HIGH PERFORMANCE ENGINEERED MATERIALS

Hancor SanTite pipe is made from rigid, High Density Polyethylene (HDPE) material, which is arguably the best material to withstand abrasion, and corrosive attacks from acids and alkaline soils as well as the harsh conditions found in industrial waste and municipal sewers. Alternative materials such as PVC compounds manufactured in accordance with ASTM D1784 are allowed to use fillers (typically crushed limestone), which reduce the material’s long-term strength properties and impact strength capability. HDPE specifications have no allowance for fillers or recycled material when conforming to ASTM D3350. High material assures the physical properties meet the minimum classification of 85A/400C as defined and described in ASTM D3350. This assures impact strength and long term service life for the tough, wet, world of sanitary sewer.

ADVANCED ENGINEERED JOINT PERFORMANCE

The Hancor patented composite joint system is used to assure long-term water tightness. Joint tightness exceeds the minimum requirements of ASTM D3212. The composite jointing system not only meets the laboratory test of ASTM D3212 but has been shown to provide continuous watertight performance for the over 100 year life of the system. At the heart success for the jointing system is the reinforced bell and spigot technology.

CONTRACTOR’S CHOICE FOR CONSTRUCTION

High performance HDPE assures owners and contractors of the structural integrity of the Hancor SanTite pipe. This all adds up to a more installation friendly pipe.

QUALITY ENGINEERING AND MANUFACTURING

Hancor sanitary sewer pipe uses state-of-the-art seamless construction with similar corrugations which provide superb structural integrity. Some manufacturers use helically wrapped thermoplastic pipe technology, which provides opportunity for seam separation and splitting. Additionally, Hancor sanitary sewer pipe has integral bells and spigots formed by continuous extrusions without the use of postproduction welding. This tough, highly engineered product is constructed from high performance material built to withstand the rigors of the installed environment and handle impacts well in excess of its tools.

OUTSTANDING HYDRAULICS IN REAL APPLICATIONS

Hancor sewer pipe is a dual wall product with a smooth waterway. Advanced material technology in combination with co-extruded liners translate into smooth liners. With most EPA design criteria dictating a Manning’s coefficient consistent with that of RCP, HDPE offers a smooth base. Typical in-service field conditions must be in a design Manning’s coefficient of not greater than 0.012.

COMPLETE LINE OF FITTINGS AND ACCESSORIES

In addition to a superb pipe product, Hancor offers a complete line of fittings, manhole connection adapters, and accessories.
HANCOR SANITATE SEWER PIPE SPECIFICATION

**SCOPE**

This specification describes 24” - 60” (600 - 1500mm) Hancor SanTite Pipe for use in gravity flow applications, such as industrial wastewater and municipal sanitary sewers.

**PIPE REQUIREMENTS**

Hancor SanTite Pipe shall have smooth interior and transition external corrugations, 24” - 60” (600 - 1500mm) pipe diameters shall meet all the requirements of ASTM F2306.

**HYDRAULICS**

A Manning’s coefficient of not less than 0.012 shall be used for design.

**FITTINGS**

Couplings, elbows, reducers, tees, valves, and other fittings shall be capable of withstand ing operating conditions when installed. Fittings may be welded or brazed. Fabricated fittings shall be welded at all accessible interior and exterior junctions.

**MATERIAL REQUIREMENTS**

Pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306. The pipe shall be made of virgin polyethylene resin that conforms to ASTM F2306.
HANCOR SANITITE SEWER PIPE SPECIFICATION

**SCOPE**
This specification describes 24” - 60” (600 - 1500mm) Hancor Sanitite Pipe for use in gravity flow applications, such as industrial wastewater and municipal sanitary sewer.

**PIPE REQUIREMENTS**
Hancor Sanitite Pipe shall have smooth interior and annular exterior corrugations. 24” - 60” (600 - 1500mm) pipe diameters shall meet all the requirements of ASTM F2306.

**INTEGRALSTHIS**
A Hargis’s coefficient of not less than 0.012 shall be used for design.

**JOINT PERFORMANCE**
Pipe shall be joined with the Hancor Sanitite composite joint meeting or exceeding the short-term test requirements of ASTM D3212.

**HYDRAULICS**
A Manning’s coefficient of not less than 0.012 shall be used for design.

**FIELD PIPE AND JOINT PERFORMANCE TESTING**
To assure watertightness, field performance verification may be accomplished by testing in accordance with ASTM F417 or ASTM C969. Appropriate safety precautions must be used when field testing any pipe material. For long runs of pipe, joint to joint testing should be considered.

**FITTINGS**
Couplings, elbows, reducers, tees, wyes, laterals and other fittings shall be capable of withstandng all operating conditions when installed. Fittings may be molded or fabricated. Fabricated fittings shall be tested at all accessible inner and outer junctions.

**MATERIAL REQUIREMENTS**
Pipe shall be made of pure polyethylene resin that conforms to ASTM F2306. The manufacturer shall be responsible for providing pipe with the minimum wall thickness to conform to ASTM F2306.

