

## Table of Contents

<b>Preface</b> . . . . .	17
André COLSON	
<b>Introduction</b> . . . . .	19
Michel MERMET	
<b>PART I. MICROTUNNELING</b> . . . . .	23
<b>Chapter 1. Introduction to Guidelines: Subject and Fields of Application</b> . . . . .	25
1.1. General introduction of “trenchless technology” . . . . .	25
1.2. History and characteristics of microtunneling methods . . . . .	27
1.3. Purpose of the guidelines. . . . .	28
<b>Chapter 2. Techniques and Theory of Operation for the Installation of Pipes by Microtunneling</b> . . . . .	31
2.1. General information . . . . .	31
2.2. Different functions of a boring machine . . . . .	32
2.2.1. Mechanized excavation of the soil . . . . .	32
2.2.1.1. Blasting the soil. . . . .	32
2.2.1.2. Confinement of the face. . . . .	33
2.2.2. Discharge of excavated earth (or mucking). . . . .	34
2.2.2.1. Hydraulic mucking. . . . .	34
2.2.2.2. Mucking with a screw conveyor . . . . .	35
2.2.2.3. Pneumatic mucking . . . . .	36

6 Microtunneling and Horizontal Drilling

2.2.3. Guidance and trajectory correction. . . . .	36
2.2.4. Installation of pipelines by jacking. . . . .	37
2.3. Various types of pipes . . . . .	37
2.3.1. Materials used . . . . .	38
2.3.2. Joints between pipes . . . . .	38
2.3.3. Resistance capacity of pipes. . . . .	39

**Chapter 3. Summary of Parameters Affecting Work at the Site . . . . . 41**

3.1. Summary of parameters affecting the microtunneling. . . . .	41
3.1.1. Rate of penetration . . . . .	42
3.1.1.1. Duration for pipe jacking only . . . . .	43
3.1.1.2. Total duration for the installation of a pipe in the ground . . . . .	46
3.1.2. Alignment deviations. . . . .	46
3.1.2.1. Human factors . . . . .	46
3.1.2.2. Technological factors . . . . .	48
3.1.2.3. Factors linked to the soil . . . . .	50
3.1.3. Frictional forces . . . . .	51
3.1.3.1. Principle of analysis for experimental data. . . . .	52
3.1.3.2. Effect of the overcut . . . . .	53
3.1.3.3. Impact of the downtimes . . . . .	54
3.1.3.4. Impact of lubrication. . . . .	57
3.1.3.5. Impact of misalignment . . . . .	64
3.1.3.6. Impact of granulometry . . . . .	64
3.1.4. Stresses at the head . . . . .	64
3.1.4.1. Presentation of general results . . . . .	64
3.1.4.2. Influence of blasting and mucking. . . . .	67
3.1.4.3. Influence of trajectory deviations . . . . .	68
3.2. Description of the main hitches that can occur when constructing a microtunneling site . . . . .	69
3.2.1. Blocking of the machine. . . . .	69
3.2.1.1. Various boulders and obstacles . . . . .	69
3.2.1.2. Excessive friction. . . . .	70
3.2.1.3. Abrasiveness of the soil . . . . .	71
3.2.1.4. Sticking of clay . . . . .	72
3.2.2. Damaged pipes . . . . .	72
3.2.3. Surface disturbances . . . . .	73
3.2.3.1. Settlement caused by the annular space. . . . .	74
3.2.3.2. Instability of the face, poor balancing of the pressure at the face . . . . .	74
3.2.4. Excessive roll . . . . .	75

