
**Plastics piping systems for hot and cold
water installations — Crosslinked
polyethylene (PE-X) —**

**Part 3:
Fittings**

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*Systèmes de canalisations en plastique pour les installations d'eau
chaude et froide — Polyéthylène réticulé (PE-X) —*

Partie 3: Raccords

ISO 15875-3:2003

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15875-3 was prepared by the European Committee for Standardization (CEN) in collaboration with Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 2, *Plastics pipes and fittings for water supplies*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Throughout the text of this document, read “...this European Standard...” to mean “...this International Standard...”.

[ISO 15875-3:2003](http://www.iso.org/iso/15875-3:2003)

ISO 15875 consists of the following parts, under the general title *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X)*: 15875-3-2003

- *Part 1: General*
- *Part 2: Pipes*
- *Part 3: Fittings*
- *Part 5: Fitness for purpose of the system*
- *Part 7: Guidance for the assessment of conformity* [Technical Specification]

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Foreword

This document (EN ISO 15875-3:2003) has been prepared by Technical Committee CEN/TC 155 "Plastics piping systems and ducting systems", the secretariat of which is held by NEN, in collaboration with Technical Committee ISO/TC 138 "Plastics pipes, fittings and valves for the transport of fluids".

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2004, and conflicting national standards shall be withdrawn at the latest by December 2005.

NOTE This draft was submitted for CEN enquiry as prEN 12318-3:1996.

This standard is part of a System Standard for plastics piping systems of a particular material for a specified application. There are a number of such System Standards.

System Standards are based on the results of the work being undertaken in ISO/TC 138 "Plastics pipes, fittings and valves for the transport of fluids", which is a Technical Committee of the International Organisation for Standardization (ISO).

They are supported by separate Standards on test methods to which references are made throughout the System Standard.

The System Standards are consistent with general standards on functional requirements and recommended practices for installation.

EN ISO 15875 consists of the following Parts ¹⁾, under the general title: *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X)*

- Part 1: *General*
- Part 2: *Pipes* <https://standards.iteh.ai/catalog/standards/sist/89d5567-aa97-4f0a-bb8c-89ac6e7af44/iso-15875-3-2003>
- Part 3: *Fittings (the present standard)*
- Part 5: *Fitness for purpose of the system*
- Part 7: *Guidance for the assessment of conformity* (published as CEN ISO/TS 15875-7).

This Part of EN ISO 15875 includes a Bibliography

At the date of publication of this standard, System Standards for piping systems of other plastics materials used for the same application include the following:

EN ISO 15874, *Plastics piping systems for hot and cold water installations — Polypropylene (PP)* (ISO 15874:2003)

EN ISO 15876, *Plastics piping systems for hot and cold water installations — Polybutylene (PB)* (ISO 15876:2003)

EN ISO 15877, *Plastics piping systems for hot and cold water installations — Chlorinated poly(vinyl chloride) (PVC-C)* (ISO 15877:2003)

For pipes and fittings which have conformed to the relevant national standard before 1st November 2003, as shown by the manufacturer or by a certification body, the national standard may continue to apply until 30th November 2005.

¹⁾ This System Standard does not incorporate a Part 4 *Ancillary equipment* or a Part 6 *Guidance for installation*. For ancillary equipment separate standards can apply. Guidance on installation of plastics piping systems made from different materials intended to be used for hot and cold water installations is given by ENV 12108 ^[1].

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and the United Kingdom.

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Introduction

The System Standard of which this is Part 3, specifies the requirements for a piping system when made from polypropylene (PE-X). The piping system is intended to be used for hot and cold water installations.

In respect of potential adverse effects on the quality of water intended for human consumption, caused by the product covered by this standard:

- This standard provides no information as to whether the product may be used without restriction in any of the Member States of the EU or EFTA;
- It should be noted that, while awaiting the adoption of verifiable European criteria, existing national regulations concerning the use and/or the characteristics of this product remain in force.

Requirements and test methods for materials and components, other than fittings, are specified in Part 1 and Part 2 of EN ISO 15875:2003. Characteristics for fitness for purpose (mainly for joints) are covered in Part 5. Part 7 (CEN ISO/TS 15875-7) gives guidance for the assessment of conformity.

This Part of EN ISO 15875 specifies the characteristics of the fittings.

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1 Scope

This Part of EN ISO 15875 specifies the characteristics of fittings for crosslinked polyethylene (PE-X) piping systems intended to be used for hot and cold water installations within buildings for the conveyance of water, whether or not intended for human consumption, (domestic systems) and for heating systems, under design pressures and temperatures appropriate to the class of application (see Table 1 of EN ISO 15875-1:2003).

This standard covers a range of service conditions (application classes) and design pressure classes. For values of T_D , T_{max} and T_{mal} in excess of those in Table 1 of Part 1, this standard does not apply.

NOTE It is the responsibility of the purchaser or specifier to make the appropriate selections from these aspects, taking into account their particular requirements and any relevant national regulations and installation practices or codes.

It also specifies the test parameters for the test methods referred to in this standard.

In conjunction with the other Parts of EN ISO 15875:2003 (see Foreword) it is applicable to fittings made from crosslinked polyethylene (PE-X) and to fittings made from other materials which are intended to be fitted to pipes conforming to EN ISO 15875-2:2003 for hot and cold water installations and whereby the joints conform to the requirements of EN ISO 15875-5.

