

---

---

## Industrial valves — Gate valves of thermoplastics materials

*Robinetterie industrielle — Robinets-vannes en matériaux  
thermoplastiques*

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

[ISO 16139:2006](https://standards.iteh.ai/catalog/standards/sist/74ede04e-a108-4db0-8259-c7359d7c5956/iso-16139-2006)

[https://standards.iteh.ai/catalog/standards/sist/74ede04e-a108-4db0-8259-  
c7359d7c5956/iso-16139-2006](https://standards.iteh.ai/catalog/standards/sist/74ede04e-a108-4db0-8259-c7359d7c5956/iso-16139-2006)



Reference number  
ISO 16139:2006(E)

**PDF disclaimer**

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

**iTeh STANDARD PREVIEW**  
**(standards.iteh.ai)**

ISO 16139:2006

<https://standards.iteh.ai/catalog/standards/sist/74ede04e-a108-4db0-8259-c7359d7c5956/iso-16139-2006>

© ISO 2006

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Case postale 56 • CH-1211 Geneva 20  
Tel. + 41 22 749 01 11  
Fax + 41 22 749 09 47  
E-mail [copyright@iso.org](mailto:copyright@iso.org)  
Web [www.iso.org](http://www.iso.org)

Published in Switzerland

# Contents

Page

Foreword.....	iv
1 Scope .....	1
2 Normative references .....	1
3 Terms and definitions.....	2
4 Requirements .....	4
4.1 Design .....	4
4.2 Materials .....	5
4.3 Pressure/temperature rating.....	5
4.4 Dimensions.....	6
4.5 Operation .....	7
4.6 Functional characteristics .....	7
4.7 Manufacture.....	8
4.8 Other requirements.....	8
5 Test procedures .....	9
5.1 Documentation of test results .....	9
5.2 Initial type tests.....	9
6 Declaration of compliance .....	10
7 Designation .....	10
8 Marking and preparation for storage and transportation .....	11
8.1 Marking and documentation.....	11
8.2 Preparation for storage and transportation .....	12
Annex A (informative) Procurement information .....	13
Bibliography .....	14

## 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 16139 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 69, *Industrial valves*, in collaboration with ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 7, *Valves and auxiliary equipment of plastics materials*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

ISO 16139:2006  
<https://standards.iteh.ai/catalog/standards/sist/74ede04e-a108-4db0-8259-c7359d7c5956/iso-16139-2006>

# Industrial valves — Gate valves of thermoplastics materials

## 1 Scope

This International Standard specifies requirements for the design, functional characteristics and manufacture of gate valves made of thermoplastics materials intended for isolating service, their connection to the pipe system, the body materials and their pressure/temperature rating between  $-40\text{ }^{\circ}\text{C}$  and  $+120\text{ }^{\circ}\text{C}$ , for a lifetime of 25 years, and also specifies their tests.

This International Standard is applicable to hand- or power-operated valves to be installed in industrial pipe systems, irrespective of the field of application and the fluids to be conveyed.

NOTE 1 Industrial pipe systems also include systems for water supply for general purposes, drainage and sewerage.

NOTE 2 Special requirements can apply to pipe systems for water for human consumption.

This International Standard is concerned with the range of DN

DN 10, DN 15, DN 20, DN 25, DN 40, DN 50, DN 65, DN 80, DN 100, DN 125, DN 150, DN 200, DN 250, DN 300 and DN 350.

and the range of PN and Class

ISO 16139:2006  
<https://standards.iteh.ai/catalog/standards/sist/74ede04e-a108-4db0-8259-c7559d7c5956/iso-16139-2006>  
PN 6, PN 10, PN 16, and Class 150.

