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**50-YEAR WARRANTY**  
on JM Eagle  
Plastic Pipe  
**GUARANTEED**

**BLUE BRUTE™**

MEETS AWWA C900



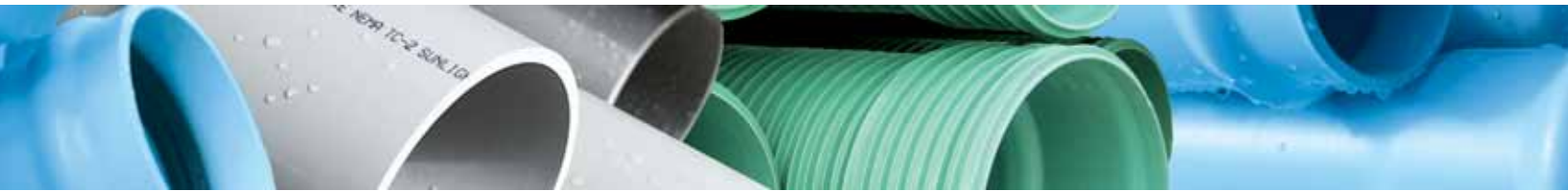
*Building essentials  
for a better tomorrow™*



## BLUE BRUTE™

PVC C.I.O.D. Distribution Pipe  
DR 25/DR18/DR14

*Pressure Class 165, 235 and 305 psi  
Ring-Tite™ Joints 4"-12"*



# BLUE BRUTE™

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# 01

## PRODUCT DESCRIPTION

### AWWA C900 BLUE BRUTE™

FOR USE IN DISTRIBUTION, MUNICIPAL WATER SYSTEMS AND OTHER SERVICES

#### DESCRIPTION

JM Eagle's Blue Brute™ pipe, produced in blue or white, conforms to the AWWA C900 specification, with gaskets meeting ASTM F477 and joints in compliance with ASTM D3139. Blue Brute™ water pipe has the long-term hydrostatic strength to meet the high safety requirements commonly needed by municipal water systems. This pipe conforms to AWWA C900-07 Pressure Class 165 psi (DR 25), 235 psi (DR 18), 305 psi (DR 14); for sizes 4"-12" in diameter.

**Note:** Please contact JM Eagle™ Sales Department for availability and locations.

#### LONG LAYING LENGTHS

The standard laying length of Blue Brute™ PVC pipe is 20 feet. This means that more ground can be covered during installation while eliminating the cost of unnecessary joints.

#### LISTING STANDARDS ANSI/NSF STANDARD 61, UL 1285, FM APPROVAL

See Short Form Specification.



#### APPLICATIONS

These products are typically used for distribution pipelines of potable water. However, this pipe may be used for gravity sewer, force main, and water reclamation projects.

#### PURPLE RECLAIM AND GREEN SEWER FORCE MAIN

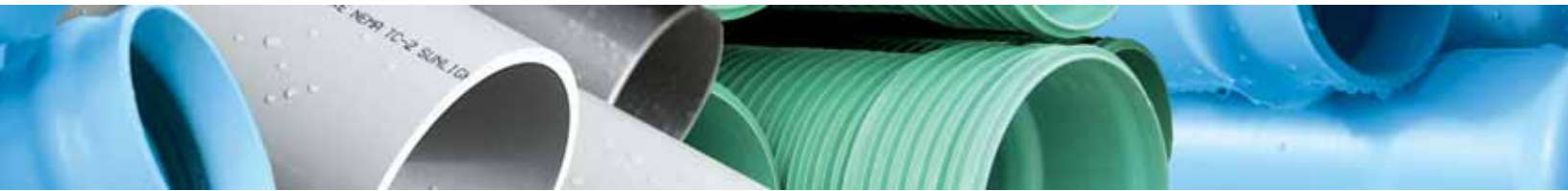
JM Eagle™ also manufactures this pipe in purple, specifically for reclaimed water systems and green for sewer force main applications. This pipe is made to the same requirements as our standard products. The only difference is that the pigment used is purple or green. These products will not be marked with UL or NSF listing marks. Additionally, the purple pipe will be marked: "Reclaimed Water... Do Not Drink" and the green pipe will be marked "Forced Sewer."

\* For lengths of 14 feet, Non-Hydrotested DR 18 Sewer Pipe is available upon request.

#### QUALITY CONTROL

Without exception, each length of pipe is hydrostatically tested and subject to inspection by our quality control inspectors throughout every step of the manufacturing process. JM Eagle's Quality Management System is ISO 9001:2000 registered.\* Copies of the registration certificates are available on our website at [www.jmeagle.com](http://www.jmeagle.com).

\* JM Eagle™ is in the process of obtaining the ISO 9001-2000 registration of Quality Management System for all locations.



### CORROSION RESISTANCE

Blue Brute™ PVC pipe is unaffected by electrolytic or galvanic corrosion, or any known corrosive soil or water conditions. You don't have to worry about tuberculation, or the need for costly lining, wrapping, coating, or cathodic protection.

### FLOW CAPACITY

This PVC water pipe has a smooth interior that stays smooth over long years of service with virtually no loss in carrying capacity. Its coefficient of flow is  $C = 150$  (Hazen & Williams) the best available in common use water systems. This capacity often allows savings in pumping costs as well as savings on the size of pipe required.

### SAVE IN HANDLING COSTS

Blue Brute™ PVC pipe is designed for installed-cost savings. Most sizes can be handled manually, so there is no need for costly installation equipment. Use the backhoe for excavating and backfilling only. Dig more trench, lay pipe faster, and save more in cost per foot installed.

### FIELD CUTTING AND BEVELING

Blue Brute™ pipe can be field cut with a power saw or ordinary handsaw. This eliminates the need to invest in costly cutting equipment. The pipe can also be beveled without the use of any expensive or complicated machinery.

### LIGHT WEIGHT

A 20 foot length of 8" DR 18 Blue Brute™ water pipe weighs approximately 184 pounds. Installers prefer it because it goes into the ground quickly—thus saving on installation costs.

### SERVICE LIFE

Because it is nonmetallic, the pipe does not lose strength due to either potable water corrosion or external galvanic soil conditions.

### INSTALLATION

This product should be installed in accordance with JM Eagle™ Publication JME-03B, "Blue Brute™, Big Blue™ and Ultra Blue™ (C900/C905/C909) Installation Guide" and "Pressure Pipe Tapping Guide."





# PRODUCT DESCRIPTION

## AWWA C900 BLUE BRUTE™

(CONTINUED)

### CAST IRON O.D.

Available in 4", 6", 8", 10", and 12" trade sizes, this pipe can be connected directly into cast/ductile iron fittings and pipe. Connections to products with other O.D. regimens can be done using commonly available adapters or transition gaskets. Dimensions should be checked for use with butterfly valves.



### RING-TITE™ JOINTS WITH LOCKED-IN GASKETS

JM Eagle's Ring-Tite™ joint can be assembled quickly. Seated in a deep groove, the flexible elastomeric Rieber® gasket provides a tight seal that protects the line from shock, vibration, earth movement and compensates for expansion and contraction of pipe lengths. There's no field mixing or application of cement. It's a simple push-together joint that remains tight under normal operating conditions.

