

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 |