ISO 21307:2011-05 (E)

Plastics pipes and fittings - Butt fusion jointing procedures for polyethylene (PE) pipes and fittings used in the construction of gas and water distribution systems

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Terms and definitions 2

4 Butt fusion jointing process 3
4.1 General 3
4.2 Principle 4
4.3 Cleaning the pipe or fitting ends, planing unit and heater surfaces 4
4.4 Clamping the components 4
4.5 Planing the pipe or fitting ends 5
4.6 Aligning the pipes or fittings 5
4.7 Measuring the drag pressure 5
4.8 Melting the pipe or fitting ends 5
4.9 Jointing the pipe or fitting ends 5
4.10 Cooling the pipe or fitting ends 5

5 Butt fusion jointing procedures 5
5.1 Single low-pressure fusion jointing procedure 6
5.2 Dual low-pressure fusion jointing procedure 7
5.3 Single high-pressure fusion jointing procedure 8

6 Quality control 9
6.1 General 9
6.2 Joint integrity testing 9
6.3 Non-destructive quality control procedures 9

Annex A (informative) Examples of single low-pressure, dual low-pressure and single high-pressure procedures 10