The factory installed Rieber® gaskets provide a tight, flexible seal that resists rolling during installation. Special gasket types are available for use with certain chemical and petroleum products. Spigot pipe ends are supplied from the factory with bevels. The bell is an integral part of the pipe length with the same strength. Joints meet or exceed ASTM D3139 for joint tightness, including a 22 in. Hg vacuum for one hour, under deflection with no leakage.

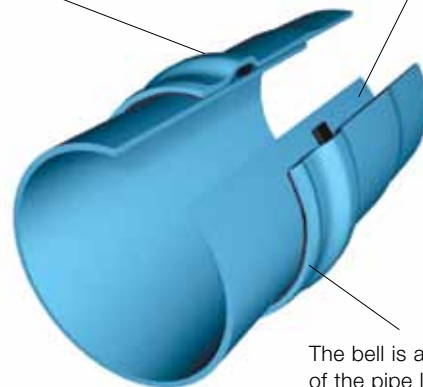
Note: Other types of gaskets may be provided. JM Eagle™ is in the process of converting all gasketed products to the Rieber® ring gasket.

\* Rieber® is a registered trademark of TI Specialty Polymer Products Inc.

### RING-TITE™ JOINT

Rieber® sealing ring provides tight, flexible seal.

Spigot pipe ends are supplied from the factory with bevels.



The bell is an integral part of the pipe length with the same strength.

### ACCESSORIES

JM Eagle's Blue Brute™ PVC pipe is compatible with all the items required for smooth installation of distribution pipelines.



## SURGE DESIGN

It is important to note that for the same conditions of interrupted flow, the surge pressures generated in pipe with high tensile moduli will be greater than the surges in low moduli (PVC) pipe of similar dimensions.

As the modulus of tensile elasticity for a piping material increases, the resultant pressure surge, or “water hammer”, caused by a change in flow velocity also increases. For example, an instantaneous 2 fps (0.6 mps) flow velocity change in an 8" water main will create surge pressures as shown in **Table 1** for different pipe materials. For all system designs, surge pressures should be examined with the pipe material in use.

**TABLE 1**

### PRESSURE SURGES IN 8 IN. WATER MAIN

In Response to 2 fps (0.6 mps) Instantaneous Flow Velocity Change.

PIPE PRODUCT	PRESSURE SURGE	
	psi	kPa
Class 50 DI Pipe	100.0	689
Class 150 AC Pipe	88.7	611
165 psi (DR 25) PVC Pipe	29.4	202

Pressure surges in PVC pipe of different dimension ratios in response to a 1 fps (0.3 mps) instantaneous flow velocity change are shown in **Table 2**.

**TABLE 2**

### DESIGN TABLE FOR PVC PIPE-PRESSURE SURGE VS. DIMENSION RATIO

In Response to 1 fps (0.3 mps) Instantaneous Flow Velocity Change.

DIMENSION RATIO	PRESSURE SURGE	
	psi	kPa
14	19.8	137
18	17.4	120
25	14.7	101

# 03

## SHORT FORM SPECIFICATION

### AWWA C900 BLUE BRUTE™

#### SCOPE

This specification designates general requirements for 4" through 12" C.I.O.D.'s pipe produced in blue or white unplasticized polyvinyl chloride (PVC) plastic pressure pipe with integral bell and spigot joints for the conveyance of water and other fluids. This pipe shall meet the requirements of AWWA Standard C900, "Polyvinyl Chloride (PVC) Water Distribution Pipe."

#### MATERIALS

All pipe shall be made from quality PVC resin, compounded to provide physical and mechanical properties that equal or exceed cell class 12454 as defined in ASTM D1784.

#### HYDROSTATIC PROOF TESTING

Each standard length of pipe is tested up to 400 psi for Pressure Class 165; 600 psi for Pressure Class 235; 800 psi for Pressure Class 305 for a minimum of 5 seconds. The integral bell shall be tested with the pipe.

#### STANDARD LAYING LENGTHS

Standard laying lengths are 20 feet for all sizes. Other lengths of 14 feet, Non-Hydrotested pipe is available upon request.

#### PIPE

Where specified as such, all pipe shall be suitable for use as pressure conduit. Provisions must be made for expansion and contraction at each joint with an elastomeric gasket. The bell shall consist of an integral wall section with a factory installed, solid cross section Rieber® or other elastomeric gasket, which meets the requirements of ASTM F477. The bell section shall be designed to be at least as hydrostatically strong as the pipe barrel and meet the requirements of AWWA C900. The joint design shall meet the requirements of ASTM D3139 under both pressure and 22 in. Hg vacuum. Sizes and dimensions shall be as shown in this specification.

Pipe installation and usage shall be in compliance with JM Eagle™ Publication JME-03B, "Blue Brute™, Big Blue™ and Ultra Blue™ C900/C905/C909 Installation Guide" and Uni-Bell® Publication UNI-PUB-08-07, "Tapping Guide for PVC Pressure Pipe."

#### QUICK BURST TEST

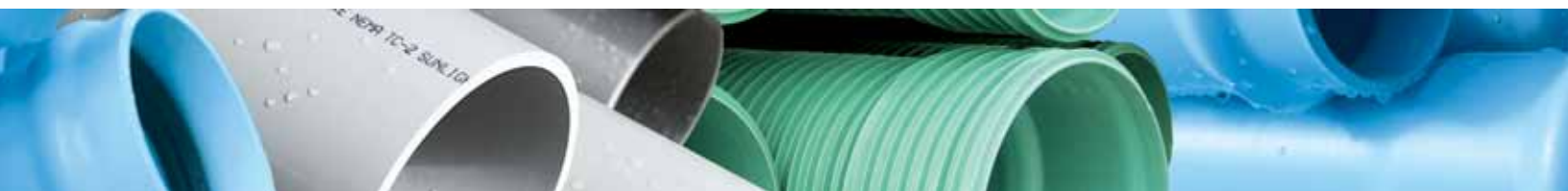
Randomly selected samples tested in accordance with AWWA C900 and UL 1285 shall withstand, without failure, the pressures listed below when applied for 60-70 seconds.

DR	PRESSURE CLASS (psi)		MINIMUM BURST PRESSURE AT 73°F (psi)
	AWWA C900-97/FM 1612	AWWA C900-07	
25	100	165	535
18	150	235	755
14	200	305	985

#### DROP IMPACT TEST

Pipe shall withstand, without failure using Tup "B" and Flat Rate Holder "B", at 73°F, a tup impact energy of 100 ft-lbf for all Pressure Class of 4"-12" trade sizes. There shall be no visible evidence of shattering or splitting when the energy is imposed.