<b>Chapter 4. Guidelines for Investigations</b> . . . . .	77
4.1. General approach of the investigations. . . . .	77
4.1.1. General objectives . . . . .	77
4.1.2. Progress of the investigations . . . . .	78
4.1.3. Cost of investigations . . . . .	79
4.2. Data to be acquired . . . . .	80
4.2.1. Geological configuration of the site . . . . .	80
4.2.2. Hydrogeological conditions . . . . .	81
4.2.3. Geotechnical characteristics of the ground . . . . .	81
4.2.4. Cavities and artificial obstacles. . . . .	82
4.2.5. Environmental conditions . . . . .	82
4.3. Methodology and means of investigation . . . . .	82
4.3.1. Documentary survey . . . . .	83
4.3.2. Geophysical investigations . . . . .	83
4.3.2.1. Objectives . . . . .	83
4.3.2.2. Usefulness of different methods . . . . .	84
4.3.2.3. General guidelines . . . . .	86
4.3.3. <i>In situ</i> boreholes and geotechnical tests . . . . .	87
4.3.3.1. Objectives of boreholes . . . . .	87
4.3.3.2. Layout of boreholes . . . . .	87
4.3.3.3. Types of <i>in situ</i> tests . . . . .	87
4.3.3.4. Guidelines on the choice of boreholes and tests. . . . .	88
4.3.4. Geotechnical tests at the laboratory . . . . .	89
4.4. Contents of the geological record . . . . .	89
<b>Chapter 5. Guidelines for the Choice of Machines and Attachments</b> . . . . .	93
5.1. General information. . . . .	93
5.2. The choice of machines according to their mucking process. . . . .	94
5.3. Choice of attachments . . . . .	95
5.3.1. The heads: opening, cutting tools . . . . .	96
5.3.2. The overcut . . . . .	98
5.3.3. The crusher. . . . .	99
5.3.4. Bore fluids . . . . .	99
<b>Chapter 6. Guidelines for Project Design, Dimensions of Pipes and the Pipe Jacking System</b> . . . . .	101
6.1. Design of shafts . . . . .	101
6.2. Calculation of pipe jacking stresses . . . . .	105
6.2.1. Definition of friction between the soil and the pipes . . . . .	105

## 8 Microtunneling and Horizontal Drilling

6.2.1.1. General definition . . . . .	105
6.2.1.2. Specific friction values . . . . .	106
6.2.2. Experimental results relating to unit friction . . . . .	106
6.2.2.1. Results of the French National Research Project “Microtunnels” . . . . .	106
6.2.2.2. Results of other studies . . . . .	110
6.2.3. Calculation methodology for frictional forces . . . . .	111
6.2.3.1. Verification of the stability of the excavation . . . . .	112
6.2.3.2. Ground convergence effect . . . . .	113
6.2.3.3. Calculation of frictional forces for unstable excavation in granular soil . . . . .	114
6.2.3.4. Calculation of frictional forces for unstable excavation in cohesive soil . . . . .	118
6.2.3.5. Calculation of frictional forces for a stable excavation. . . . .	119
6.2.4. Comparison of various approaches with experimental values . . . . .	120
6.2.4.1. Calculations-measurements comparison: granular soil without lubrication . . . . .	120
6.2.4.2. Calculations-measurements comparison: granular soil with lubrication . . . . .	121
6.2.4.3. Calculations-measurements comparison: cohesive soil without lubrication . . . . .	123
6.2.4.4. Calculations-measurements comparison: cohesive soil with lubrication . . . . .	124
6.2.5. Guidelines for the calculation of pipe jacking stresses . . . . .	124
6.2.5.1. Dynamic friction: non-cohesive soil . . . . .	125
6.2.5.2. Dynamic friction: cohesive soil . . . . .	126
6.2.5.3. Additional friction caused by stoppage in jacking . . . . .	128
6.2.5.4. Stress on the cutter head. . . . .	129
6.2.5.5. Estimate of the maximum pipe jacking stress . . . . .	129
6.3. Calculation of the maximum acceptable thrust by the pipes during jacking . . . . .	130
6.3.1. Calculation principle . . . . .	130
6.3.2. Permissible stress in the pipes . . . . .	132
6.4. Calculation of the cross-section of pipes. . . . .	133
6.4.1. Various verifications of the calculation of the size of pipes . . . . .	133
6.4.2. General calculation principles: basic Terzaghi model. . . . .	134
6.4.3. Vertical loads to the soil alone . . . . .	135
6.4.3.1. The experimental Terzaghi model. . . . .	135
6.4.3.2. The ATV A161 method . . . . .	137
6.4.3.3. Leonards’ model . . . . .	137
6.4.3.4. Guidelines for the calculation of vertical loads . . . . .	138
6.4.4. Horizontal loads of the ground . . . . .	140

