
**Plastics piping systems for soil and
waste discharge (low and high
temperature) inside buildings —
Polypropylene (PP)**

*Systèmes de canalisations en plastique pour l'évacuation des eaux-
vannes et des eaux usées (à basse et à haute température) à l'intérieur
des bâtiments — Polypropylène (PP)*

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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 7671 was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 1, *Plastics pipes and fittings for soil, waste and drainage (including land drainage)*.

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This second edition cancels and replaces the first edition (ISO 7671:1991), which has been technically revised.

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Introduction

Pipes and fittings conforming to this International Standard also meet the requirements of EN 1451-1 which are applicable to those pipes and fittings which, according to EN 1451-1, are intended to be used inside buildings (application area code “B”, see EN 1451-1) only.

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Plastics piping systems for soil and waste discharge (low and high temperature) inside buildings — Polypropylene (PP)

1 Scope

This International Standard specifies the requirements for solid-wall polypropylene (PP) pipes and fittings for soil and waste discharge (low and high temperature) inside buildings, as well as the system itself. It does not include buried pipework.

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

This International Standard is applicable to PP pipes and fittings, as well as assemblies of such pipes and fittings, intended to be used for the following purposes:

- a) soil and waste discharge pipework for the conveyance of domestic waste waters (low and high temperature);
- b) ventilation pipework associated with a);
- c) rainwater pipework inside the building.

It is applicable to pipes and fittings for jointing by means of elastomeric sealing rings or by butt fusion.

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 265-1, *Pipes and fittings of plastics materials — Fittings for domestic and industrial waste pipes — Basic dimensions: Metric series — Part 1: Unplasticized poly(vinyl chloride) (PVC-U)*

ISO 1133:1997, *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics*

ISO 3126:—¹⁾, *Plastics piping systems — Plastics components — Determination of dimensions*

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 — Materials requirements for pipe joint seals used in water and drainage applications — Part 2: Thermoplastic elastomers*

EN 728, *Plastics piping and ducting systems — Polyolefin pipes and fittings — Determination of oxidation induction time*

1) To be published. (Revision of ISO 3126:1974)

ISO 7671:2003(E)

EN 743:1994, *Plastics piping and ducting systems — Thermoplastics pipes — Determination of the longitudinal reversion*

EN 744, *Plastics piping and ducting systems — Thermoplastics pipes — Test method for resistance to external blows by the round-the-clock method*

EN 763:1994, *Plastics piping and ducting systems — Injection-moulded thermoplastics fittings — Test method for visually assessing effects of heating*

EN 1053, *Plastics piping systems — Thermoplastics piping systems for non-pressure applications — Test method for watertightness*

EN 1054, *Plastics piping systems — Thermoplastics piping systems for soil and waste discharge — Test method for airtightness of joints*

EN 1055:1996, *Plastics piping systems — Thermoplastics piping systems for soil and waste discharge inside buildings — Test method for resistance to elevated temperature cycling*

EN 1411, *Plastics piping and ducting systems — Thermoplastics pipes — Determination of resistance to external blows by the staircase method*

3 Symbols and abbreviations

3.1 Symbols

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A length of engagement

B length of lead-in

C depth of sealing zone

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d_e outside diameter (at any point)

d_{em} mean outside diameter

d_n nominal outside diameter

d_s inside diameter of the socket

d_{sm} mean inside diameter of the socket

DN nominal size

DN/OD nominal size (outside-diameter related)

e wall thickness (at any point)

e_m mean wall thickness

e_2 wall thickness of the socket

e_3 wall thickness at the groove

L_1 length of spigot

l	effective length of a pipe
R	radius of swept fittings
z	design length (z -length) of a fitting
α	nominal angle of a fitting

3.2 Abbreviations

MFR	melt mass-flow rate
OIT	oxidation induction time
PP	polypropylene
PP-H	polypropylene homopolymer
TIR	true impact rate

4 Material

4.1 PP compound

The compound for pipes and fittings shall be PP-based material (homopolymer and/or copolymer) to which may be added those additives that are needed to facilitate the manufacture of components conforming to the requirements of this International Standard.

In order to conform to national requirements on fire regulations, other additives may be used.

Fabricated fittings or parts of fabricated fittings shall be made from pipes and/or mouldings conforming to this International Standard, except for the requirements for the wall thickness of fabricated fittings and/or mouldings from PP which conform to material, mechanical and physical characteristics as required in this International Standard.

4.2 Reprocessable and recyclable material

In addition to virgin material, the use of reprocessable material obtained during the production and testing of products conforming to this International Standard is permitted. External reprocessable or recyclable material shall not be used.

NOTE Definitions concerning materials are given in EN 1451-1.

4.3 Melt mass-flow rate

The MFR of the PP-based material shall be determined in accordance with ISO 1133:1999, set of conditions M (test temperature 230 °C, load 2,16 kg).

Pipes and fittings intended to be used for mechanical joints shall be made from materials with an MFR as follows:

$$\text{MFR}(230/2,16) \leq 3,0 \text{ g/10 min}$$

Materials for pipes and fittings for butt fusion joints shall be designated by the following classes with regard to the MFR:

Class A	$MFR \leq 0,3 \text{ g/10 min};$
Class B	$0,3 \text{ g/10 min} < MFR \leq 0,6 \text{ g/10 min};$
Class C	$0,6 \text{ g/10 min} < MFR \leq 0,9 \text{ g/10 min};$
Class D	$0,9 \text{ g/10 min} < MFR \leq 1,5 \text{ g/10 min}.$

Only pipes and fittings made from materials of the same or adjacent MFR classes may be fused together.

