ISO 21307:2017-12 (E)

Plastics pipes and fittings - Butt fusion jointing procedures for polyethylene (PE) piping sys tems

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Terms and definitions 1

4 Butt fusion jointing process 4
4.1 General 4
4.2 Principle 4
4.3 Cleaning the pipe or fitting ends, planing unit and heater surfaces 5
4.4 Clamping the components 5
4.5 Planing the pipe or fitting ends 5
4.6 Aligning the pipes or fittings 6
4.7 Calculation of the gauge pressure 6
4.8 Determination of the drag pressure 6
4.9 Heating the pipe or fitting ends 6
4.10 Jointing the pipe or fitting ends 7
4.11 Cooling the pipe or fitting ends 7

5 Butt fusion jointing procedures 7
5.1 General 7
5.2 Single low-pressure fusion jointing procedure 7
5.3 Dual low-pressure fusion jointing procedure 9
5.4 Single high-pressure fusion jointing procedure 10

6 Quality control 12
6.1 General 12
6.2 Destructive joint integrity testing 12
6.3 Non-destructive joint integrity testing 12

Annex A (informative) Examples of values of parameters for single low-pressure fusion jointing procedure 13

Annex B (informative) Examples of values of parameters for dual low-pressure fusion jointing procedure 14

Annex C (informative) Examples of values of parameters for single high-pressure fusion jointing procedure 15

Bibliography 16