## TESTING REQUIREMENTS PER AWWA C900

TEST	PRESSURE CLASS C900-07		
	165 psi	235 psi	305 psi
<b>LONG TERM PRESSURE TEST</b> 1000 hours (psi)	350	500	650
<b>EXTRUSION QUALITY OF PVC PIPE BY ACETONE IMMERSION TEST METHOD ASTM D2152</b>	20 min	20 min	20 min
<b>FLATTENING TEST</b> Tests extrusion quality and ductility under slow loading conditions. (Flattening Capability)	40% of OD between the plates within 2 - 5 min	40% of OD between the plates within 2 - 5 min	40% of OD between the plates within 2 - 5 min
<b>HYDROSTATIC PROOF TEST</b> (each piece) (psi)	330	470	610

## TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

PROPERTY	AWWA C900 BLUE BRUTE™ PVC PIPE	ASTM TEST METHOD
<b>Fiber Hoop Stress at 73° F</b> Minimum Short Term Bursting Strength (psi) 1,000 Hour Strength (psi) min	6400 4200	D1599 D1598
<b>Working Pressure Rating</b> 73° F (% of rating at 73° F) 80° F (% of rating at 73° F) 100° F (% of rating at 73° F)	100% 88% 62%	
<b>Chemical Resistance at 73° F</b> Acids Salts - Bases	Excellent Excellent	
<b>Physical Properties of Compound Std. Test Specimens</b> Minimum Tensile Strength (psi) at 73° F	7000	D638
<b>Thermal Expansion</b> (in / 100 ft / 50° F Change)	2"	
<b>Fire Resistance</b>	Self Extinguishing	
<b>Flame Spread</b>	10	E162
<b>Smoke Development</b>	330	E84
<b>Coefficient of Flow</b> Hazen & Williams	C = 150	
<b>Mannings N Value</b>	N = 0.009	

\* For data, sizes, or classes not reflected in these charts, please contact JM Eagle™ for assistance.



## DIMENSIONS AND WEIGHTS

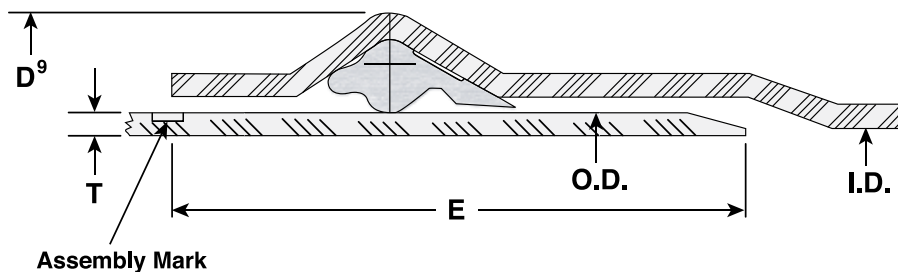
### SUBMITTAL AND DATA SHEET

PIPE SIZE (IN)	AVERAGE O.D. (IN)	NOM. I.D. (IN)	MIN. T. (IN)	MIN. E (IN)	APPROX. D <sup>9</sup> (IN)	APPROX. WEIGHT (LBS/FT)
<b>PRESSURE CLASS 165 psi (DR 25)</b>						
4	4.80	4.39	0.192	5.25	5.57	1.9
6	6.90	6.31	0.276	6.40	8.00	3.9
8	9.05	8.28	0.362	7.05	10.50	6.7
10	11.10	10.16	0.444	8.20	12.88	10.1
12	13.20	12.08	0.528	8.80	15.31	14.4
<b>PRESSURE CLASS 235 psi (DR 18)*</b>						
4	4.80	4.23	0.267	5.25	5.87	2.6
6	6.90	6.09	0.383	6.40	8.43	5.3
8	9.05	7.98	0.503	7.05	11.06	9.2
10	11.10	9.79	0.617	8.20	13.57	13.9
12	13.20	11.65	0.733	8.80	16.13	19.7
<b>PRESSURE CLASS 305 psi (DR 14)*</b>						
4	4.80	4.07	0.343	5.25	6.17	3.2
6	6.90	5.86	0.493	6.40	8.87	6.7
8	9.05	7.68	0.646	7.05	11.63	11.6
10	11.10	9.42	0.793	8.20	14.27	17.6
12	13.20	11.20	0.943	8.80	16.97	25.1

Consult JM Eagle™ for CSA and other listing availability prior to shipment.

**Note:** \*FM Approvals Pressure Class 150 psi for DR 18 and 200 psi for DR 14.

\* Contact your JM Eagle™ sales representative for location availability.



I.D. : Inside Diameter

D<sup>9</sup> : Bell Outside Diameter

O.D. : Outside Diameter

E : Distance between Assembly Mark to the end of spigot.

T : Wall Thickness

# FLOW/FRICTION CHARTS

## FLOW/FRICTION LOSS, BLUE BRUTE™ PVC PIPE

4" C.I.O.D. (AWWA C900) ACTUAL O.D. 4.80 INCH

FLOW (GAL/MIN)	DR 25 (165 psi)		DR 18 (235 psi)		DR 14 (305 psi)	
	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT
20	0.424	0.008	0.456	0.010	0.493	0.012
25	0.530	0.012	0.570	0.015	0.616	0.018
30	0.636	0.017	0.684	0.021	0.739	0.025
35	0.742	0.023	0.798	0.028	0.863	0.033
40	0.847	0.029	0.912	0.035	0.986	0.043
45	0.953	0.037	1.026	0.044	1.109	0.053
50	1.059	0.045	1.140	0.053	1.232	0.064
60	1.271	0.062	1.368	0.075	1.479	0.090
70	1.483	0.083	1.597	0.099	1.725	0.120
75	1.589	0.094	1.711	0.113	1.849	0.136
80	1.695	0.106	1.825	0.127	1.972	0.154
90	1.907	0.132	2.053	0.158	2.218	0.191
100	2.119	0.161	2.281	0.192	2.465	0.232
125	2.648	0.243	2.851	0.291	3.081	0.351
150	3.178	0.341	3.421	0.408	3.697	0.492
175	3.708	0.453	3.991	0.542	4.313	0.655
200	4.237	0.580	4.562	0.694	4.930	0.839
250	5.297	0.877	5.702	1.050	6.162	1.268
300	6.356	1.230	6.842	1.471	7.394	1.777
350	7.415	1.636	7.983	1.957	8.627	2.364
400	8.475	2.095	9.123	2.506	9.859	3.027
450	9.534	2.606	10.264	3.117	11.092	3.765
500	10.593	3.167	11.404	3.789	12.324	4.576
600	12.712	4.439	13.685	5.311	14.789	6.415
700	14.831	5.906	15.965	7.066	17.254	8.534

Based on calculation methods and design tables set forth by the Uni-Bell® PVC Pipe Association, "Handbook of PVC Pipe Design and Construction."