4.4 Thermal stability

When determined in accordance with EN 728, using a test temperature of 200 °C, the oxidation induction time (OIT) of the material shall be not less than 8 min.

NOTE Requirements for thermal stability are only applicable to materials for pipes and fittings intended for butt fusion.

4.5 Sealing ring retaining means

Sealing rings may be retained, using means made from plastics other than PP, provided the joints conform to the requirements given in Clause 9.

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4.6 Fire behaviour

No specific requirements are set by this International Standard for fire behaviour. Attention is drawn to the need to comply with any relevant national regulations in this respect.

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5 General characteristics

5.1 Appearance

When viewed without magnification, the following requirements shall be met:

- the internal and external surfaces of pipes and fittings shall be smooth, clean and free from grooving, blistering, impurities, pores or any other surface irregularity likely to prevent conformity of pipes and fittings to this International Standard;
- each end of a pipe or fitting shall be cleanly cut, if applicable, and shall be square to its axis.

5.2 Colour

Pipes and fittings shall be uniformly coloured through the whole wall.

The recommended colour for pipes and fittings is grey, black or white.

6 Geometrical characteristics

6.1 General

All dimensions shall be measured in accordance with ISO 3126.

The figures given in this International Standard are schematic sketches only, to indicate the relevant dimensions. They do not necessarily represent manufactured components. The dimensions given shall be conformed to.

6.2 Dimensions of pipes

6.2.1 Outside diameters

The mean outside diameter, d_{em} , shall conform to Table 1 or Table 2, as applicable.

Table 1 — Mean outside diameters
(metric series)

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Mean outside diameter d_{em}	
		min.	max.
32	32	32,0	32,3
40	40	40,0	40,3
50	50	50,0	50,3
63	63	63,0	63,3
75	75	75,0	75,4
80	80	80,0	80,4
90	90	90,0	90,4
100	100	100,0	100,4
110	110	110,0	110,4
125	125	125,0	125,4
160	160	160,0	160,5
200	200	200,0	200,6

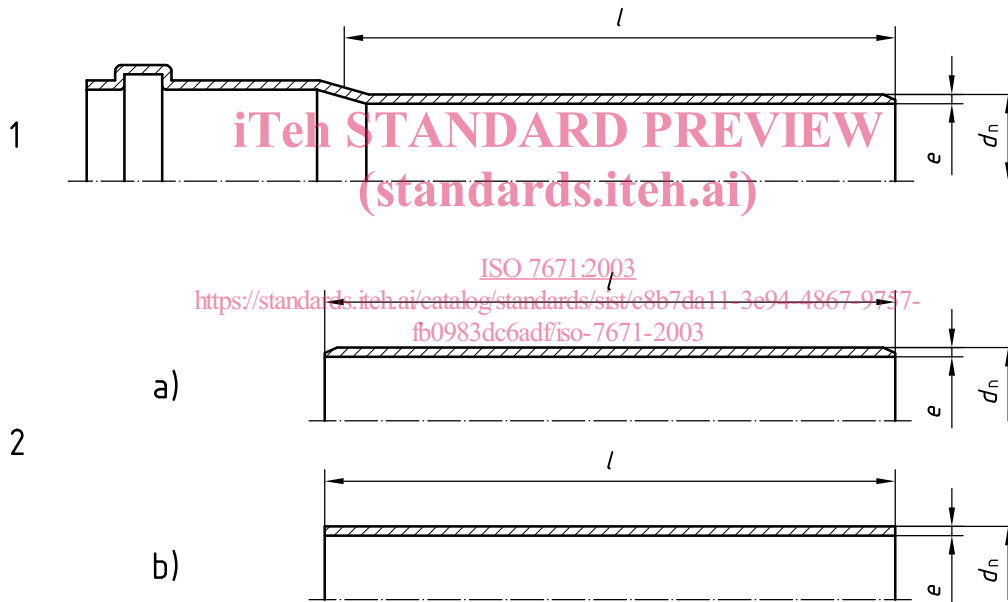
Table 2 — Mean outside diameters
(series based on inch dimensions)

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Mean outside diameter d_{em}	
		min.	max.
34	34	34,4	34,8
41	41	40,8	41,2
54	54	53,9	54,3

6.2.2 Effective length of pipes

The effective length, l , of a pipe shall not be less than that declared by the manufacturer and shall be measured as shown in Figure 1. For pipes with sockets, the effective length is considered to be the distance between the pipe ends minus the socket length. For practical reasons, this length is measured to the outside of the socket.



Key

- 1 single-socket pipe
- 2 plain-ended pipes
 - a) with chamfer
 - b) without chamfer

Figure 1 — Effective lengths of pipes

6.2.3 Chamfering

If a chamfer is applied, the angle of chamfering shall be between 15° and 45° to the axis of the pipe (see Figure 3). When pipes without a chamfer are used, the pipe ends shall be deburred.

The remaining wall thickness of the end of the pipe shall be at least 1/3 of e_{min} .