## 2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 7-1:1994, *Pipe threads where pressure-tight joints are made on the threads — Part 1: Dimensions, tolerances and designation*

ISO 228-1:2000, *Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions, tolerances and designation*

ISO 898-1:1999, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 1: Bolts, screws and studs*

ISO 5210:1991, *Industrial valves — Multi-turn valve actuator attachments*

ISO 8233:1988, *Thermoplastics valves — Torque — Test method*

ISO 8659:1989, *Thermoplastic valves — Fatigue strength — Test method*

ISO 9393-2:2005, *Thermoplastics valves for industrial applications — Pressure test methods and requirements — Part 2: Test conditions and basic requirements*

ISO/TR 10358:1993, *Plastics pipes and fittings — Combined chemical-resistance classification table*

ISO 10931:2005, *Plastics piping systems for industrial applications — Poly(vinylidene fluoride) (PVDF) — Specifications for components and the system*

ISO 12092:2000, *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*

ISO 12162:1995, *Thermoplastics materials for pipes and fittings for pressure applications — Classification and designation — Overall service (design) coefficient*

ISO 15493:2003, *Plastics piping systems for industrial applications — Acrylonitrile-butadiene-styrene (ABS), unplasticized poly(vinyl chloride) (PVC-U) and chlorinated poly(vinyl chloride) (PVC-C) — Specifications for components and the system — Metric series*

ISO 15494:2003, *Plastics piping systems for industrial applications — Polybutene (PB), polyethylene (PE) and polypropylene (PP) — Specifications for components and the system — Metric series*

EN 558-1:1995, *Industrial valves — Face-to-face and centre-to-face dimensions of metal valves for use in flanged pipe systems — Part 1: PN-designated valves*

EN 558-2:1995, *Industrial valves — Face-to-face and centre-to-face dimensions of metal valves for use in flanged pipe systems — Part 2: Class-designated valves*

EN 736-1:1995, *Valves — Terminology — Part 1: Definition of types of valves*

EN 736-2:1997, *Valves — Terminology — Part 2: Definition of components of valves*

EN 736-3:1999, *Valves — Terminology — Part 3: Definition of terms*

EN 1092-1:2001, *Flanges and their joints — Circular flanges for pipes, valves, fittings and accessories, PN designated — Part 1: Steel flanges*

EN 1267:1999, *Valves — Test of flow resistance using water as test fluid*

EN 1759-1:2004, *Flanges and their joints — Circular flanges for pipes, valves, fittings and accessories, Class designated — Part 1: Steel flanges, NPS ½ to 24*

EN 12107:1997, *Plastics piping systems — Injection-moulded thermoplastics fittings, valves and ancillary equipment — Determination of the long-term hydrostatic strength of thermoplastics materials for injection moulding of piping components*

EN 12266-1:2003, *Industrial valves — Testing of valves — Part 1: Pressure tests, test procedures and acceptance criteria — Mandatory requirements*

EN 12570:2000, *Industrial valves — Method for sizing the operating element*

### 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 736-1, EN 736-2 and EN 736-3 and the following apply.

NOTE Other terms and definitions relative to thermoplastics materials are given in ISO 15493, ISO 15494 and ISO 10931.

**3.1****nominal size****DN**

alphanumeric designation of size for components of a pipework system, which is used for reference purposes, comprising the letters DN followed by a dimensionless whole number which is indirectly related to the physical size, in millimetres, of the bore or outside diameter of the end connections

[ISO 6708:1995, definition 2.1]

**3.2****nominal pressure****PN**

numerical designation relating to pressure that is a convenient round number for reference purposes

NOTE 1 It is intended that all equipment of the same nominal size (DN) designated by the same PN number have the same mating dimensions appropriate to the type of end connections.

NOTE 2 The permissible working pressure depends upon materials, design and working temperature and is to be selected from the pressure/temperature rating tables in corresponding standards.

[ISO 7268:1983, Clause 2]

**3.3****Class**

alphanumeric designation used for reference purposes related to a combination of mechanical and dimensional characteristics of a component of a pipework system, which comprises the word "Class" followed by a dimensionless whole number

NOTE The number following the word "Class" does not represent a measurable value and is not intended to be used for calculation purposes except where specified in the relevant standard.

**3.4****allowable maximum operating pressure****PMA**

maximum pressure occurring from time to time, including surge, that a component is capable of withstanding in service

[EN 805:2000, definition 3.1.1]

NOTE EU Directive 97/23/EC (PED) designates PS (maximum allowable pressure) irrespective of temperature. The values of PMA and PS are identical at 20 °C.

