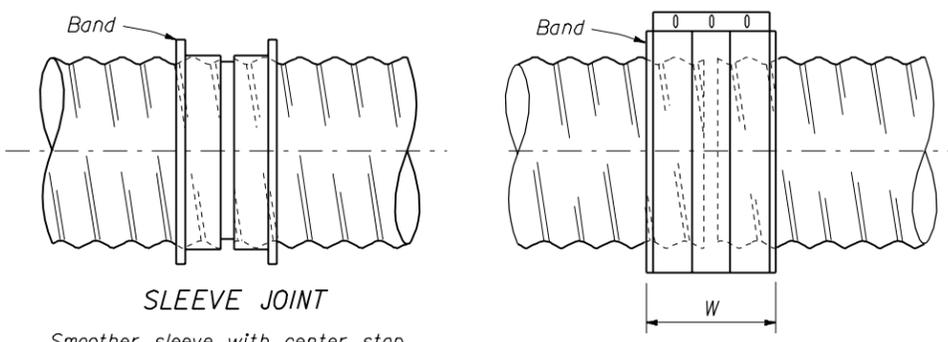


COUPLING BANDS FOR METAL PIPE CULVERT ^{1/}					
CORRUGATION SIZE ^{2/}	ROUND PIPE DIAMETER	PIPE-ARCH SPAN X RISE	MINIMUM BAND WIDTH		
			ANNULAR ^{3/} CORRUGATED BANDS	HELICALLY ^{4/} CORRUGATED BANDS	SEMI- ^{5/} CORRUGATED BANDS
38 x 6.5	underdrain ^{6/}	-	265	180	265
68 x 13	300 to 900	430 x 330 to 1060 x 740	180	300	
	1050 to 1800	1240 x 840 to 2100 x 1450	265	300	
75 x 25	1950 to 2100	-	265	300	265
	900 to 1800	1520 x 1170 to 2050 x 1500	300	350	265
125 x 25	1950 to 3600	2200 x 1620 to 3600 x 2320	300	350	265
	900 to 1800	1520 x 1170 to 2050 x 1500	500	560	
	1950 to 3600	2200 x 1620 to 3600 x 2320	500	560	

- ^{1/} Fabricate annular, helical and semi-corrugated type coupling bands from the same metal as the connecting pipe. Provide coupling bands not more than 3 nominal sheet thicknesses thinner than the thickness of the pipe to be connected, and no thinner than 1.32 mm for steel or 1.2 mm for aluminum. Fasten coupling bands with the following diameter of bolt:
 *10 for 450 mm round culvert (530x380 mm pipe arch) or less
 *13 for 525 mm round culvert (610x460 mm pipe arch) or more
- ^{2/} For helically corrugated pipe with rerolled ends, the nominal corrugations size refers to the dimension of the end corrugation in the pipe.
- ^{3/} Use annular corrugated bands with pipes having annular corrugations or with helical pipe having rerolled end to form annular corrugations. A 265 mm band is acceptable on pipe ends rerolled with 68x13 mm corrugations. A 300 mm band is acceptable on pipe ends rerolled with 75x25 mm pipe corrugations.
- ^{4/} Use helical corrugated bands with pipes having helically corrugated ends.
- ^{5/} The minimum band widths shown for 75x25 mm and 125x25 mm corrugated sizes apply to 68x13 mm corrugations on rerolled pipe ends.
- ^{6/} Smooth sleeve-type couplers and flat bands may be used for pipe diameters of 300 mm or less. Use a matching metal having a nominal thickness of not less than 1.02 mm for steel, or 0.91 mm for aluminum, or a plastic with an equivalent strength to metal.