6.4.5. Surface loads . . . . .	141
6.4.5.1. Permanent surface loads . . . . .	141
6.4.5.2. Traffic loads . . . . .	142
6.4.6. Water pressure: presence of groundwater . . . . .	145
6.4.7. Permissible stress in the pipes . . . . .	147
6.5. Bore fluids . . . . .	148
6.5.1. General information . . . . .	148
6.5.2. Selection criteria . . . . .	150
6.5.3. Products used . . . . .	151
6.5.4. Recycling and processing . . . . .	152
6.5.5. Implementation at the site . . . . .	153
6.5.6. Slurry treatment: technical and regulatory aspects . . . . .	153
6.5.6.1. General considerations . . . . .	153
6.5.6.2. Current regulations . . . . .	156
6.5.6.3. Lines for removal of drilling residues . . . . .	156
6.5.6.4. Prospects for reclamation . . . . .	158
<b>Chapter 7. Guidelines for the Site Supervision . . . . .</b>	<b>159</b>
7.1. Guidelines for guidance . . . . .	159
7.1.1. Necessity of controlling trajectory deviations . . . . .	159
7.1.2. Guidelines for the measurement of deviations . . . . .	160
7.1.3. Guidelines for the monitoring of deviations . . . . .	160
7.1.3.1. Initial adjustments and starting of jacking . . . . .	161
7.1.3.2. Corrections during jacking . . . . .	161
7.1.3.3. Adjustment of the overcut . . . . .	162
7.2. Guidelines on the drilling parameters . . . . .	162
7.2.1. Avoid instability of the face . . . . .	163
7.2.2. Avoid excessive thrust on the head and the blocking of the cutterhead . . . . .	164
7.2.3. Checking the roll . . . . .	164
7.3. Guidelines on lubrication . . . . .	165
7.4. Guidelines regarding stoppages during jacking . . . . .	166
7.4.1. Provision for the increase in the thrust during restarting . . . . .	166
7.4.2. Limit the increase of the thrust during restarting . . . . .	167
7.5. Data acquisition during the project . . . . .	167

<b>Chapter 8. Socio-Economic and Contractual Aspects</b> . . . . .	169
8.1. Social and economic aspects: concept of social cost. . . . .	169
8.1.1. Value of modern urban sites. . . . .	170
8.1.1.1. Total cost of the work . . . . .	170
8.1.1.2. Direct cost . . . . .	170
8.1.1.3. Overhead cost . . . . .	170
8.1.1.4. Social cost . . . . .	171
8.1.2. Traditional urban sites: nuisance factors . . . . .	171
8.1.2.1. Traffic disruption. . . . .	171
8.1.2.2. Damage to the environment . . . . .	172
8.1.2.3. Risk of accidents . . . . .	172
8.1.2.4. Economic impacts . . . . .	173
8.1.3. Reduction in nuisance by trenchless techniques . . . . .	174
8.1.4. Methods for evaluating the social cost. . . . .	176
8.1.4.1. Methods used in a context other than that of urban sites. . . . .	177
8.1.4.2. Approaches as part of urban underground sites . . . . .	179
8.1.4.3. Comparison methodology for the costs of trench and trenchless techniques . . . . .	181
8.1.5. Other suggestions to reduce the social cost. . . . .	187
8.1.5.1. Susceptibility maps . . . . .	188
8.1.5.2. Financial incentives . . . . .	188
8.1.6. Conclusions . . . . .	188
8.2. Contractual aspects: objectives and success factors . . . . .	189
8.2.1. Proper contractualisation of a microtunneling project . . . . .	190
8.2.1.1. Well defined respective roles. . . . .	190
8.2.1.2. Appropriate risk management . . . . .	192
8.2.1.3. Knowledge of the structure and underground use. . . . .	195
8.2.1.4. Suitable allotment and contracting . . . . .	195
8.2.2. Establishment of appropriate tender documents and a consultation regulation. . . . .	196
8.2.2.1. Tender documents based on a defined strategy . . . . .	196
8.2.2.2. Specifications adapted to every item of the tender documents . . . . .	197
8.2.2.3. A properly described project . . . . .	197
8.2.2.4. Correctly sized and adapted products . . . . .	201
8.2.2.5. Well defined and controlled microtunneling procedures . . . . .	201
8.2.3. Presentation of compliant and pertinent offers by the contractor . . . . .	202
8.2.3.1. Appropriate qualifications . . . . .	202
8.2.3.2. Adequate and adapted references . . . . .	203
8.2.3.3. A complete and definite technical submission. . . . .	204