**3.5****trim**

inside parts of the valve in contact with the fluid

NOTE Adapted from EN 736-2:1997, definition 3.2.

**3.6****rating factor** $f_r$ 

rating factor used in the relationship between PMA and PN or Class and to calculate the PMA at temperatures other than 20 °C

**3.7****manual forces** $F$  and  $F_s$ 

operating manual force ( $F$ ) and maximum manual force ( $F_s$ ) which one person is capable of applying to the manual operating element of a valve

NOTE Adapted from EN 12570:2000.

## 4 Requirements

### 4.1 Design

#### 4.1.1 Valve function

Gate valves in accordance with this International Standard shall be suitable for isolating service.

#### 4.1.2 Design characteristics

Valves shall have the following design characteristics:

- a) a symmetrical design of valve obturation suitable for both flow directions;
- b) a body bore that is either
  - full bore i.e. not less than 90 % of DN expressed in millimetres (mm), or
  - reduced bore, in which case the manufacturer shall declare the actual bore diameter;
- c) a system of obturation which, in the fully open position, does not intrude into the bore;
- d) a soft seat method of obturation with sealing elements on the obturator or in the valve body;
- e) a stem sealing system by a stuffing box or by self-sealing elements.

#### 4.1.3 Types of valve end connection

The types of valve end connection can be chosen from the following alternatives:

- butt or socket fusion ends;
- spigot ends for cementing or for welding;
- socket ends for electro-fusion;
- socket ends for heated tool welding;
- socket ends for cementing;
- socket ends for/with elastomeric seal rings;
- flanged ends;
- wafer type ends;
- threaded ends;
- union ends.

Other types of end connection are possible.

All valve ends shall be an integral part of, or threaded onto, the valve body. Different types of end connection on one body are possible.



## 4.2 Materials

### 4.2.1 Materials for the body and bonnet/cover

The valve body and bonnet/cover materials may be selected from ISO 15493 or ISO 15494 or ISO 10931, and shall be in accordance with the requirements of the relevant above International Standard:

- ABS;
- PE;
- PP;
- PVC-C;
- PVC-U;
- PVDF.

If other body and bonnet/cover materials are used, the manufacturer shall ensure that these materials fulfil adequate requirements (such as those contained in the above International Standards for the above materials).

The bolting material between body and bonnet/cover shall be selected according to ISO 898-1.

### 4.2.2 Materials for other valve components

The choice of the materials for the disc or wedge and all other internal components shall be the responsibility of the manufacturer. Design of these components shall ensure the mechanical integrity of the valve and shall be tested as specified in 5.2. A component failing any test according to 5.2 is not in conformity with the requirements of this International Standard.

## 4.3 Pressure/temperature rating

The valve body shall be designed in accordance with the MRS values as defined in ISO 12162 for the material specified in 4.2.1, and rated for PN 6, PN 10, PN 16 or Class 150.

The PMA, in relation to the working temperature of the complete valve, depends not only on the pressure/temperature ( $p/t$ ) rating of the valve body material, but also on the valve design, and can be different from the  $p/t$  rating of the shell material. The PMA for thermoplastics valves shall be determined using a rating factor  $f_r$  as follows:

$$\text{PMA} = f_r \times \text{PN [in bar}^1\text{]} \text{ or } \text{PMA} = f_r \times \text{Class [in psi}^2\text{]}$$

The minimum values for the rating factor  $f_r$  for valves shall be as specified in Table 1 and are valid for

- the relevant body material,
- a lifetime of 25 years, and
- fluids without any effect on the physical and chemical characteristics of the valve materials in contact with the fluid.

1) 1 bar = 0,1 MPa =  $10^5$  Pa; 1 MPa = 1 N/mm<sup>2</sup>.

2) Pounds per square inch.

NOTE For applications with lifetimes other than 25 years and/or with fluids with any effect on the physical and/or chemical characteristics of the valve body, the rating factor  $f_r$  is usually established by the manufacturer.

