

DIN EN 1254-2:2021-10 (E)

Copper and copper alloys - Plumbing fittings - Part 2: Compression fittings for use with copper tubes

Contents		Page
European foreword		4
Introduction		5
1	Scope	6
2	Normative references	7
3	Terms and definitions	8
4	Product characteristics	8
4.1	Internal pressure	8
4.2	Tightness	8
4.3	Resistance to high temperature for fittings with elastomeric seals (for heating networks) ..	9
4.4	Release of dangerous substances	9
4.5	Durability	10
4.6	Wall thickness at threaded portions of adaptor fittings	10
4.7	Dimensions of tail pipe ends for swivel fittings	10
4.8	Dimensions of gas union connectors	11
4.9	Threaded end dimensions	11
4.11	Bore dimensions	11
4.12	Identity of elastomeric sealing material for liquid applications	11
4.13	Identity of elastomeric sealing material for gas applications	11
4.14	Tube abutment	12
4.15	Alignment of the fitting ends	12
4.16	Shapes for tightening systems	12
4.17	Surface condition	12
4.18	Plated or coated surfaces	12
5	Testing, assessment and sampling methods	13
5.1	General	13
5.2	Internal pressure	13
5.3	Tightness	14
5.4	Durability	15
5.5	Wall thickness at threaded portions of adaptor fittings	16
5.6	Dimensions of tail pipe ends for swivel fittings	16
5.7	Dimensions of gas union connectors	16
5.8	Threaded end dimensions	17
5.9	Bore dimensions	17
5.10	Identity of elastomeric sealing material for liquid applications	17
5.11	Identity of elastomeric sealing material for gas applications	17
5.12	Alignment of the fitting ends	17
6	Evaluation of conformity	17
6.1	General	17
6.2	Type testing	17
6.3	Factory production control (FPC)	23
7	Designation	26
8	Marking, labelling and packaging	26

8.1	General	26
8.2	Additional marking	26
8.3	Dezincification resistant copper zinc alloys	27
Annex A (normative) Operating temperatures and corresponding maximum operating pressures ...		28
Bibliography		29