

HAPAS

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HAPAS Certificate

07/H130

Product Sheet 2 Issue 2

CHERRY TWINWALL HIGHWAY DRAINAGE SYSTEM

CHERRY TWINWALL FITTINGS

This Product Sheet⁽¹⁾ is issued by the British Board of Agrément (BBA). The Highways Authorities Product Approval Scheme (HAPAS) is supported by National Highways (NH) (acting on behalf of the Overseeing Organisations of the Department for Transport; Transport Scotland; the Welsh Government; and the Department for Infrastructure, Northern Ireland), the Association of Directors of Environment, Economy, Planning and Transport (ADEPT), the Local Government Technical Advisers Group and industry bodies.

(1) Hereinafter referred to as 'Certificate'.

This Certificate relates to Cherry Twinwall Fittings, ranging from 150 to 600 mm diameter, for use in non-pressure underground highway drainage systems, for the collection and disposal of surface and sub-surface water, in accordance with the *Manual of Contract Documents for Highway Works* (MCHW), Volumes 1 and 2.



The BBA has awarded this Certificate to the company named above for the products described herein. These products have been assessed as complying with the requirements of the BBA HAPAS Certification Scheme according to the assessments set out in this Certificate.

On behalf of the British Board of Agrément

Date of Second issue: 27 June 2023

Originally certificated on 26 April 2022

Hardy Giesler
Chief Executive Officer

This BBA HAPAS Certificate is issued under the BBA's accreditation to ISO/IEC 17065 (UKAS accredited Certification Body Number 0113).

Clauses marked † are additional information outside the scope of accreditation.

Readers MUST check the validity and latest issue number of this BBA HAPAS Certificate by referring to the BBA website or contacting the BBA directly.

The Certificate should be read in full as it may be misleading to read clauses in isolation.

Any photographs are for illustrative purposes only, do not constitute advice and should not be relied upon.

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1 Production Description

1.1 The Certificate holder specifies the products under assessment, Cherry Twinwall Fittings, for use in conjunction with Cherry Twinwall Pipes and Couplers (the subject of Product Sheet 1 of this Certificate), in non-pressure underground highway drainage systems, for the collection and disposal of surface and sub-surface water, in accordance with the *Manual of Contract Documents for Highway Works* (MCHW), Volumes 1 and 2.

1.2 Cherry Twinwall Fittings comprise a range of 150 to 600 mm diameter (nominal size DN 150, 225, 300, 375, 450, 600) fittings, to the material specifications given in Table 1 and range in Table 2:

- Rotational moulded (RM) fittings — manufactured from black recycled high-density polyethylene (HDPE)
- Fabricated (F) fittings — manufactured from HDPE pipes and PE and polypropylene couplers to material specifications as detailed in Product Sheet 1 of this Certificate.

Table 1 Material characteristics

Product	Fittings
Manufacturing process	Rotationally moulded
Dimensions (mm)	150 to 600
Material	PE
Test method	Specification
Tensile properties BS EN ISO 527-2 : 2012	Sample 1B at 50 mm·min ⁻¹ ≥ 18 MPa
Thermal stability (OIT) BS EN 728 : 1997	≥ 4 min
Melt mass-flow rate BS EN ISO 1133-1 : 2011	≤ 0.75 g (10 min) ⁻¹ 2.16 kg at 190 °C
Reference density BS EN ISO 1183-1 : 2012	≥ 935 kg·m ⁻³

Table 2 Fitting range

	Nominal size	150	225	300	375	450	600
Bends 15°, 30°, 45° and 90°		RM	RM	RM	F	RM	F
Equal swept branches 45°(Y) and 90°(T)		RM	RM	RM	F	F	F
	150		RM	RM	F	F	F
	225			RM	F	F	F
Unequal branches					F	F	F
45°(Y) and 90°(T)	300					F	F
	375					F	F
	450						F
Reducers	225	RM					
	300	RM	RM				
	375	RM	RM	RM			
	450	RM	RM	RM	F		
	600	RM	RM	RM	RM	RM	
End caps		RM	RM	RM	RM	RM	RM
Female adaptor	160	RM					

1.3 Sealing of the joints requires rubber sealing rings supplied by Certificate holder. The seals are manufactured from ethylene propylene diene monomer (EPDM) to BS EN 681-1 : 1996, Type WC.

