

DIN EN 1254-4:2021-10 (E)

Copper and copper alloys - Plumbing fittings - Part 4: Threaded fittings

Contents	Page
European foreword	3
Introduction	4
1 Scope	5
2 Normative references	5
3 Terms and definitions	6
4 Product characteristics	6
4.1 Internal pressure	6
4.2 Tightness	6
4.3 Resistance to high temperature (for heating networks)	6
4.4 Release of dangerous substances	7
4.5 Durability	7
4.6 Wall thickness at threaded portions of fittings	7
4.7 Dimensions of tail pipe ends for swivel fittings	7
4.8 Dimensions of gas union connectors	8
4.9 Threaded end dimensions	8
4.10 Other adapter ends (not defined in EN 1254-20:2021)	8
4.11 Bore dimensions	8
4.12 Alignment of the fitting ends	8
4.13 Shapes for tightening systems	8
4.14 Surface condition	8
4.15 Plated or coated surfaces	8
5 Testing, assessment and sampling methods	9
5.1 General	9
5.2 Internal pressure	9
5.3 Tightness: Integrity of fabricated fitting bodies or having an 'as cast' microstructure	9
5.4 Durability	9
5.5 Wall thickness at threaded portions of adaptor fittings	10
5.6 Dimensions of tail pipe ends for swivel fittings	10
5.7 Dimensions of gas union connectors	10
5.8 Threaded end dimensions	10
5.9 Bore dimensions	10
5.10 Alignment of the fitting ends	11
6 Evaluation of conformity	11
6.1 General	11
6.2 Type testing	11
6.3 Factory production control (FPC)	13
7 Designation	15
8 Marking, labelling and packaging	15
8.1 General	15
8.2 Dezincification resistant copper zinc alloys	15
Annex A (normative) Maximum operating temperatures and maximum operating pressures	16
Bibliography	18