# FLOW/FRICTION CHARTS

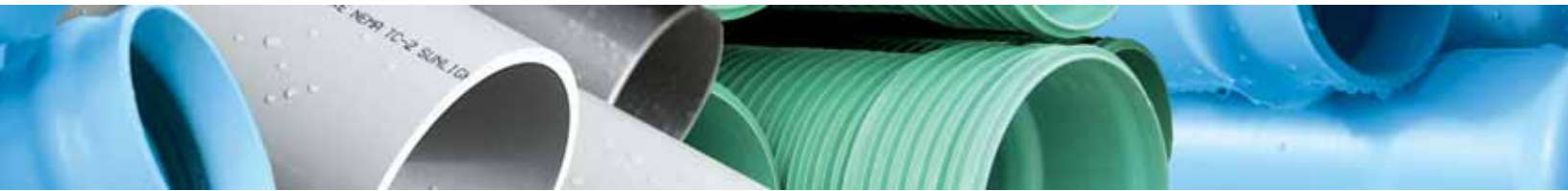
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## FLOW/FRICTION LOSS, BLUE BRUTE™ PVC PIPE

6" C.I.O.D. (AWWA C900) ACTUAL O.D. 6.90 INCH

FLOW (GAL/MIN)	DR 25 (165 psi)		DR 18 (235psi)		DR 14 (305 psi)	
	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT
50	0.513	0.008	0.552	0.009	0.596	0.011
60	0.615	0.011	0.662	0.013	0.716	0.015
70	0.718	0.014	0.772	0.017	0.835	0.021
75	0.769	0.016	0.827	0.019	0.895	0.023
80	0.820	0.018	0.882	0.022	0.954	0.026
90	0.923	0.023	0.993	0.027	1.073	0.033
100	1.025	0.027	1.103	0.033	1.193	0.040
125	1.282	0.042	1.379	0.050	1.491	0.060
150	1.538	0.058	1.655	0.070	1.789	0.084
175	1.794	0.078	1.930	0.093	2.087	0.112
200	2.051	0.099	2.206	0.119	2.385	0.143
250	2.563	0.150	2.758	0.179	2.982	0.217
300	3.076	0.210	3.309	0.251	3.578	0.304
350	3.589	0.280	3.861	0.334	4.175	0.404
400	4.101	0.358	4.412	0.428	4.771	0.518
450	4.614	0.446	4.964	0.533	5.367	0.644
500	5.126	0.542	5.516	0.647	5.964	0.783
600	6.152	0.759	6.619	0.907	7.156	1.097
700	7.177	1.010	7.722	1.207	8.349	1.460
800	8.202	1.294	8.825	1.546	9.542	1.869
1000	10.253	1.956	11.031	2.337	11.927	2.826

Based on calculation methods and design tables set forth by the Uni-Bell® PVC Pipe Association, "Handbook of PVC Pipe Design and Construction."



## FLOW/FRICTION LOSS, BLUE BRUTE™ PVC PIPE

8" C.I.O.D. (AWWA C900) ACTUAL O.D. 9.05 INCH

FLOW (GAL/MIN)	DR 25 (165 psi)		DR 18 (235 psi)		DR 14 (305 psi)	
	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT
100	0.596	0.007	0.641	0.009	0.693	0.011
125	0.745	0.011	0.802	0.013	0.866	0.016
150	0.894	0.016	0.962	0.019	1.040	0.022
200	1.192	0.027	1.283	0.032	1.386	0.038
250	1.490	0.040	1.604	0.048	1.733	0.058
300	1.788	0.056	1.924	0.067	2.079	0.081
350	2.086	0.075	2.245	0.089	2.426	0.108
400	2.384	0.096	2.566	0.115	2.772	0.138
450	2.682	0.119	2.887	0.142	3.119	0.172
500	2.980	0.145	3.207	0.173	3.466	0.209
600	3.576	0.203	3.849	0.243	4.159	0.293
700	4.172	0.270	4.490	0.323	4.852	0.390
800	4.768	0.346	5.132	0.413	5.545	0.499
1000	5.960	0.523	6.415	0.625	6.931	0.754
1200	7.152	0.732	7.698	0.876	8.317	1.057
1400	8.344	0.975	8.981	1.165	9.704	1.407
1600	9.536	1.248	10.264	1.492	11.090	1.802
2000	11.920	1.887	12.829	2.256	13.862	2.724

Based on calculation methods and design tables set forth by the Uni-Bell® PVC Pipe Association, "Handbook of PVC Pipe Design and Construction."



# FLOW/FRICTION CHARTS

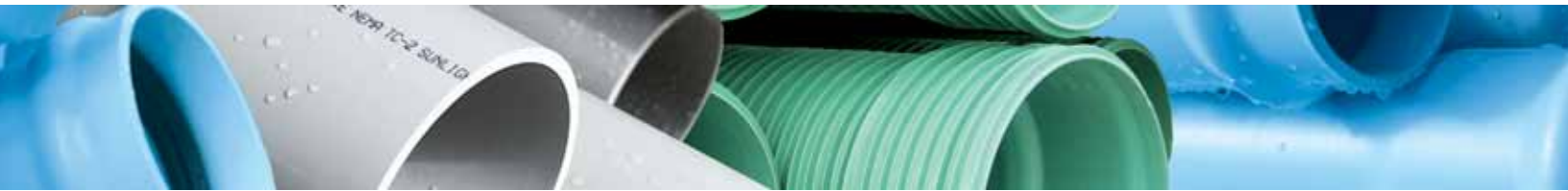
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## FLOW/FRICTION LOSS, BLUE BRUTE™ PVC PIPE

10" C.I.O.D. (AWWA C900) ACTUAL O.D. 11.10 INCH

FLOW (GAL/MIN)	DR 25 (165 psi)		DR 18 (235 psi)		DR 14 (305 psi)	
	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT
175	0.693	0.008	0.746	0.009	0.807	0.011
200	0.792	0.010	0.853	0.012	0.922	0.014
250	0.990	0.015	1.066	0.018	1.152	0.021
300	1.189	0.021	1.279	0.025	1.383	0.030
350	1.387	0.028	1.492	0.033	1.613	0.040
400	1.585	0.035	1.706	0.042	1.843	0.051
450	1.783	0.044	1.919	0.053	2.074	0.064
500	1.981	0.054	2.132	0.064	2.304	0.077
600	2.377	0.075	2.559	0.090	2.765	0.109
700	2.773	0.100	2.985	0.120	3.226	0.144
800	3.169	0.128	3.411	0.153	3.687	0.185
1000	3.962	0.194	4.264	0.231	4.609	0.280
1200	4.754	0.271	5.117	0.324	5.530	0.392
1400	5.547	0.361	5.970	0.432	6.452	0.521
1600	6.339	0.462	6.823	0.553	7.374	0.668
2000	7.924	0.699	8.528	0.835	9.217	1.009
2500	9.905	1.056	10.661	1.263	11.522	1.526
3000	11.886	1.480	12.793	1.770	13.826	2.139

Based on calculation methods and design tables set forth by the Uni-Bell® PVC Pipe Association, "Handbook of PVC Pipe Design and Construction."



