

ICS 83.140.30

G 33



**NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC
OF CHINA**

中华人民共和国国家标准

GB/T 18477.1-2007

Replace GB/T 18477-2001

**Unplasticized polyvinyl chloride (PVC-U) structure wall
pipeline system for underground soil waste and drainage -**

Part 1: double wall corrugated pipes

埋地排水用硬聚氯乙烯(PVC-U)结构壁管道系统

第 1 部分：双壁波纹管材

Issued on December 05, 2007

Implemented on September 01, 2008

**Issued by General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China**

Standardization Administration of the People's Republic of China

Contents

Foreword	0
1 Scope	1
2 Normative References	1
3 Definitions and symbols	2
4 Material	4
5 Classification	4
6 Pipe structure and connection	6
7 Technology requirements	7
8 Test method	10
9 Inspection rules	12
10 Marking, transportation and storage	13
Annex A (Informative) Raw material requirements	14
Annex B (Normative) Elastic seal ring connector sealing test methods	15

Foreword

GB/T 18477 *Rigid Polyvinyl Chloride (PVC-U) Structure Wall Pipe System for Underground Drainage and Sewage* is divided into three parts:

- Part 1: Double wall corrugated pipes
- Part 2: Reinforced pipes (Prepare to formulate)
- Part 3: Bilayer and hollow-wall construction with axial hollow pipes (Prepare to formulate)

This part is Part 1 of GB/T 18477.

This part substitutes GB/T 18477-2001 *Rigid Polyvinyl Chloride (PVC-U) Structure Wall Pipe System for Underground Soil Waste and Drainage*. During amendment, the Standard refers to the requirements on PVC-U structure wall pipes in the international standard ISO/DIS 21138-1: 2006 *Non-pressure Underground Thermoplastic Piping System for Drainage and Sewage Rigid Polyvinyl Chloride (PVC-U), Polypropylene (PP) and Polyethylene (PE) Structural Pipe Wall System Part 1: Pipes, Pipe Fittings and System Material Regulations and Performance Requirements* and ISO/DIS 21138-3: 2006 *Non-pressure Underground Thermoplastic Piping System for Drainage and Sewage Rigid Polyvinyl Chloride (PVC-U), Polypropylene (PP) and Polyethylene (PE) Structural Pipe Wall System Part 3: Type B Pipes and Pipe Fittings of Unsmooth External Wall*.

In comparison with GB/T 18477—2001, this part has the major changes as follows:

- Added the Chapter of Definitions, Symbols (See Chapter 3);
- Added the dimensions for inner diameter series (See 7.3);
- Added the requirements of laminated wall thickness and inner wall thickness (See 7.3);
- Added density requirements (See 7.4)
- Added system suitability test (See 7.5)
- Added Annex A and Annex B.

Please note that some contents in this part may involve patents. The issued institution of this part should not bear the responsibility to identify these patents.

Annex A of this part is informative, while Annex B is normative.

This part was proposed by China National Light Industry Council.

This part is under jurisdiction of National Technical Committee of Standardization for Plastics Products (SAC/TC48).

This part is drafted by the following units: ERA Plastic Industry Group, Zhejiang Zhongcai Pipes Science and Technology Co., Ltd., Guangdong Liansu Technology Industrial Co., Ltd., Fujian Axiata New Material Technology Co., Ltd., Anhui Guotong Hi-Tech Pipes Industry Co., Ltd., Chongqing Goody Plastic Electrical Appliances Co., Ltd., Hangzhou Boda Plastic Industry Co., Ltd. and Jiangsu Province Product Quality Supervision and Inspection Center.

Main Personnel involved in drafting this part: Huang Jian, Ding Liangyu, Lin Shaoquan, Wei Zuoyou, Zhang Wenli, Wu Xiaofen, Zhou Bo and Zhu Yuhong.

Unplasticized polyvinyl chloride (PVC-U) structure wall pipeline system for underground soil waste and drainage - Part 1: double wall corrugated pipes

1 Scope

This part in GB/T 18477 regulated the material, classification, pipe structure and connection, technical requirements, test methods, inspection rules and marks, transportation and storage of rigid polyvinyl chloride double wall corrugated pipes (hereinafter referred to as Pipe) that took polyvinyl chloride resin as the main raw material and extrusion molding used for underground drainage.

This part applies to the pipes used for non-pressure municipal underground drainage, outside drainage of building and farmland drainage pipes as well as communication cable threading casings.

Considering the material chemical resistance and temperature resistance, it can also be used as non-pressure underground industrial sewage pipes.

2 Normative References

The articles contained in the following documents have become this standard when they are quoted herein. For the dated documents so quoted, all the modifications (excluding corrections) or revisions made thereafter shall not be applicable to this Standard. For the undated documents so quoted, the latest editions shall be applicable to this Standard.

GB/T 1033-1986 Test method for density and relative density of plastics

GB/T 2828.1-2003 Sampling procedures for inspection by attributea-Part1: Sampling schemes indexed by acceptance quality limit(AQL) for lot-by-lot inspection (ISO 2859-1:1999,IDT)

GB/T 2918-1998 Plastics--standard atmospheres for conditioning and testing (idt ISO



北京文心雕语翻译有限公司
Beijing Lancarver Translation Inc.

完整版本请在线下单

或咨询：

TEL: 400-678-1309

QQ: 19315219

Email: info@lancarver.com

<http://www.lancarver.com>

线下付款方式：

1. 对公账户：

单位名称：北京文心雕语翻译有限公司

开户行：中国工商银行北京清河镇支行

账 号：0200 1486 0900 0006 131

2. 支付宝账户：info@lancarver.com

注：付款成功后，请预留电邮，完整版本将在一个工作日内通过电子 PDF 或 Word 形式发送至您的预留邮箱，如需索取发票，下单成功后的三个工作日内安排开具并寄出，预祝合作愉快！



银联特约商户