1.4 Product codes follow the pattern:

- Bend eg TB15015, where 150 is the nominal size of bend and 15, its angle
- Branch eg TT150-150, and TY150-150, where 150 is the nominal size of each branch, T (for equal branches) is for 90° and Y (for unequal branches) for 45° angles
- Reducer eg TR225-150, where 225 and 150 are the nominal sizes of each end of the reducer
- End cap eg TE150 where 150 is the nominal size of end cap
- Female adaptor TA150-160, where 150 and 160 are the nominal sizes of each end of the adaptor.

1.5 Cherry Twinwall Fittings comply with the requirements of the MCHW, Volume 1, Clause 518.6 for the fittings, and Clause 518.7 for the system. When installed in accordance with the recommendations given in this Certificate, the products are suitable for use in highway drainage systems for the collection and disposal of surface and sub-surface water.

2 Requirements

Requirements for the products are outlined in the BBA HAPAS Certification Scheme Document and have been established from the following specification documents.

- the MCHW⁽¹⁾, Volume 1, Series 500
- the MCHW, Volume 2, Series NG 500.

(1) The MCHW is operated by National Highways (NH) (acting on behalf of the Overseeing Organisations of the Department for Transport; Transport Scotland; the Welsh Government; and the Department for Infrastructure, Northern Ireland).

3 Summary of Product Assessment

The products were assessed on the basis of the following characteristics in accordance with HAPAS requirements.

3.1 Mechanical resistance and stability

3.1.1 Mechanical properties

Table 3 Characteristics for mechanical properties

Product assessed	Assessment method	Requirement	Outcome
Fittings	Impact resistance to BS EN ISO 13263 : 2017	DN < 300, no damage DN ≥ 300, may fail and must be identified as 'handle with care'	Pass

The assessment showed that the products comply with HAPAS requirements for this.

3.1.2 Performance of joints

Table 4 Characteristics for performance of joints

Product assessed	Assessment method	Requirement	Outcome
Fittings	Dimensions to BS ISO 11922-1 : 2018	As per drawings	Pass
System (Pipe, fitting, seal)	Tightness of joints to BS EN ISO 13259 : 2018	No leakage	Pass
Fabricated fittings	Watertightness to BS EN ISO 13254 : 2017	No leakage	Pass

The assessment showed that the products comply with HAPAS requirements for this characteristic.

3.1.3 Strength and stability

Table 5 Characteristics for strength and stability

Product assessed	Assessment method	Requirement	Outcome
Fittings	Ring stiffness to BS EN ISO 13967 : 2009	≥ 6 kN·m ⁻²	Pass
Fabricated fittings	Strength and flexibility to BS EN ISO 13264 : 2017	No leakage	Pass

The assessment showed that the products comply with HAPAS requirements for this characteristic.

3.2 Sustainable use of natural resources

The product is manufactured from polyethylene and polypropylene, which can be recycled.

3.3 Durability

Table 6 Characteristics for durability

Product assessed	Assessment method	Requirement	Outcome
Fittings	Ring stiffness to BS EN ISO 13967 : 2009	$\geq 6 \text{ kN}\cdot\text{m}^{-2}$	Value achieved
	Resistance to heating to BS EN ISO 580 : 2005	Depth of cracks, delamination or blisters less than 20 % of the wall thickness around the injection point(s). No part of the weld line to open to a depth of more than 20 % of the wall thickness	Pass
Fittings material	Resistance to chemicals the MCHW, Vol 1, Clause 518.2, For guidance: PD ISO/TR 10358 : 2021	Product conforming to the MCHW, Vol 1, Clause 518	Pass

The assessment showed that the products comply with HAPAS requirements for this characteristic.