## FLOW/FRICTION LOSS, BLUE BRUTE™ PVC PIPE

12" C.I.O.D. (AWWA C900) ACTUAL O.D. 13.20 INCH

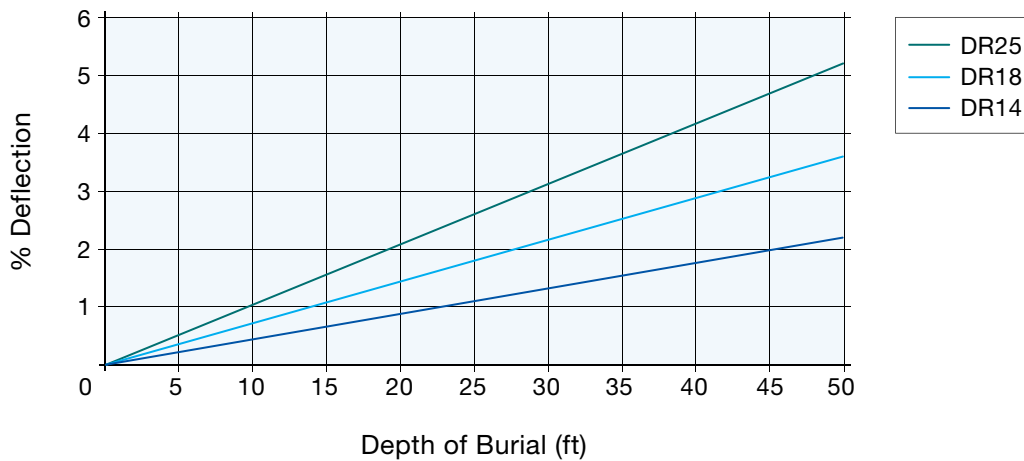
FLOW (GAL/MIN)	DR 25 (165 psi)		DR 18 (235 psi)		DR 14 (305 psi)	
	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT	VELOCITY FT/S	PRESSURE DROP psi/100 FT
300	0.840	0.009	0.904	0.011	0.978	0.013
350	0.981	0.012	1.055	0.014	1.141	0.017
400	1.121	0.015	1.206	0.018	1.304	0.022
450	1.261	0.019	1.357	0.023	1.467	0.027
500	1.401	0.023	1.507	0.028	1.629	0.033
600	1.681	0.032	1.809	0.039	1.955	0.047
700	1.961	0.043	2.110	0.051	2.281	0.062
800	2.241	0.055	2.412	0.066	2.607	0.080
1000	2.802	0.083	3.015	0.100	3.259	0.120
1200	3.362	0.117	3.617	0.140	3.911	0.169
1400	3.922	0.155	4.220	0.186	4.563	0.224
1600	4.482	0.199	4.823	0.238	5.214	0.287
2000	5.603	0.301	6.029	0.359	6.518	0.434
2500	7.004	0.455	7.536	0.543	8.147	0.657
3000	8.405	0.637	9.044	0.761	9.777	0.920
3500	9.805	0.848	10.551	1.013	11.406	1.225
4000	11.206	1.085	12.058	1.297	13.036	1.568
4500	12.607	1.350	13.565	1.613	14.665	1.950

Based on calculation methods and design tables set forth by the Uni-Bell® PVC Pipe Association, "Handbook of PVC Pipe Design and Construction."

# 06

## DEFLECTION CHART

### Blue Brute™ Deflection By Depth of Burial :: †



:: Deflections computed using a unit weight of backfill at 120 lbs/cft and assume no internal pressure or live load.

:: Pipe embedment used in calculations is Class 1, 2, 3, or 4, as defined in ASTM D2321 with appropriate compaction to achieve an  $E' = 1000$  psi.

† Based on calculation methods and design tables set forth by the Uni-Bell® PVC Pipe Association, "Handbook of PVC Pipe Design and Construction."



## SHORT FORM INSTALLATION GUIDE/ WARNING

*This information is furnished in order to provide a brief review of the installation requirements for JM Eagle™ Blue Brute™ PVC pipe. It is not intended to serve as or replace the function of the FULL VERSION product installation guide available upon request.*

1. Check to see that the gasket is properly seated in the bell groove, and that the bell and spigot are clean before assembly.
2. Apply the approved lubricant supplied with the pipe to the spigot end of the pipe, paying particular attention to the bevel. The coating should be equivalent to a brush coat of enamel paint.
3. Assemble the joint only to and not over the stop mark provided on the spigot end.
4. If undue resistance to insertion of the spigot is encountered, or the assembly mark does not reach the flush position, disassemble the joint and check the position of the rubber gasket, and remove any debris.
5. Curvature of the pipe shall be accomplished through longitudinal bending of the pipe barrel in accordance with the following table. Deflection of the joint is not allowed and may cause leakage.

PIPE SIZE (IN)	RADIUS (FT)
4	100
6	150
8	200
10	250
12	300

6. Prior to backfilling, check to see that the assembly mark is flush with the end of the bell.
7. All taps performed on JM Eagle's pressure products, shall be in accordance with Uni-Bell® Publication UNI-PUB-08-07, "Tapping Guide for PVC Pressure Pipe."

### WARNING: RUPTURE HAZARD

**IMPROPER INSTALLATION OR MISUSE OF TAPPING TOOLS MAY CAUSE PIPES UNDER HIGH PRESSURE TO RUPTURE AND RESULT IN HIGH VELOCITY AIRBORNE FRAGMENTATION LEADING TO SERIOUS INJURIES AND/OR DEATH.**

**BEFORE AND DURING INSTALLATION, ALWAYS:**

- Consult and follow the FULL VERSION of the product installation guide
- Closely follow job specifications
- Use protective gear and equipment

**BEFORE AND DURING TAPPING, ALWAYS:**

- Consult and follow Uni-Bell® Publication UNI-PUB-08-07, "Tapping Guide for PVC Pressure Pipe."
- Use the correct tapping tools
- Bleed air from pipes at high spot before tapping
- Use protective gear and equipment

Please contact JM Eagle™ Product Assurance at (800) 621-4404 to obtain FULL VERSION of the appropriate installation guide or for further assistance.



## LIMITED WARRANTY

### 1. PERIODS AND SCOPE OF COVERAGE

JM Eagle™ warrants that the pipe products certified to the standards of the American Water Works Association (AWWA) for water distribution, transmission and force sewer mains including C900, C905, C909, C901 and C906 products manufactured by JM Eagle™ (each a “Product” and collectively, the “Products”)\* are manufactured in accordance with the following AWWA, ASTM, ANSI/NSF, and UL standards as follows: (1) AWWA C900 and ASTM 1784 cell class 12454; Gaskets meet ASTM F477; Joints meet ASTM D3139; ANSI/NSF-61, UL 1285 for the C900, (2) AWWA C905 and ASTM 1784 cell class 12454; Gaskets meet ASTM F477; Joints meet ASTM D3139; ANSI/NSF-61, UL 1285 for C905, (3) AWWAC909 and UL 1285; Gaskets meet ASTM F477; Joints meet ASTM D3139 for C909 and (4) AWWA C901/906, ASTM D2239, ASTM D2737, ASTM D3035, F714, cell class per ASTM D3350, PPI listed material (TR-4) PE3408/3608 & PE4710, ASNI/NSF-14 for C901 and C906. JM Eagle™ warrants that each of these Products manufactured by JM Eagle™ leaves our plant free from defects in workmanship and materials. These Products as manufactured by JM Eagle™ are backed by our unprecedented fifty (50) year Limited Warranty. This Limited Warranty provides that Products manufactured by JM Eagle™ meet the above stated quality standards published by the AWWA, ASTM International (ASTM), American National Standards Institute/NSF International (ANSI/NSF), and Underwriters Laboratories (UL).

