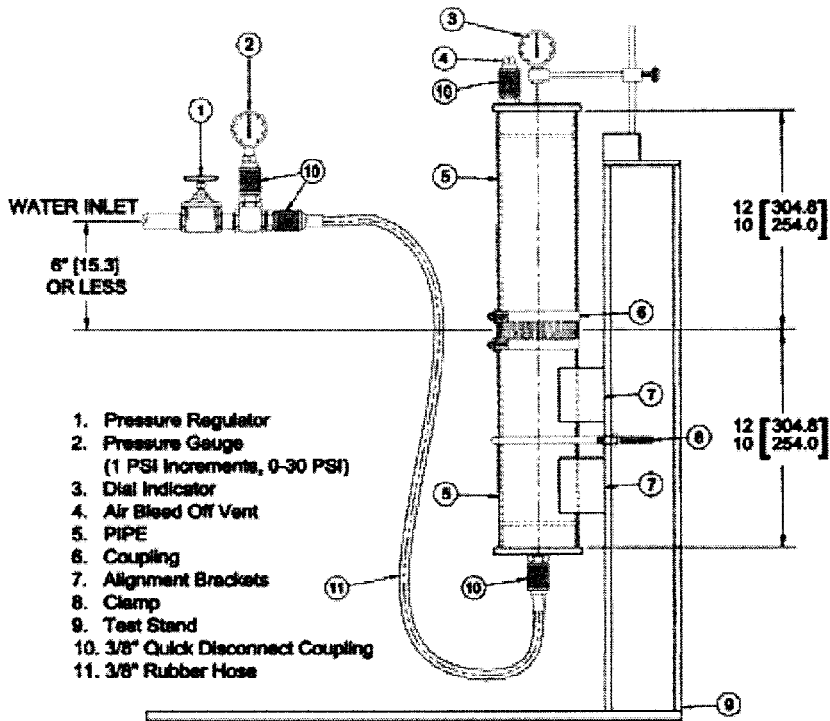


FIG. 7 Unrestrained Hydrostatic Test

 **C 1277 – 9703**

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