This standard is applicable to fittings of the following types:

- mechanical fittings; <https://standards.iteh.ai/catalog/standards/sist/8f9d5567-aa97-4f0a-bb8c-871ae6e7af44/iso-15875-3-2003>
- electrofusion fittings;
- fittings with incorporated inserts.

2 Normative references

This Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 578, *Plastics piping systems — Plastics pipes and fittings — Determination of the opacity*

ISO 15875-3:2003(E)

EN 579, *Plastics piping systems — Crosslinked polyethylene (PE-X) pipes — Determination of degree of crosslinking by solvent extraction*

EN 681-1, *Elastomeric seals — Materials requirements for pipe joint seals used in water and drainage applications — Part 1: Vulcanized rubber*

EN 681-2, *Elastomeric seals — Material requirements for pipe joint seals used in water and drainage applications — Part 2: Thermoplastic elastomers*

EN 921:1994, *Plastics piping systems — Thermoplastics pipes — Determination of resistance to internal pressure at constant temperature*

EN 1254-3, *Copper and copper alloys — Plumbing fittings — Part 3: Fittings with compression ends for use with plastics pipes*

EN 10088-1, *Stainless steels — Part 1: List of stainless steels*

prEN 10226-1, *Pipe threads where pressure-tight joints are made on the threads — Part 1: Taper external threads and parallel internal threads — Dimensions, tolerances and designation*

EN 12107, *Plastics piping systems — Injection-moulded thermoplastics fittings, valves and ancillary equipment — Determination of the long-term hydrostatic strength of thermoplastics materials for injection- moulding piping components*

EN ISO 228-1, *Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions, tolerances and designation*

EN ISO 3126, *Plastics piping systems — Plastics components — Determination of dimensions (ISO:2003)*

EN ISO 9080, *Plastics piping and ducting systems — Determination of the long-term hydrostatic strength of thermoplastics materials in pipe form by extrapolation (ISO 9080:2003)*

EN ISO 15875-1:2003, *Plastics piping system for hot and cold water installations — Crosslinked polyethylene (PE-X) — Part 1: General (ISO 15875-1:2002)* [ISO 15875-3:2003](https://standards.iteh.ai/catalog/standards/sist/8f9d5567-aa97-4f0a-bb8c-)

EN ISO 15875-2:2003, *Plastics piping system for hot and cold water installations — Crosslinked polyethylene (PE-X) — Part 2: Pipes (ISO 15875-2:2002)*

EN ISO 15875-5 *Plastics piping system for hot and cold water installations — Crosslinked polyethylene (PE-X) — Part 5: Fitness for purpose of the system (ISO 15875-5:2002)*

ISO 12092, *Fittings, valves and other piping system components made of unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly(vinyl chloride) (PVC-C), acrylonitrile-butadiene-styrene (ABS) and acrylonitrile-styrene-acrylester (ASA) for pipes under pressure — Resistance to internal pressure — Test method*

3 Terms and definitions, symbols and abbreviated terms

For the purposes of this standard, terms and definitions, symbols and abbreviated terms given in EN ISO 15875-1:2003 apply together with the following terms and definitions:

3.1 Mechanical fittings

3.1.1

compression fitting

fitting in which the joint is made by the compression of a ring or sleeve on the outside wall of the pipe with or without additional sealing elements and with internal support

3.1.2

crimped fitting

fitting in which the joint is made by compression of the fitting and/or a ring on the outside wall of the pipe by means of a special tool

3.1.3**flanged fitting**

fitting in which the pipe connection consists of two mating flanges which are mechanically pressed together and sealed by the compression of an elastomeric sealing element between them

3.1.4**flat seat union fitting**

fitting in which the pipe connection consists primarily of two components, at least one of which normally incorporates a flat sealing surface, which are mechanically pressed together by means of a screwed nut or similar and sealed by the compression of an elastomeric sealing element between them

3.2**electrofusion fitting**

fitting in which the joint with the pipe is made by melting together the outer part of the pipe and the inner part of the fitting by means of heat induced by current flowing in an appropriate resistor inserted in the fitting body

3.3**fitting with incorporated inserts**

fitting in which the joints is made by means of connecting threads or other outlets, inserted in the plastics body combined with fusion ends for electrofusion

4 Material characteristics

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4.1 Plastics fitting material

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4.1.1 Fitting material identical to PE-X pipe material

The material from which fittings are made shall conform to the requirements as specified for pipes in EN ISO 15875-2:2003.

When tested in accordance with the test method as specified in Table 1 using the indicated parameters, injection moulded tubular test pieces shall withstand the hydrostatic (hoop) stress without bursting or leakage.

Table 1 — Mechanical characteristics of tubular test pieces made of PE-X by injection moulding

Characteristic	Requirement	Test parameters for the individual tests				Test method
		Hydrostatic (hoop) stress	Test temp.	Test period	Number of test pieces	
Resistance to internal pressure	No bursting or leakage during the test period	MPa	°C	h		EN 921:1994 (together with EN 12107)
		12,0	20	1	3	
		4,8	95	1	3	
		4,4	95	1000	3	
		Test parameters for all tests				
Sampling procedure			a			
Type of end cap			Type a)			
Orientation of test piece			Not specified			
Type of test			Water-in -water			
a The sampling procedure is not specified. For guidance see CEN ISO/TS 15875-7 [2].						