<b>PART II. HORIZONTAL DRILLING</b> . . . . .	207
<b>Chapter 9. Introduction to Guidelines: Purpose and Fields of Application</b> . . . . .	209
9.1. General introduction of “the trenchless technology” . . . . .	209
9.2. History and characteristics of drilling methods . . . . .	211
9.3. Purpose of the recommendations and fields of application . . . . .	219
<b>Chapter 10. Techniques and Principles of Operation for Horizontal Drilling</b> . . . . .	223
10.1. General information . . . . .	223
10.2. Different stages of horizontal drilling . . . . .	225
10.2.1. Pilot drilling . . . . .	225
10.2.2. Reaming . . . . .	226
10.2.3. Guidance and trajectory corrections . . . . .	228
10.2.3.1. Walk-over systems . . . . .	228
10.2.3.2. Downhole systems or wireline steering systems . . . . .	230
10.2.4. Site organisation . . . . .	230
10.2.4.1. Administrative authorizations . . . . .	230
10.2.4.2. Access, site installation . . . . .	230
10.2.4.3. Water . . . . .	230
10.2.4.4. Slurry transfers . . . . .	231
10.2.4.5. Work areas . . . . .	231
10.3. Different types of pipes or conduits . . . . .	231
10.3.1. Thermoplastic pipelines . . . . .	232
10.3.1.1. Polyethylene pipes . . . . .	232
10.3.1.2. Polyvinylchloride pipes . . . . .	238
10.3.2. Metal pipelines . . . . .	240
10.3.2.1. Steel pipes . . . . .	240
10.3.2.2. Pipes in ductile cast iron . . . . .	242
<b>Chapter 11. Summary of Parameters Affecting the Start of a Building Site</b> . . . . .	247
11.1. Summary of parameters affecting the execution of horizontal drilling . . . . .	247
11.2. Parameters related to the ground . . . . .	247
11.3. Parameters related to groundwater and soil permeability . . . . .	248

12 Microtunneling and Horizontal Drilling

11.4. Parameters related to obstacles . . . . .	249
11.5. Parameters related to the nature of the pipeline to be installed . . . . .	249
11.6. Parameters related to the drive length . . . . .	249
11.7. Parameters related to the radius of curvature . . . . .	251
11.8. Parameters related to the characteristics of the drilling mud . . . . .	251
11.9. Parameters related to the characteristics of the drilling rig . . . . .	251
11.10. Parameters related to the regularity of the profile, the piloting and the guidance . . . . .	251
11.11. Parameters related to preliminary exploration . . . . .	251
11.12. Parameters related to the (overall dimensions) congestion of the site . . . . .	251
11.13. Parameters related to delays . . . . .	252
11.14. Parameters related to weather conditions . . . . .	252

**Chapter 12. Guidelines for Explorations . . . . . 253**

12.1. General theory of explorations . . . . .	253
12.1.1. General objectives . . . . .	253
12.1.2. Stages of explorations . . . . .	254
12.1.3. Cost of explorations . . . . .	254
12.2. Data to be acquired . . . . .	255
12.2.1. Geological configuration of the site . . . . .	255
12.2.2. Hydrogeological conditions . . . . .	257
12.2.3. Geotechnical characteristics of the soils . . . . .	257
12.2.4. Pockets and artificial obstacles . . . . .	258
12.2.5. Environmental parameters . . . . .	258
12.3. Methodology and means of explorations . . . . .	259
12.3.1. Documentary survey . . . . .	259
12.3.2. Geophysical investigations . . . . .	260
12.3.2.1. Objectives . . . . .	260
12.3.2.2. Advantage of various methods . . . . .	260
12.3.2.3. General recommendations . . . . .	263
12.3.3. Drilling and <i>in situ</i> geotechnical tests . . . . .	264
12.3.3.1. Test drilling objectives . . . . .	264
12.3.3.2. Setting up investigations boreholes . . . . .	264
12.3.3.3. Test drilling methods . . . . .	265
12.3.3.4. Samples for laboratory tests . . . . .	267
12.3.3.5. <i>In situ</i> tests . . . . .	268
12.4. Contents of the geological-geotechnical dossier of a project . . . . .	269



<b>Chapter 13. Guidelines for the Choice of Drilling Rigs and Equipment . . .</b>	<b>273</b>
13.1. General information . . . . .	273
13.2. Choice of drilling rigs according to their power . . . . .	274
13.2.1. Mini drilling rigs. . . . .	275
13.2.2. Medium drilling rigs . . . . .	276
13.2.3. Maxi drilling rigs . . . . .	276
13.2.4. Mega drilling rigs . . . . .	277
13.3. Choice of drilling rigs according to their technical characteristics. . .	277
13.3.1. Chassis . . . . .	277
13.3.1.1. Base . . . . .	277
13.3.1.2. Trailer. . . . .	278
13.3.1.3. Track mounted chassis. . . . .	278
13.3.1.4. Wheeled chassis. . . . .	278
13.3.2. Transmission of forces . . . . .	278
13.3.2.1. Chain driven . . . . .	278
13.3.2.2. Rack and pinion. . . . .	279
13.3.2.3. Hydraulic jacks . . . . .	279
13.3.3. Power limits . . . . .	279
13.4. Drilling rods. . . . .	279
13.5. Tools . . . . .	281
13.5.1. Wing cutters . . . . .	281
13.5.2. Spiral compactor bells . . . . .	282
13.5.3. Fluted reamers . . . . .	282
13.5.4. Rock reamers. . . . .	282
13.5.5. Barrel reamers . . . . .	283
<b>Chapter 14. Guidelines for a Project Design . . . . .</b>	<b>285</b>
14.1. Basic principles of a pilot pattern . . . . .	285
14.1.1. Rack angle and exit angle . . . . .	285
14.1.2. First and last part of the drilling. . . . .	286
14.1.3. Radius of curvature . . . . .	286
14.1.3.1. Radius of curvature of the pilot hole. . . . .	287
14.1.3.2. Combined radii . . . . .	288
14.1.4. Roofing . . . . .	288
14.1.5. Relation between the diameters of the pipeline and the borehole . . . . .	289

