DIN EN 1254-8:2012-12 (E)

Copper and copper alloys - Plumbing fittings - Part 8: Fittings with press ends for use with plastics and multilayer pipes

Contents

Page

Foreword 4

Introduction 5

1 Scope 6

2 Normative references 6

3 Terms and definitions 7

4 Requirements 8
4.1 General 8
4.2 Materials 8
4.2.1 General 8
4.2.2 Reaction to fire 10
4.2.3 Resistance to high temperature (for heating networks) 10
4.3 Dimensions and tolerances 11
4.3.1 Minimum bore area 11
4.3.2 Minimum bore area through an internal support 11
4.3.3 Tolerance for the alignment of the fitting ends 13
4.4 Design and manufacture 13
4.4.1 Press fittings 13
4.4.2 Pipe abutment 13
4.4.3 Surface condition 13
4.4.4 Plated or coated surfaces 13

5 Testing, assessment and sampling methods 13
5.1 Type testing 13
5.1.1 General 13
5.1.2 Gas application 14
5.1.3 Preparation of fittings for testing 14
5.1.4 Test temperature 14
5.2 Resistance to stress corrosion 14
5.3 Factory production control system 15
5.3.1 General 15
5.3.2 Integrity of fittings bodies with as-cast microstructure or fabricated by welding or brazing 15
5.3.3 Resistance to dezincification 15

6 Evaluation of conformity 16
6.1 General 16
6.2 Type testing 16
6.2.1 General 16
6.2.2 Requirements and characteristics 16
6.2.3 Use of historical data 16
6.2.4 Further type testing 16
6.3 Sampling, testing and conformity criteria 17
6.3.1 Sampling 17
6.3.2 Testing and conformity criteria 17
6.4 Factory production control (FPC) 17
6.4.1 General 17

6.4.2 Personnel 17
6.4.3 Equipment 18
6.4.4 Raw materials and components 18
6.4.5 In-process control 18
6.4.6 Traceability and marking 18
6.4.7 Non-conforming products 18
6.4.8 Corrective action 18
6.4.9 Handling, storage, packaging 18

7 Classification and designation 18

8 Marking 19
8.1 General 19
8.2 Dezincification resistant copper-zinc alloys 19

9 Documentation 19
9.1 Declaration of conformity 19
9.2 User instructions 19

Annex A (normative) Resistance to stress corrosion 20

A.1 Introduction 20
A.2 Test piece 20
A.3 Procedure 20
A.4 Test report 20

Annex B (normative) Pressure test for fitting bodies with as cast microstructure or fabricated by welding or brazing 21

B.1 Introduction 21
B.2 Principle 21
B.3 Apparatus 21
B.4 Test piece 21
B.5 Procedure 22

Annex C (normative) Determination of mean depth of dezincification 23

C.1 Introduction 23
C.2 Procedure 23
C.3 Expression of results 23

Bibliography 24