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