Table 1 gives the minimum rating factors and the allowable temperature range for the valve body materials.

If the choice of materials of the trim parts (e.g. obturator, seals) limits the maximum allowable temperature of the complete valve to less than the values given in Table 1, then this limitation shall be marked as specified in item 8 of Table 2.

The  $p/t$  rating factor for each valve type and each shell material shall be declared by the manufacturer.

**Table 1 — Minimum values for rating factor  $f_r$  for a lifetime up to 25 years**

Temperature °C	Minimum rating factor $f_r$ for body material					
	ABS	PE	PP	PVC-C	PVC-U	PVDF
– 40	1,0	1,0	—	—	—	a
– 30	1,0	1,0	—	—	—	a
– 20	1,0	1,0	—	—	—	1,0
– 10	1,0	1,0	—	—	—	1,0
0	1,0	1,0	—	—	—	1,0
+ 5	1,0	1,0	1,0	—	—	1,0
10	1,0	1,0	1,0	1,0	1,0	1,0
20	1,0	1,0	1,0	1,0	1,0	1,0
25	1,0	1,0	1,0	1,0	1,0	1,0
30	0,8	0,76	0,85	0,85	0,80	0,9
40	0,6	0,53	0,70	0,65	0,60	0,8
50	0,4	0,35	0,55	0,50	0,35	0,71
60	0,2	0,24	0,40	0,35	0,15	0,63
70	—	—	0,27	0,25	—	0,54
80	—	—	0,15	0,15	—	0,47
90	—	—	0,08	a	—	0,36
100	—	—	a	—	—	0,25
110	—	—	—	—	—	0,17
120	—	—	—	—	—	0,12
130	—	—	—	—	—	a
140	—	—	—	—	—	a

NOTE These values do not coincide with the relevant factors for pipes and fittings.

<sup>a</sup> A rating factor for this temperature may be declared by the manufacturer.

## 4.4 Dimensions

### 4.4.1 Face-to-face dimensions

The face-to-face dimensions of valves for use in flanged pipe systems shall be selected from

- EN 558-1 for PN designated flanges,
- EN 558-2 for Class designated flanges.

For all other types of end connection, the face-to-face dimensions shall be the responsibility of the manufacturer.

#### 4.4.2 Joint dimensions of the valve end connections

The joint dimensions for use in flanged valve end connections shall be in accordance with

- EN 1092-1 for PN designated flanges,
- EN 1759-1 for Class designated flanges.

The joint dimensions of valves to be connected by threaded ends shall be in accordance with ISO 7-1 or ISO 228-1.

The joint dimensions for other end connections shall be, as applicable, in accordance with ISO 15493, ISO 15494 and ISO 10931. If connections not defined in the above International Standards, but specified in 4.1.3, are selected, the manufacturer shall declare the joint dimensions.

#### 4.5 Operation

Hand-operated valves shall be

- closed clockwise when viewed from above,
- provided with a position indicator, and
- limited by a mechanical stop at the open position.

Gear- and power-operated valves shall

- be limited by a mechanical stop device at the open position, and
- have actuator attachments in accordance with the requirements of ISO 5210.

Valve actuators of a compact design which are integrated in the valve may be excepted from this requirement.

#### 4.6 Functional characteristics

##### 4.6.1 Design strength

For each valve body material, the shell design strength shall conform to ISO 9393-2:2005,

- Clause 5, for the shell test, and
- Clause 6, for the long-term behaviour test of the complete valve.

##### 4.6.2 Flow characteristics

If the body bore is less than 90 % of DN, the manufacturer shall specify the  $k_v$  values according to EN 1267 for the fully open position.

##### 4.6.3 Seat and shell leaktightness

The seat and shell leaktightness shall be in accordance with the requirements of ISO 9393-2:2005, Clause 7.

##### 4.6.4 Operating torque

The manufacturer shall declare the operating torque values allowed to fully open and fully close a valve at a differential pressure equal to the PN, in bar (or equal to the Class, in psi).