If any Product is determined within fifty (50) years from the date of invoice by JM Eagle™ to be defective because it failed to meet the above stated standards, JM Eagle™ will then provide replacement product of the same type, size and quantity of the product and pay for the costs directly related to its replacement\*\*\* or issue credits, offsets or a combination thereof for the wholesale purchase price of the defective product.

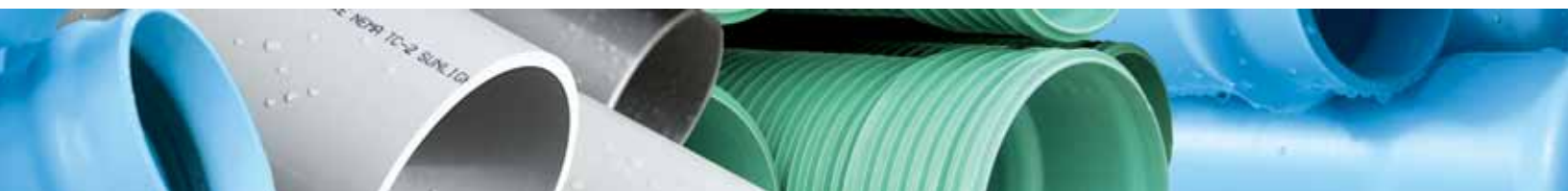
JM Eagle™ also warrants that the design of our Products are independently tested and/or certified by AWWA, NSF and UL to meet their respective standards and that our plants manufacturing the Products are already certified or in process of being certified to ISO 9001 certification\*\* as part of our program to develop manufacturing processes that consistently produce high quality plastic pipe.

JM Eagle™ quality control programs encompass three critical aspects of the manufacturing process: the incoming raw material, pipe production, and the finished goods.

### 2. EXCLUSIONS FROM COVERAGE AND EXCLUSIVE REMEDY:

Products manufactured by JM Eagle™ are marked with JM Eagle, PW Eagle or US Poly stencil markings. This limited warranty excludes any Product not manufactured by JM Eagle™, even if it is sold by JM Eagle™, and also excludes defects or failures caused after shipment by:

- improper installation (including, without limitation, misalignment),
- use in improper applications or conditions or in conjunction with improper materials (including, without limitation, improper lubricants, pastes, solvents or sealants),
- contact with aggressive chemical agents, freezing or overheating of liquids in the Product, or unusual pressure surges or pulsation,
- vibration,
- temperature shocking,
- U.V. degradation,
- failure to adhere to JM Eagle™’s instructions concerning the proper handling, installation, testing and use of the Product,
- failure to adhere to applicable standards set forth by local laws, codes, or regulations and the applicable industry standards, or
- any other improper activities not listed above or damage caused by the fault or negligence of anyone other than JM Eagle™.



THE WARRANTIES IN THIS LIMITED WARRANTY ARE THE ONLY WARRANTIES APPLICABLE TO THE PRODUCTS. THERE ARE NO OTHER WARRANTIES, REPRESENTATIONS OR CONDITIONS OF ANY KIND, EXPRESS OR IMPLIED, STATUTORY OR OTHERWISE, WITH RESPECT TO THE PRODUCTS SUPPLIED HEREUNDER INCLUDING, WITHOUT LIMITATION, ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. ALL SUCH WARRANTIES ARE HEREBY SPECIFICALLY DISCLAIMED AND JM EAGLE™ SHALL NOT BE LIABLE IN THIS RESPECT NOTWITHSTANDING JM EAGLE'S™ ACTUAL KNOWLEDGE OF THE PRODUCT'S INTENDED USE OR ANY ADVICE OR REPRESENTATIONS THAT MAY HAVE BEEN RENDERED BY JM EAGLE™ CONCERNING THE DESIGN, MANUFACTURE, FABRICATION, SALE, USE, INSTALLATION OR PROVISION OF THE PRODUCTS. NO STATEMENT, CONDUCT OR DESCRIPTION BY JM EAGLE™ OR ITS REPRESENTATIVES, IN ADDITION TO OR BEYOND THIS LIMITED WARRANTY, SHALL CONSTITUTE A WARRANTY.

BUYER AGREES THAT ITS SOLE AND EXCLUSIVE REMEDY FOR BREACH OF THIS LIMITED WARRANTY, AND THE SOLE AND EXCLUSIVE OBLIGATION OF JM EAGLE™ IN RESPECT OF ANY CLAIMS FOR BREACH OF THIS LIMITED WARRANTY, SHALL BE (1) THE REPLACEMENT OF THE SAME TYPE, SIZE AND LIKE QUANTITY OF NON-DEFECTIVE PRODUCT, AT THE ORIGINAL POINT OF DELIVERY AND COSTS RELATED TO ITS REPLACEMENT\*\*\*, OR (2) CREDITS, OFFSETS, OR A COMBINATION THEREOF, FOR THE WHOLESALE PURCHASE PRICE OF THE DEFECTIVE PRODUCT. IN NO EVENT SHALL JM EAGLE™ BE LIABLE FOR LOST PROFITS, LOSS OF GOODWILL, LOSS OF BUSINESS OPPORTUNITIES, DAMAGE TO REPUTATION, SPECIAL DAMAGES, INDIRECT DAMAGES, DELAY DAMAGES, PUNITIVE DAMAGES, EXEMPLARY DAMAGES, CONSEQUENTIAL DAMAGES OR INCIDENTAL DAMAGES.

### **3. REQUIREMENTS FOR MAKING CLAIMS:**

Every claim for breach under this warranty shall be void unless it is made in writing to JM Eagle™ and postmarked within five business (5) days of the date the defect was discovered or in the exercise of ordinary care should have been discovered and, in any event, the claim must also be made within fifty (50) years of the date of the JM Eagle™ invoice. As noted above, Products manufactured by JM Eagle™ are marked with a JM Eagle, PW Eagle or US Polystencil. This limited warranty excludes any Product not manufactured by JM Eagle™, even if it is sold by JM Eagle™ .

Any claim for breach of warranty must be sent to:

PRODUCT ASSURANCE DEPARTMENT  
JM EAGLE  
5200 W. CENTURY BOULEVARD  
LOS ANGELES, CA, 90045

For questions regarding claims, the Product Assurance Department may be also contacted at 1-800-621-4404 or JMWebSupport1@jmeagle.com.

No claim under this limited warranty will be valid unless (1) proof of purchase with the date thereof as well as a description of the alleged defect in reasonable detail is presented to the satisfaction of JM Eagle™, (2) written permission and/or a Return Goods Authorization (RGA) is obtained from JM Eagle™, (3) JM Eagle™ is given a meaningful and reasonable opportunity to inspect the allegedly defective Product and its installation at the site and (4) at JM Eagle™'s request, representative samples of the allegedly defective Product are returned to JM Eagle™ in accordance with JM Eagle™'s instructions.

\* Products covered by this Limited Warranty include similar PW Eagle and US Poly products manufactured by JM Eagle after July 1, 2007.

\*\* JM Eagle's Conroe Texas plant in the process of obtaining ISO 9001 certification. The other plants are already certified to ISO 9001.