**INSTALLATION**
Installation shall be in accordance with ASTM D2321, with the exception that minimum joint backfill depths for backfill over the top of the pipe shall be 1 ft. (0.3 m), for 24” - 48” (600 - 1200mm) diameters, and 2 ft. (0.6 m) for 60” (1500mm) diameter.

**PIPE DIMENSIONS**
Pipe dimensions shall be as drawn in Table 1 below:

**FEATURES AND BENEFITS**
- Patented reinforced bell-and-spigot joint is a cost-effective alternative to traditional materials.
- HDPE (High Density Polyethylene) for less breakages than conventional sewer products.
- Field proven in watertight storm drainage, low head pressure applications, and sanitary sewer applications. To meet the deeper burial depths of sanitary sewer lines, a flexible pipe and bell-and-spigot joint is necessary. The joint has been field proven in watertight storm drainage, low head pressure applications, and sanitary sewer applications. To meet the deeper burial depths of sanitary sewer lines, a flexible pipe and bell-and-spigot joint is necessary.

**Gaskets**
Gaskets shall be made of polyisoprene meeting the requirements of ASTM F477. Gaskets shall be installed by the pipe manufacturer and encased with a removable wrap to ensure the gasket is free from debris. A joint lubricant available from the manufacturer shall be used on the gasket and bell during assembly.

**SANITITE JOINT**
Joint assemblies have been field proven in watertight storm drainage, low head pressure applications, and sanitary sewer applications. The reinforced bell shall include bell reinforcement by means of multiple ceramic polymer inserts installed in the manifolds. The spigot steel shall have two gaskets which can be fully inserted into the bell.

**Table 1**

<table>
<thead>
<tr>
<th>Nominal Diameter, in. (mm)</th>
<th>24” (600)</th>
<th>36” (900)</th>
<th>48” (1200)</th>
<th>60” (1500)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Min. Pipe Stiffness (KN/m²)</td>
<td>0.07</td>
<td>0.095</td>
<td>0.105</td>
<td>0.105</td>
</tr>
<tr>
<td>Inner Liner Thickness, in.</td>
<td>0.07</td>
<td>0.095</td>
<td>0.105</td>
<td>0.105</td>
</tr>
<tr>
<td>Min. Pipe OD, in. (mm)</td>
<td>3.0</td>
<td>4.3</td>
<td>5.5</td>
<td>6.6</td>
</tr>
<tr>
<td>Min. Pipe ID, in. (mm)</td>
<td>2.4</td>
<td>3.5</td>
<td>4.8</td>
<td>5.6</td>
</tr>
</tbody>
</table>

**Hancor Sanitite**
Hancor Sanitite composite joints are designed for a minimum 100 year design life. They are 100% virgin HDPE Material and are designed for a minimum 100 year design life. Available in sizes from 24” to 60”, SaniTite is ideal for industrial and municipal sanitary trunk and sewer applications. To meet the deeper burial depths of sanitary sewer lines, a flexible pipe and bell-and-spigot joint is necessary. The joint has been field proven in watertight storm drainage, low head pressure applications, and sanitary sewer applications. The reinforced bell shall include bell reinforcement by means of multiple ceramic polymer inserts installed in the manifolds. The spigot steel shall have two gaskets which can be fully inserted into the bell. Gaskets shall be made of polyisoprene meeting the requirements of ASTM F477. Gaskets shall be installed by the pipe manufacturer and encased with a removable wrap to ensure the gasket is free from debris. A joint lubricant available from the manufacturer shall be used on the gasket and bell during assembly.

**FIELD PIPE AND JOINT PERFORMANCE TESTING**
To assure watertightness, field performance verification may be accomplished by testing in accordance with ASTM F417 or ASTM C969. Appropriate safety precautions must be used when field testing any pipe material. For long runs of pipe, joint to joint testing should be considered.

**FITTINGS**
Couplings, elbows, reducers, tees, wyes, laterals and other fittings shall be capable of withstanding all operating conditions when installed. Fittings may be molded or fabricated. Fabricated fittings shall be tested at all accessible inner and outer junctions.

**MATERIAL REQUIREMENTS**
Pipe shall be made of pure polyethylene resin that conforms to ASTM F2306. The manufacturer shall be responsible for providing pipe with the minimum wall thickness to conform to ASTM F2306. Average NCLS test specimen results must exceed 24 hours with no test result less than 17 hours.

**INSTALLATION**
Installation shall be in accordance with ASTM D2321, the exception that minimum joint backfill depths for backfill over the top of the pipe shall be 1 ft. (0.3 m), for 24” - 48” (600 - 1200mm) diameters, and 2 ft. (0.6 m) for 60” (1500mm) diameter.

**PIPE DIMENSIONS**
Pipe dimensions shall be as drawn in Table 1 below:

**FEATURES AND BENEFITS**
- Patented reinforced bell-and-spigot joint is a cost-effective alternative to traditional materials.
- HDPE (High Density Polyethylene) for less breakages than conventional sewer products.
- Available in 20.5’ (6.24m) lengths for shallow burial and short lengths to accommodate trench boxes.
- Lightweight, easy to handle, easily cut to field.
- Bell-and-spigot joint for ease and speed of connection.
- High UV resistance for hassle-free speed of connection.
- Lightweight, easy to handle, easily cut to field.
- Bell-and-spigot joint for ease and speed of connection.
- Smooth interior for greater hydraulics.
HANCOR SANITITE SEWER PIPE SPECIFICATION

SCOPe
This specification describes 24” - 60” (600 - 1500mm) Hancor Sanitite Pipe for use in gravity flow applications, such as industrial wastewater and municipally sanitary sewer systems.