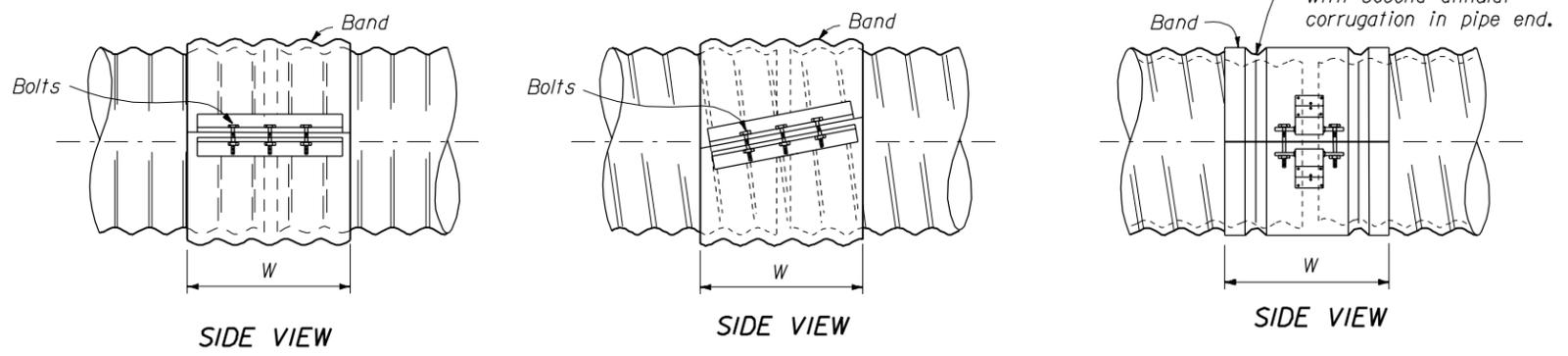


SLEEVE JOINT
Smoother sleeve with center stop. Stab type joint.

SMOOTH SLEEVE BAND

FLAT BAND

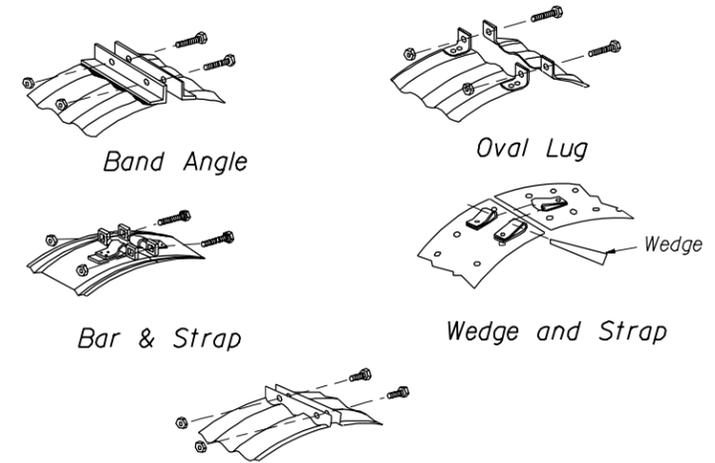
- NOTES:**
- Watertight pipe joints are not required unless specified in the Special Contract Requirements.
 - Other types of coupling bands or fastening devices that comply with the joint performance criteria of AASHTO Standard specifications for Highway Bridges, Division II Section 26 may be used.



ANNULAR BAND
Rivet, spot weld, or fillet weld at crest of corrugation at heel and toe of angle.

HELICAL BAND
Rivet, spot weld, or fillet weld at crest of corrugation at heel and toe of angle.

SEMI-CORRUGATED BAND
Bolt, bar and strap connector



STANDARD BAND CONNECTIONS

Second angle connection optional to 1050 mm diameter, required above 1065 mm diameter.

Second angle connection optional to 1050 mm diameter, required above 1050 mm diameter.

ANNULAR BAND

HELICAL BAND

NO SCALE

U.S. DEPARTMENT OF TRANSPORTATION
 FEDERAL HIGHWAY ADMINISTRATION
 FEDERAL LANDS HIGHWAY

METRIC STANDARD
**METAL PIPE CULVERT
 COUPLING BAND**

STANDARD APPROVED FOR USE ---
 REVISED: 08/97 07/98

STANDARD
M602-02