\*\*\* Replacement costs shall be reasonable and based on industry standard cost parameters such as those listed in the RS Means Assemblies Cost Data Book.



# EXTENDED WARRANTY

## NOTICE OF RETROACTIVE EXTENSION OF LIMITED WARRANTY

Pipe certified to the standards of the American Water Works Association (AWWA) for water distribution, transmission and force sewer mains including C900, C905, C909, C901 and C906 products manufactured by JM Eagle™ (hereinafter “Products”)\* are now backed by our unprecedented fifty (50) year limited warranty. (See [www.jmeagle.com](http://www.jmeagle.com) for full details). JM Eagle™ is proud to announce that it is so confident in the quality of its products, that effective April 1, 2010, it will retroactively extend similar warranty protection for Product manufacturing defect failures. For any Products manufactured by JM Eagle™ and purchased from JM Eagle™ since December 1, 1982, JM Eagle™ will retroactively extend fifty (50) year warranty protection for any manufacturing defect that causes failure on or after April 1, 2010. As set forth in detail below, to be eligible for this retroactive extension, the Products need only have been manufactured by JM Eagle™, contain the original stencil markings, have been purchased since December 1, 1982, and failed on or after April 1, 2010. The fifty (50) year retroactive extended warranty will begin to run on the date of invoice for purchase from JM Eagle™ and will expire fifty (50) years from that date.

## EXTENDED RETROACTIVE LIMITED WARRANTY

### 1. PERIODS AND SCOPE OF COVERAGE

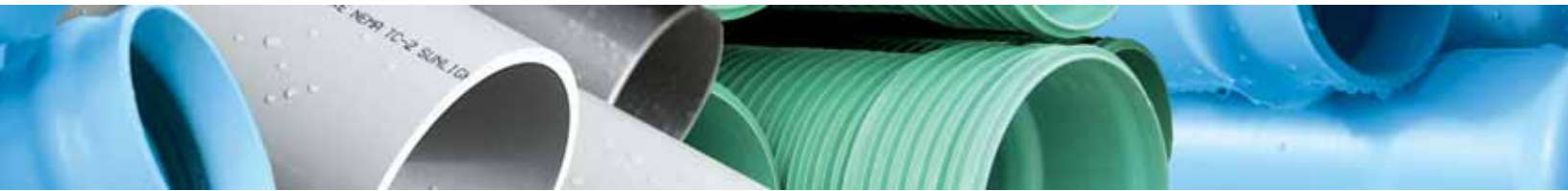
JM Eagle™ warrants through this retroactive extension of Limited Warranty that its pipe products certified to the standards of the American Water Works Association for water distribution, transmission and force sewer mains including C900, C905, C909, C901 and C906 products manufactured by JM Eagle™ (each a “Product” and collectively, the “Products”)\* were manufactured in accordance with any of the following AWWA, ASTM, ANSI/NSF, and UL standards then in existence as follows: (1) AWWA C900 and ASTM 1784 cell class 12454; Gaskets meet ASTM F477; Joints meet ASTM D3139; ANSI/NSF-61, UL 1285 for the C900, (2) AWWA C905 and ASTM 1784 cell class 12454; Gaskets meet ASTM F477; Joints meet ASTM D3139; ANSI/NSF-61, UL 1285 for C905, (3) AWWA C909 and UL 1285; Gaskets meet ASTM F477; Joints meet ASTM D3139 for C909 and (4) AWWA C901/906, ASTM D2239, ASTM D2737, ASTM D3035, F714, cell class per ASTM D3350, PPI listed material (TR-4) PE3408/3608 & PE4710, ANSI/NSF-14 for C901 and C906. JM Eagle™ warrants that each of these Products manufactured by JM Eagle™ left our plant free from defects in workmanship and materials. These Products as manufactured by JM Eagle™ are retroactively backed by our extended, unprecedented fifty (50) year Limited Warranty. This Limited Warranty provides that Products manufactured by JM Eagle™ met the applicable then-existing quality standards stated above and that are published by the AWWA, ASTM International (ASTM), American National Standards Institute/ NSF International (ANSI/NSF) and Underwriters Laboratories (UL).

If any Product fails after April 1, 2010 and is determined within fifty (50) years from the date of invoice by JM Eagle™ to be defective because it failed to meet the above stated standards, JM Eagle™ will then provide replacement product of the same type, size and quantity of the product and costs related to this replacement\*\* or issue credits, offsets or a combination thereof for the wholesale purchase price of the defective product.

### 2. EXCLUSIONS FROM COVERAGE AND EXCLUSIVE REMEDY:

Products manufactured by JM Eagle™ are marked with JM Eagle, PW Eagle or US Poly stencil markings. This limited warranty excludes any Product not manufactured by JM Eagle™, even if it is sold by JM Eagle™, and also excludes defects or failures caused after shipment by:

- improper installation (including, without limitation, misalignment),
- use in improper applications or conditions or in conjunction with improper materials (including, without limitation, improper lubricants, pastes, solvents or sealants),
- contact with aggressive chemical agents, freezing or overheating of liquids in the Product, or unusual pressure surges or pulsation,



- vibration,
- temperature shocking,
- U.V. degradation,
- failure to adhere to JM Eagle™'s instructions concerning the proper handling, installation, testing and use of the Product,
- failure to adhere to applicable standards set forth by local laws, codes, or regulations and the applicable industry standards, or
- any other improper activities not listed above or damage caused by the fault or negligence of anyone other than JM Eagle™ .

THE WARRANTIES IN THIS LIMITED WARRANTY ARE THE ONLY WARRANTIES APPLICABLE TO THE PRODUCTS. THERE ARE NO OTHER WARRANTIES, REPRESENTATIONS OR CONDITIONS OF ANY KIND, EXPRESS OR IMPLIED, STATUTORY OR OTHERWISE, WITH RESPECT TO THE PRODUCTS SUPPLIED HEREUNDER INCLUDING, WITHOUT LIMITATION, ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. ALL SUCH WARRANTIES ARE HEREBY SPECIFICALLY DISCLAIMED AND JM EAGLE™ SHALL NOT BE LIABLE IN THIS RESPECT NOTWITHSTANDING JM EAGLE™'S ACTUAL KNOWLEDGE OF THE PRODUCT'S INTENDED USE OR ANY ADVICE OR REPRESENTATIONS THAT MAY HAVE BEEN RENDERED BY JM EAGLE™ CONCERNING THE DESIGN, MANUFACTURE, FABRICATION, SALE, USE, INSTALLATION OR PROVISION OF THE PRODUCTS. NO STATEMENT, CONDUCT OR DESCRIPTION BY JM EAGLE™ OR ITS REPRESENTATIVES, IN ADDITION TO OR BEYOND THIS LIMITED WARRANTY, SHALL CONSTITUTE A WARRANTY.