Pipe REQUIREMENTS
Hancor Sanitite Pipe shall have smooth interior and annular exterior corrugations. 24” - 60” (600 - 1500mm) pipe diameters shall meet all the requirements of ASTM F2306.

HYdraulIcS
Hancor Sanitite Pipe shall have smooth interior and annular exterior corrugations. 24” - 60” (600 - 1500mm) diameters shall have a reinforced bell-and-spigot. The reinforced bell shall include bell reinforcement by means of multiple ceramic polymer wraps installed by the manufacturer. The spigot shall have two gaskets which can be fully inserted into the bell.

Joint PERFORMANCE
Pipes shall be joined with the Hancor Sanitite composite joint meeting or exceeding the short-term test requirements of ASTM D3212.

InStallation
Installation shall be in accordance with ASTM D2321, with the exception that minimum NCLS test specimen results must exceed 24 hours with no test result less than 17 hours.

MATERIAL REQUIREMENTS
Pipe shall be made of virgin polyethylene resin that conform to ASTM F2306. The pipe shall be made of a material meeting the requirements of cell classification HDPE-2500 or higher in accordance with ASTM D2984. Average NCLS test specimen results must exceed 24 hours with no test result less than 17 hours.

INSTALLation
Installation shall be in accordance with ASTM D2322, with the exception that minimum test depth for backfill over the top of the pipe shall be 1 ft. (0.3 m), for 24” - 48” (600 - 1200mm) diameters, and 2 ft. (0.6 m) for 60” (1500mm) diameter.

PIPE DIMENSIONS
Pipe dimensions shall be as shown in Table 1 below:

FEATURES AND BENEFITS
• Patented reinforced bell-and-spigot joint maintains a smooth pipe joint.
• HD-25 (high duty traffic loads) rated with material core.
• Tough, high impact resistant HDPE, for less breakage than conventional sewer products.
• Available in 20.5’ (6.24m) lengths for storage and transport.
• Lightweight, easy to handle, easily cut to field.
• Bell-and-spigot joint for easy and speed of connection.
• High UV resistance for hassle free site storage.
• Smooth flow for greater hydraulics.

Hancor Sanitite: Hancor Sanitite composite joints are committed to providing you with the answers to all your questions, including your region. For more information about Hancor Sanitite Composite Joint, please contact your local Hancor representative or visit our website at www.hancor.com.
HIGH PERFORMANCE ENGINEERED MATERIALS

Hancor® SaniTite® pipe is made from rigid High Density Polyethylene (HDPE) material, which is arguably the least material to withstand damage, and convives attacks from solids and alkaline soils as well as the harsh chemcials found in industrial waste and municipal sewers. Alternate materials such as PVC compounds manufactured in accordance with ASTM D1784 are allowed to use fillers (typically crumbled limestone), which reduce the pipe component’s long-term strength properties and impact strength capability. HDPE specifications have no allowance for fillers or recycled material when conforming to ASTM D3350. HDPE material assures the physical properties meet the minimum classification of 435400C as defined and described in ASTM D3350. This assures impact strength and long term service life for the tough, real world environment of sanitary sewers.

ADVANCED ENGINEERED JOINT PERFORMANCE

The Hancor® patented composite joint system is used to assure long-term watertightness. Joint tightness exceeds the minimum requirement of ASTM D3350. The composite jointing system not only meets the laboratory test of ASTM D3212 but has been shown to provide continuous watertight performance for the over 100 year life of the system. At the heart of success for the jointing system is the interlaced bell and socket technology.

CONTRACTOR’S CHOICE FOR CONSTRUCTION

High performance HDPE assures owners and contractors of the structural integrity of the Hancor® SaniTite® pipe. This all adds up to a more installation friendly pipe.

QUALITY ENGINEERING AND MANUFACTURING

Hancor® sanitary sewer pipe uses state-of-the-art seamless construction with similar corrugations which provide superb structural integrity. Some manufacturers use helically wrapped thermoplastic pipe technology, which provides opportunity for seam separation and splitting. Additionally, Hancor sanitary sewer pipe has integral bells and sockets formed by continuous extrusion without the use of postproduction welding. This tough, highly engineered product is constructed with higher performance material built to withstand the rigors of the installed environment and handle impacts well in excess of its limits.

OUTSTANDING HYDRAULICS IN REAL APPLICATIONS

Hancor sewer pipe in a dual wall product with a smooth waterway. Advanced material technology in combination with co-extruded liners translate into smooth liners. With most EPA design criteria dictating a Manning’s coefficient consistent with that of RCP HDPE offers a smooth liner. Typical in-service field conditions result in a design Manning’s coefficient of not greater than 0.012.

COMPLETE LINE OF FITTINGS AND ACCESSORIES

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