3.3.1 The assessment showed that the products comply with HAPAS requirements for chemical resistance, subject to the water discharged being rainwater, surface water and ground water, excluding chemically contaminated wastewaters, such as industrial discharges. In situations where the piping system is to be exposed to the excluded influents, specific chemical and temperature resistance must be taken into account by a suitably experienced and competent individual. Material used in the manufacture of the product, is expected to have an adequate resistance to the types and levels of chemicals likely to occur in soils and groundwater in civil engineering applications.

3.3.2 Under normal service conditions, the products will have a life of at least 50 years, provided they are designed, installed and maintained in accordance with this Certificate and the Certificate holder's instructions.

3.4 Cleaning and maintenance

Table 7 Characteristics for maintenance and cleaning

Product assessed	Assessment method	Requirement	Outcome
Fittings $\leq 350 \text{ mm}$	Rodding resistance to the MCHW, Vol 1, sub- Clause 518.12	Average failure energy > 3 joules. No damage	Pass

The assessment showed that the products comply with HAPAS requirements for this characteristic.

4 Summary of Process Assessment

Manufacturing process and quality control	Complies with HAPAS requirements
Delivery and site handling	Complies with HAPAS requirements
Installation	Complies with HAPAS requirements

4.1 Manufacture

4.1.1 The BBA has undertaken the following tasks for the assessment of product manufacture and has established that the manufacture complies with BBA HAPAS Certification Scheme requirements:

- the BBA has recorded and evaluated the manufacturer's documentation on the methods adopted for quality control procedures and product testing against HAPAS requirements
- the BBA has assessed the quality control operated over batches of incoming materials and formulations against HAPAS Requirements
- the BBA has evaluated the process for management of non-conforming work
- the BBA has audited the production process and verified that it is in accordance with the documented process
- the BBA has checked that equipment has been properly tested and calibrated.

4.1.2 The BBA has undertaken to review the above measures on a regular basis through a surveillance process, to verify that the specifications and quality control operated by the manufacturer are being maintained.

4.2 Delivery and site handling

† 4.2.1 The Certificate holder stated that the products are delivered to site in packaging bearing a label including the Certificate holder's name, product code, diameter, angle of bends and branches, production date and the BBA logo incorporating the number of this Certificate. Depending on size, the products are delivered on pallets or despatched individually.

4.2.2 To achieve the performance described in this Certificate, delivery and site handling must be performed in accordance with the Certificate holder's instructions and this Certificate, including:

- compliance with the requirements of the MCHW, Vol 1, Series 500, Clause 518 and BS EN 1610 : 2015
- care must be taken not to drop products on their ends, particularly during cold weather conditions
- the products must be protected from direct sunlight if long-term storage is envisaged.

4.3 Design

4.3.1 Structural design

4.3.1.1 In general, structural design of the products, by employing analytical or numerical methods, is not needed provided the parameters of the project are within the value range as given in PD CEN/TS 15223 : 2017, Table 1.

4.3.1.2 Specific combinations (when prescribing loads that each component must be able to withstand or any special safety factors to be used etc) must be supported by calculations carried out by a suitably experienced and competent individual in accordance with BS 9295 : 2020, BS EN 1295-1 : 2019 and PD CEN/TR 1295-2 : 2005.

4.3.1.3 Calculated prediction of the actual pipe's behaviour depends on the framework conditions used for it. Applied values must be monitored through exhaustive soil survey assessments and by supervising the installation.

4.3.2 Hydraulic design of the system

4.3.2.1 The internal surface of the product is hydraulically smooth, and the design of joints and fittings ensure good hydraulic performances. An appropriate value of roughness coefficient must be selected when designing the drainage system. For new pipes, a value of 0.006 mm is applicable, but for designs, a value of 0.6 mm is generally used.

4.3.2.2 The products have normal flow characteristics associated with thermoplastics pipes.

4.4 Installation

4.4.1 The Certificate holder's instructions for installation of the products were confirmed as meeting the BBA HAPAS Certification Scheme requirements.

4.4.2 To achieve the performance described in this Certificate, the product must be protected against damage from site construction traffic.

