

DIN EN 1254-3:2025-04 (E)

Copper and copper alloys - Plumbing fittings - Part 3: Compression fittings for use with plastics and multilayer pipes (includes Amendment A1:2025)

Contents		Page
European foreword.....		4
Introduction		6
1	Scope.....	7
2	Normative references.....	8
3	Terms and definitions	10
4	Product characteristics.....	10
4.1	Internal pressure	10
4.2	Tightness.....	10
4.3	Resistance to high temperature for fittings with elastomeric seals (for heating networks).....	11
4.4	Release of dangerous substances.....	11
4.5	Durability.....	12
4.6	Wall thickness at the threaded portions of fittings and/or compression nut	12
4.7	Dimensions of tail pipe ends for swivel fittings.....	12
4.8	Dimensions of gas union connectors	13
4.9	Threaded end dimensions	13
4.10	Other adapter ends (not defined in A1 EN 1254-20:2021+A1:2025 A1).....	13
4.11	Bore dimensions.....	13
4.12	Identity of elastomeric sealing material for liquid applications	13
4.13	Identity of elastomeric sealing material for gas applications.....	13
4.14	Pipe abutment	14
4.15	Alignment of the fitting ends.....	14
4.16	Shapes for tightening systems.....	14
4.17	Surface condition	14
4.18	Plated or coated surfaces	14
4.19	A1 Wall thickness of the fitting body A1	14
5	Testing, assessment and sampling methods	14
5.1	General.....	14
5.2	Internal pressure	15
5.3	Tightness.....	16
5.4	Durability.....	20
5.5	Wall thickness at threaded portions of adaptor fittings.....	20
5.6	Dimensions of tail pipe ends for swivel fittings.....	21
5.7	Dimensions of gas union connectors	21
5.8	Threaded end dimensions	21
5.9	Bore dimensions.....	21
5.10	Identity of elastomeric sealing material for liquid applications	21
5.11	Identity of elastomeric sealing material for gas applications.....	21
5.12	Alignment of the fitting ends.....	21
5.13	A1 Wall thickness of the fitting body A1	22
6	Evaluation of conformity	22
6.1	General.....	22
6.2	Type testing.....	22
6.3	Factory production control (FPC)	28

7	Designation.....	31
8	Marking, labelling and packaging	31
8.1	General.....	31
8.2	Additional marking.....	31
8.3	Dezincification resistant copper zinc alloys	32
	Annex A (normative) Operating temperatures and design pressures	33
	Bibliography	35