

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