



WL PLASTICS
An INEOS Business

Camcore™ IPS Specification



Sewer & Reclaimed Water

The ideal piping solution

Camcore™ IPS Specification

High density polyethylene for sewer and waste water pipe collection

A. Camcore™

Produced from High Density Polyethylene (HDPE) PE 4710 materials, Camcore™ pipe is designed for sewer and waste water pipe collection services. Camcore™ is currently manufactured in nominal diameters 4 inch through 18 inch in Iron Pipe Sizes (IPS). Camcore™ conforms to AWWA C906 and ASTM D3035 standards. It is pressure rated in accordance to the Plastics Pipe Institute (PPI) TR 3 policies and procedures.

Camcore™ pipe enhances video inspection and lateral tap locating by utilizing a coextruded light color interior surface. This polyethylene pipe contains a light grey interior surface

which is considered the standard for sewer and water collection applications in both rural and municipal water systems. Also external striping colors are available to identify specific usages such as non-potable water, grey water, reclaimed water, waste water, force main and gravity municipal sewage, etc. Camcore™ HDPE is chemical and corrosion resistant pipe, especially against hydrogen sulfide attack, oxidation and tuberculation. In comparison to solid wall grey HDPE pipe, Camcore™ has indefinite outdoor storage life due to carbon black's resistance to UV degradation. Where as solid grey competitive products do not. It also has a higher density allowing for greater abrasion resistance and pull strength. Camcore™ is an excellent choice for sewer and waste water infrastructure pipe applications.

Working pressure classes for Camcore™ IPS

IPS size	Average OD, in	Pressure class	PC250	PC200	PC150	PC125	PC100
		SDR	9	11	13.5	17	21
4	4.50	Min. Wall	0.500	0.409	0.333	0.265	0.214
		Avg. ID	3.440	3.633	3.793	3.939	4.046
		lbs/ft	2.720	2.275	1.887	1.526	1.247
6	6.625	Min. Wall	0.736	0.602	0.491	0.390	0.315
		Avg. ID	5.064	5.348	5.585	5.799	5.956
		lbs/ft	5.894	4.930	4.095	3.307	2.703
8	8.625	Min. Wall	0.958	0.784	0.639	0.507	0.411
		Avg. ID	6.593	6.963	7.271	7.549	7.754
		lbs/ft	9.988	8.359	6.939	5.597	4.591
10	10.750	Min. Wall	1.194	0.977	0.796	0.632	0.512
		Avg. ID	8.218	8.678	9.062	9.409	9.665
		lbs/ft	15.515	12.983	10.774	8.695	7.128
12	12.750	Min. Wall	1.417	1.159	0.944	0.750	0.607
		Avg. ID	9.747	10.293	10.748	11.160	11.463
		lbs/ft	21.837	18.267	15.155	12.238	10.023
14	14	Min. Wall	1.556	1.273	1.037	0.824	0.667
		Avg ID	10.702	11.302	11.801	12.254	12.587
		lb/ft	26.329	22.030	18.279	14.763	12.093
16	16	Min. Wall	1.778	1.455	1.185	0.941	0.762
		Avg ID	12.231	12.916	13.487	14.005	14.385
		lb/ft	34.384	28.777	23.872	19.269	15.789
18	18.00	Min. Wall	2.000	1.636	1.333	1.059	0.857
		Avg ID	13.760	14.531	15.173	15.755	16.183
		lb/ft	43.513	36.403	30.210	24.395	19.977

Note: For evaluated temperatures greater than 73° F refer to WL118

B. Pipe material

Camcore™ pipe is produced from the highest rated HDPE pipe materials. This is a long lasting, fusible pipe. Camcore™ HDPE materials are listed in Plastics Pipe Institutes (PPI) Technical Report 4 (TR-4) (ref: plasticpipe.org/Publications/technical-reports.html)

Camcore™ is classified under ASTM D3350 as a Type III, Class PE445574C/E, Grade PE47 Camcore™ is also classified under ASTM D1248 as a Type III, Class D, Category 5, Grade E10 or E11.

C. Camcore™ advantages

- Leak-free piping
- Video surveillance enhancement
- Durable
- Fatigue free
- Chemical resistance
- UV protected
- Lateral tap locating
- Impact resistant
- Does NOT support biological growth
- Environmentally friendly
- Flexible
- Excellent for trenchless piping system installations
- Fusion condition compatibility
- Surge resistant
- Fusible pipe

Camcore™ ASTM D3350 cell classification of PE445574C/E

	Property	Standard	Typical value
Class	Cell classification	ASTM D3350	445574C/E (black/gray)
4	Density	ASTM D1505	0.960 g/cc (black/gray)
4	Melt index	ASTM D1238	0.1 g/10 m
5	Flexural modulus	ASTM D790	>110,000 <160,000 psi
5	Tensile strength	ASTM D638	>3500 psi
7	SCG (PENT)	ASTM F1473	>500 hours
4	HDB @73F	ASTM D2837	1600 psi
C/E	Color; UV stabilizer	ASTM D3350	Carbon black/color w/UV stabilizer

Note: PPI TR-4 Hydrostatic Design Stress (HDS), Strength Design Basis (SDB), Pressure Design Basis (PDB) and Minimum Required Strength (MRS) Ratings for Thermoplastic Piping Materials or Pipe

D. Pipe fusion

It is recommended that HDPE pipe fusion in accordance to ASTM F2620, PPI TR-33, and pipe and fittings manufacturing recommendations (Ref: WL101). Mechanical joining procedures supplied by fittings manufacture(s). Camcore™ is manufactured to ASTM D3035 which contains tighter OD tolerances than ASTM F714 for improved electro-fusion compatibilities. It also meets and exceeds ASTM F714 requirements.

E. Pipe installation of HDPE plastic pipe

Installations follow manufacturing recommendations and applicable to ASTM D2774, D2657, F2620, D2683, D3261, F1055, AWWA C901 or C906, AWWA M55, and/or WL101 and WL113.



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Manufacturing locations

- Bowie, TX
- Casper, WY
- Cedar City, UT
- Elizabethtown, KY
- Lubbock, TX (HDPE)
- Lubbock, TX (MDPE)
- Rapid City, SD
- Snyder, TX
- Statesboro, GA
- Titusville, PA (HDPE/MDPE)

Corporate office

3575 Lone Star Circle, Suite 300,
Fort Worth, TX, 76177

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