14 Microtunneling and Horizontal Drilling

14.2. Drilling plans . . . . .	289
14.2.1. Longitudinal profile . . . . .	289
14.2.2. Plan view . . . . .	290
14.2.3. Cross-sections . . . . .	290
14.2.4. Work site installation plans . . . . .	291
14.2.5. Catenary and launching ramp . . . . .	291
14.3. Design notes . . . . .	291
14.3.1. Calculation for the work stage. . . . .	292
14.3.1.1. Pulling forces at the level of the drilling head . . . . .	292
14.3.1.2. Tractive forces at the level of the drilling machine . . . . .	292
14.3.1.3. Calculation methods of pulling forces . . . . .	293
14.3.1.4. Calculation of the drilling machine dimensions . . . . .	293
14.3.1.5. Supports . . . . .	293
14.3.1.6. Stresses suffered by the tubes . . . . .	294
14.3.1.7. Protection against collapse . . . . .	294
14.3.2. Calculation of operations stage . . . . .	294
14.4. Work planning . . . . .	294
14.5. Drilling fluids . . . . .	295
14.5.1. General information . . . . .	295
14.5.2. Selection criteria . . . . .	297
14.5.3. Products used . . . . .	298
14.5.4. Recycling and processing . . . . .	299
14.5.5. Implementation at the site . . . . .	301
14.5.6. Sludge treatment: technical and regulatory aspects . . . . .	301
14.5.6.1. General considerations . . . . .	301
14.5.6.2. Drilling wastes eliminations solutions . . . . .	303
14.5.6.3. Development prospects . . . . .	306
<b>Chapter 15. Guidelines for the Management of the Site . . . . .</b>	<b>307</b>
15.1. Guidelines on lubrication, drilling fluids . . . . .	307
15.1.1. General information . . . . .	307
15.1.2. Selection criteria . . . . .	308
15.1.3. Products used . . . . .	308
15.1.4. Implementation at the site . . . . .	308
15.1.5. Polluted sites, environment, slurry . . . . .	308
15.2. Recommendations on reaming . . . . .	309
15.2.1. Reaming diameter . . . . .	309
15.2.2. Choice of the reamer . . . . .	309
15.2.3. Multiple bores . . . . .	310
15.2.4. Reaming sequences . . . . .	310
15.2.5. Reaming speed . . . . .	312
15.2.6. Installing a protective sleeve . . . . .	313

15.3. Guidelines on safety and protection of environment . . . . .	314
15.3.1. Safety at the work station (at the site) . . . . .	314
15.3.1.1. Work on inclines . . . . .	314
15.3.1.2. Work on rotating mechanical parts and tools. . . . .	314
15.3.1.3. Risk of slipping increased by the presence of drilling mud . . . . .	314
15.3.1.4. Respiratory risks related to the inhalation of bentonite powder . . . . .	315
15.3.1.5. Handling of loads during lifting (drilling rod, reamers, etc.) . . . . .	315
15.3.1.6. Significant torsional moments during the tightening or loosening of drilling rod/tool unions . . . . .	315
15.3.1.7. Communication between the control cab, the drilling rig and the pipeline side. . . . .	315
15.3.1.8. Work under thoroughfares. . . . .	315
15.3.1.9. Risks of aggressions on underground structures. . . . .	315
15.3.2. Security of machines . . . . .	316
15.3.3. Security of drilling tools . . . . .	316
15.3.4. Protection of the environment . . . . .	316
<b>Appendix 1. Glossary of Symbols Used . . . . .</b>	<b>319</b>
<b>Appendix 2. Glossary of Horizontal Drilling . . . . .</b>	<b>323</b>
<b>Bibliography . . . . .</b>	<b>333</b>
<b>Index . . . . .</b>	<b>341</b>