DIN EN 1254-1:2021-10 (E)

Copper and copper alloys - Plumbing fittings - Part 1: Capillary fittings for soldering or brazing to copper tubes

Contents

Page

European foreword 4

Introduction 5

1 Scope 6

2 Normative references 7

3 Terms and definitions 7

4 Product characteristics 8
4.1 Internal pressure 8
4.2 Tightness 8
4.3 Release of dangerous substances 8
4.4 Durability 8
4.5 Dimensional tolerances of diameters to achieve reliable capillary flow 9
4.6 Wall thickness for ends for capillary soldering or capillary brazing to copper tubes 11
4.7 Wall thickness at threaded portions of adaptor fittings 13
4.8 Dimensions of tail pipe ends for swivel fittings 13
4.9 Dimensions of gas union connectors 13
4.10 Threaded end dimensions 13
4.11 Other adapter ends (not defined in EN 1254-20:2021) 13
4.12 Length of engagement 13
4.13 Bore dimensions 16
4.14 Tube abutment 16
4.15 Alignment of the fitting ends 16
4.16 Shapes for tightening systems 16
4.17 Surface condition 16
4.18 Surface cleanliness for medical gases 17
4.19 Plated or coated surfaces 17

5 Testing, assessment and sampling methods 17
5.1 General 17
5.2 Internal pressure 17
5.3 Tightness: Integrity of fabricated fitting bodies or having an 'as cast' microstructure 18
5.4 Durability 18
5.5 Dimensional tolerances of diameters 18
5.6 Wall thickness for ends for capillary soldering or capillary brazing to copper tubes 18
5.7 Wall thickness at threaded portions of adaptor fittings 19
5.8 Dimensions of tail pipe ends for swivel fittings 19
5.9 Dimensions of gas union connectors 19
5.10 Threaded end dimensions 19
5.11 Length of engagement 19
5.12 Bore dimension 19
5.13 Alignment of the fitting ends 20

6 Evaluation of conformity 20
6.1 General 20
6.2 Type testing 20
6.3 Factory production control (FPC) 22

7 Designation 25

8 Marking, labelling and packaging 25
8.1 General 25
8.2 Dezincification resistant copper zinc alloys 25

Annex A (normative) Operating temperatures and corresponding maximum operating pressures ... 26

Bibliography 27