BUYER AGREES THAT ITS SOLE AND EXCLUSIVE REMEDY FOR BREACH OF THIS LIMITED WARRANTY, AND THE SOLE AND EXCLUSIVE OBLIGATION OF JM EAGLE™ IN RESPECT OF ANY CLAIMS FOR BREACH OF THIS LIMITED WARRANTY, SHALL BE, (1) THE REPLACEMENT OF THE SAME TYPE, SIZE AND LIKE QUANTITY OF NON-DEFECTIVE PRODUCT, AT THE ORIGINAL POINT OF DELIVERY, AND COSTS DIRECTLY RELATED TO THIS REPLACEMENT\*\*\*, OR (2) CREDITS, OFFSETS, OR A COMBINATION THEREOF, FOR THE WHOLESALE PURCHASE PRICE OF THE DEFECTIVE PRODUCT. IN NO EVENT SHALL JM EAGLE™ BE LIABLE FOR LOST PROFITS, LOSS OF GOODWILL, LOSS OF BUSINESS OPPORTUNITIES, DAMAGE TO REPUTATION, SPECIAL DAMAGES, INDIRECT DAMAGES, DELAY DAMAGES, PUNITIVE DAMAGES, EXEMPLARY DAMAGES, CONSEQUENTIAL DAMAGES OR INCIDENTAL DAMAGES.

### 3. REQUIREMENTS FOR MAKING CLAIMS:

Every claim for breach under this warranty shall be void unless it is made in writing to JM Eagle™ and postmarked within five business (5) days of the date the defect was discovered or in the exercise of ordinary care should have been discovered and, in any event, the claim must also be made within fifty (50) years of the date of the JM Eagle™ invoice. As noted above, Products manufactured by JM Eagle™ are marked with JM Eagle™, PW Eagle or US Poly stencils. This limited warranty excludes any Product not manufactured by JM Eagle™, even if it is sold by JM Eagle™ .

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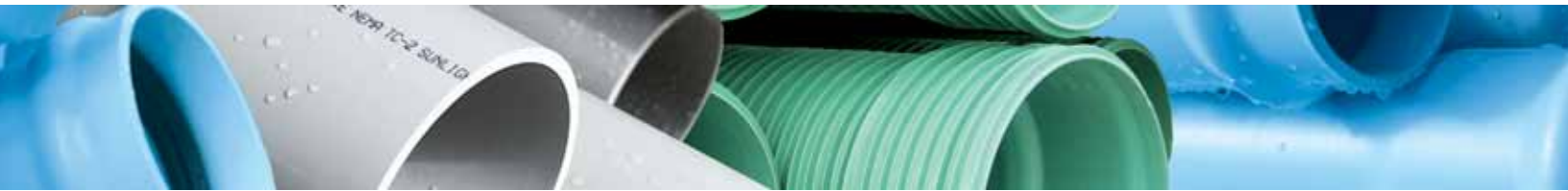
PRODUCT ASSURANCE DEPARTMENT  
JM EAGLE  
5200 W. CENTURY BOULEVARD  
LOS ANGELES, CA, 90045

For questions regarding claims, the Product Assurance Department may be also contacted at 1-800-621-4404 or JMWebSupport1@jmeagle.com.

No claim under this limited warranty will be valid unless (1) proof of purchase with the date thereof as well as a description of the alleged defect in reasonable detail is presented to the satisfaction of JM Eagle™, (2) written permission and/or a Return Goods Authorization (RGA) is obtained from JM Eagle™, (3) JM Eagle™ is given a meaningful and reasonable opportunity to inspect the allegedly defective Product and its installation at the site and (4) at JM Eagle™'s request, representative samples of the allegedly defective Product are returned to JM Eagle™ in accordance with JM Eagle™'s instructions.

\* Products covered by this Limited Warranty include similar PW Eagle and US Poly products manufactured by JM Eagle after July 1, 2007.  
\*\* JM Eagle's Conroe Texas plant in the process of obtaining ISO 9001 certification. The other plants are already certified to ISO 9001.  
\*\*\* Replacement costs shall be reasonable and based on industry standard cost parameters such as those listed in the RS Means Assemblies Cost Data Book.





# PLANT LOCATIONS

## **ADEL**

2101 J-M Drive  
Adel, Georgia 31620

## **BATCHELOR**

2894 Marion Monk Road  
Batchelor, Louisiana 70715

## **BUTNER**

2602 West Lyon Station Road  
Creedmoor, North Carolina 27522

## **CAMERON PARK**

3500 Robin Lane  
Cameron Park, California 95682

## **COLUMBIA**

6500 North Brown Station Road  
Columbia, Missouri 65202

## **CONROE**

101 East Avenue M  
Conroe, Texas 77301

## **FONTANA**

10990 Hemlock Avenue  
Fontana, California 92337

## **HASTINGS**

146 North Maple Avenue  
Hastings, Nebraska 68901

## **KINGMAN**

4620 Olympic Way  
Kingman, Arizona 86401

## **MAGNOLIA**

2220 Duracrete Drive  
Magnolia, Arkansas 71753

## **MCNARY**

31240 Roxbury Road  
Umatilla, Oregon 97882

## **MEADVILLE**

15661 Delano Road  
Cochranton, Pennsylvania 16314

## **PERRIS**

23711 Rider Street  
Perris, California 92570

## **PUEBLO**

1742 E. Platteville Boulevard  
Pueblo West, Colorado 81007

## **STOCKTON**

1051 Sperry Road  
Stockton, California 95206

## **SUNNYSIDE**

1820 South First Street  
Sunnyside, Washington 98944

## **TACOMA**

2330 Port of Tacoma Road  
Tacoma, Washington 98421

## **TULSA**

4501 West 49th Street  
Tulsa, Oklahoma 74107

## **VISALIA**

8875 Avenue 304  
Visalia, California 93291

## **WHARTON**

10807 US 59 RD  
Wharton, Texas 77488

## **WILTON**

1314 W. Third Street  
Wilton, Iowa 52778

## **MEXICO**

PLASTICS TECHNOLOGY  
DE MÉXICO S DE R.L. DE S.A.  
Av. Montes Urales No. 8 y 10  
Parque Industrial Opción, Carretera  
57 Qro. -S.L.P. Km. 57.8  
C.P. 37980 San José Iturbide,  
Guanajuato México

*\* Our Mexico location is a joint  
venture between JM Eagle™ and  
Plastics Technology*

## **GLOBAL HEADQUARTERS**

5200 West Century Boulevard  
Los Angeles, California 90045

## **REGIONAL OFFICE**

Nine Peach Tree Hill Road  
Livingston, New Jersey 07039

**J-M Manufacturing Co., Inc. and PW Eagle, Inc. are doing business as JM Eagle™.**

# JM Eagle

- THE LEADER IN PIPE INNOVATION
- THE HIGHEST LEVEL OF QUALITY
- THE LARGEST BREADTH OF PRODUCT
- THE WIDEST CAPACITY
- EXPRESS DELIVERY



## PLANT LOCATIONS

Revised May 2010  
JME-02A  
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*Building essentials  
for a better tomorrow™*

### GLOBAL HEADQUARTERS:

5200 West Century Blvd  
Los Angeles, CA 90045  
T: 800.621.4404  
F: 800.451.4170

[www.JMEagle.com](http://www.JMEagle.com)

### REGIONAL OFFICE:

Nine Peach Tree Hill Road  
Livingston, NJ 07039  
T: 973.535.1633  
F: 973.533.4185