

DIN EN 1254-7:2021-10 (E)

Copper and copper alloys - Plumbing fittings - Part 7: Press fittings for use with metallic 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 heating networks)	10
4.4 Release of dangerous substances	10
4.5 Durability	10
4.6 Wall thickness at threaded portions of adaptor fittings	11
4.7 Dimensions of tail pipe ends for swivel fittings	11
4.8 Dimensions of gas union connectors	11
4.9 Threaded end dimensions	11
4.10 Other adapter ends (not defined in EN 1254-20:2021)	11
4.11 Bore dimensions	12
4.12 Identity of elastomeric sealing material for liquid applications	12
4.13 Identity of elastomeric sealing material for gas applications	12
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	13
5 Testing, assessment and sampling methods	13
5.1 General	13
5.2 Internal pressure	13
5.3 Tightness	14
5.4 Durability	16
5.5 Wall thickness at threaded portions of adaptor fittings	17
5.6 Dimensions of tail pipe ends for swivel fittings	17
5.7 Dimensions of gas union connectors	17
5.8 Threaded end dimensions	18
5.9 Bore dimensions	18
5.10 Identity of elastomeric sealing material for liquid applications	18
5.11 Identity of elastomeric sealing material for gas applications	18
5.12 Alignment of the fitting ends	18
6 Evaluation of conformity	18
6.1 General	18
6.2 Type testing	19
6.3 Factory production control (FPC)	25
7 Designation	29

8	Marking, labelling and packaging	29
8.1	General	29
8.2	Additional marking	29
8.3	Dezincification resistant copper zinc alloys	30
Annex A (normative)	Maximum operating temperatures and corresponding maximum operating pressures	31
Annex B (normative)	Minimum nominal wall thicknesses of copper tube with R220, R250 and R290 temper conforming to EN 1057 suitable for jointing by press fittings	32
Bibliography		34