4.4.3 To achieve the performance described in this Certificate, the product must be installed in accordance with:

- Certificate holder's instructions
- National Highways requirements and the MCHW Volume 1, Clauses 502 to 505, 518.8, and 518.9, and Volume 3, Drawing Nos F1 (Type T and S) and F2 (Type G, H and I)
- CD 533 (DMRB 4.2.5)
- BS EN 752 : 2017 and BS EN 1610 : 2015

and tested in accordance with the MCHW, Volume 1, Clause 509.

† 4.4.4 The Certificate holder's instructions advise the following:

- for a watertight joint, the pipe end and socket/coupler/fitting should be cleaned, and a rubber seal fitted externally between the first and second corrugation in the pipe. The seal and inside of the socket/coupler should be lubricated and the pipe pushed fully home to the central register, either by hand or using a lever if necessary
- care should be taken during backfill to maintain the line and level of the pipelines. If necessary, the pipe and relevant fittings where applicable, should be restrained to prevent uplift
- all pipework elements must be laid with the correct bedding and surrounding material.

4.4.5 To achieve the performance described in this Certificate, Installation of the products must be carried out by a competent general builder, or a contractor, experienced with these types of products.

4.5 Maintenance

4.5.1 To achieve the performance described in this Certificate:

- access to the system for cleaning must be provided by conventional means
- in common with other standard plastic drainage systems, toothed root cutters and rods with metal ferrules, as used with some mechanical clearing systems, could damage the products and must not be used
- the products have adequate resistance to cleaning by water jetting and rodding. However, it is recommended that a low-pressure, high-volume jetting method is used in accordance with the MCHW, Volume 1, Clause 521 and general advice as stated in sub-Causes 520.1 to 520.4.

5 Fulfilment of Requirements

5.1 The conclusion of this BBA assessment is that Cherry Twinwall Fittings, when used in accordance with the provisions of this Certificate comply with the BBA HAPAS Certification Scheme requirements.

5.2 In order for the products to continue to meet Scheme requirements, they must be installed, used and maintained as per the manufacturer's instructions and as detailed in the Certificate.

6 Validity of Certificate

Continuing validity of this Certificate is dependent on the following factors:

- continuing compliance with product or process requirements, as described in the HAPAS Scheme document, and the specification documents referred to therein
- ongoing BBA surveillance of factory production control, to verify that the specifications and quality control being operated by the manufacturer are being maintained
- formal triennial Review of the Certificate, and Reissue for required technical or non-technical updates
- compliance with ongoing Certificate obligations by the Certificate holder and manufacturers.

†7 Additional Regulations

Construction (Design and Management) Regulations 2015

Construction (Design and Management) Regulations (Northern Ireland) 2016

Information in this Certificate may assist the client, designer (including Principal Designer) and contractor (including Principal Contractor) to address their obligations under these Regulations.

CE Marking

The Certificate holder has taken the responsibility of CE Marking the products in accordance with harmonised European Standard EN 681-1 : 1996.

8 Bibliography

BS 9295 : 2020 *Guide to the structural design of buried pipes*

BS EN 681-1 : 1996 *Elastomeric seals — Material requirements for pipe joint seals used in water and drainage applications — Vulcanized rubber*

BS EN 728 : 1997 *Plastics piping and ducting systems — Polyolefin pipes and fittings — Determination of oxidation induction time*

BS EN 752 : 2017 *Drain and sewer systems outside buildings — sewer system management*

BS EN 1610 : 2015 *Construction and testing of drains and sewers*

BS EN 1295-1 : 2019 *Structural design of buried pipelines under various conditions of loading — General requirements*

BS EN ISO 527-2 : 2012 *Plastics — Determination of tensile properties — Test conditions for moulding and extrusion plastics*

BS EN ISO 580 : 2005 *Plastics piping and ducting systems — Injection-moulded thermoplastics fittings — Methods for visually assessing the effects of heating*

BS EN ISO 1133-1 : 2011 *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics*

BS EN ISO 1183-1 : 2012 *Plastics — Methods for determining the density and relative density of non-cellular plastics — Immersion method, liquid pycnometer method and titration method*

BS EN ISO 13254 : 2017 *Thermoplastic piping systems for non-pressure applications — Test method for watertightness*

BS EN ISO 13259 : 2018 *Thermoplastics piping systems for underground non-pressure applications — Test method for leaktightness of elastomeric sealing ring type joints*

BS EN ISO 13263 : 2017 *Thermoplastics piping systems for non-pressure underground drainage and sewerage - thermoplastics fittings — test method for impact strength*

BS EN ISO 13264 : 2017 *Thermoplastics piping systems for non-pressure underground drainage and sewerage. Thermoplastics fittings — Test method for mechanical strength or flexibility of fabricated fittings*

BS EN ISO 13967 : 2009 *Thermoplastics fittings — Determination of ring stiffness*

BS ISO 11922-1 : 2018 *Thermoplastics pipes for the conveyance of fluids — Dimensions and tolerances — Metric series*

PD CEN/TS 15223 : 2017 *Plastics piping systems — Validated design parameters of buried thermoplastics piping systems*

PD CEN/TR 1295-2 : 2005 *Structural design of buried pipelines under loading — Part 2: Summary of nationally established methods of design*

PD ISO/TR 10358 : 2021 *Plastics pipes and fittings — Combined chemical-resistance classification table*

Design Manual for Roads and Bridges (DMRB), CD 533 Determination of pipe and bedding combinations for drainage works SG, Version 1.1.0. Issue December 2021

Manual of Contract Documents for Highway Works, Volume 1 Specification for Highway Works, Series 0500, Drainage and Service Ducts, February 2020

Manual of Contract Documents for Highway Works, Volume 2 Notes for Guidance on the Specification for Highway Works, Series NG 0500, February 2020

Manual of Contract Documents for Highway Works, Volume 3 Highway Construction Details, Section 1 Carriageway and Other Details, F Series

9 Conditions of Certification

9.1 This Certificate:

- relates only to the product/system that is named and described on the front page
- is issued only to the company, firm, organisation or person named on the front page – no other company, firm, organisation or person may hold or claim that this Certificate has been issued to them
- is valid only within the UK
- has to be read, considered and used as a whole document – it may be misleading and will be incomplete to be selective
- is copyright of the BBA
- is subject to English Law.

9.2 Publications, documents, specifications, legislation, regulations, standards and the like referenced in this Certificate are those that were current and/or deemed relevant by the BBA at the date of issue or reissue of this Certificate.

9.3 This Certificate will remain valid for an unlimited period provided that the product/system and its manufacture and/or fabrication, including all related and relevant parts and processes thereof:

- are maintained at or above the levels which have been assessed and found to be satisfactory by the BBA
- continue to be checked as and when deemed appropriate by the BBA under arrangements that it will determine
- are reviewed by the BBA as and when it considers appropriate.

9.4 The BBA has used due skill, care and diligence in preparing this Certificate, but no warranty is provided.

9.5 In issuing this Certificate the BBA is not responsible and is excluded from any liability to any company, firm, organisation or person, for any matters arising directly or indirectly from:

- the presence or absence of any patent, intellectual property or similar rights subsisting in the product/system or any other product/system
- the right of the Certificate holder to manufacture, supply, install, maintain or market the product/system
- actual installations of the product/system, including their nature, design, methods, performance, workmanship and maintenance
- any works and constructions in which the product/system is installed, including their nature, design, methods, performance, workmanship and maintenance
- any loss or damage, including personal injury, howsoever caused by the product/system, including its manufacture, supply, installation, use, maintenance and removal
- any claims by the manufacturer relating to UKCA marking and CE marking.

9.6 Any information relating to the manufacture, supply, installation, use, maintenance and removal of this product/system which is contained or referred to in this Certificate is the minimum required to be met when the product/system is manufactured, supplied, installed, used, maintained and removed. It does not purport in any way to restate the requirements of the Health and Safety at Work etc. Act 1974, or of any other statutory, common law or other duty which may exist at the date of issue or reissue of this Certificate; nor is conformity with such information to be taken as satisfying the requirements of the 1974 Act or of any statutory, common law or other duty of care.

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