



SLOVENSKI STANDARD

SIST EN 12168:2016

01-oktober-2016

Nadomešča:
SIST EN 12168:2011

Baker in bakrove zlitine - Votle palice za obdelavo z odrezovanjem na avtomatih

Copper and copper alloys - Hollow rod for free machining purposes

Kupfer und Kupferlegierungen - Hohlstangen für die spanende Bearbeitung

Cuivre et alliages de cuivre — Barres creuses pour décolletage

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Ta slovenski standard je istoveten z: EN 12168:2016

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ICS:

77.150.30

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EUROPEAN STANDARD
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Copper and copper alloys - Hollow rod for free machining purposes

Cuivre et alliages de cuivre - Barres creuses pour
décolletage

Kupfer und Kupferlegierungen - Hohlstangen für die
spanende Bearbeitung

This European Standard was approved by CEN on 9 April 2016.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

Contents

Page

European foreword.....	4
Introduction	6
1 Scope	7
2 Normative references	7
3 Terms and definitions	7
4 Designations.....	9
4.1 Material.....	9
4.1.1 General.....	9
4.1.2 Symbol.....	9
4.1.3 Number	9
4.2 Material condition	9
4.3 Product.....	9
5 Ordering information	13
6 Requirements	15
6.1 Composition	15
6.2 Mechanical properties.....	15
6.3 Resistance to dezincification	15
6.4 Residual stress level.....	15
6.5 Dimensions and tolerances	15
6.5.1 Diameter or width across-flats.....	15
6.5.2 Tolerance on wall thickness.....	15
6.5.3 Eccentricity.....	16
6.5.4 Shape tolerances	16
6.5.5 Straightness.....	16
6.5.6 Length.....	16
6.5.7 Corner radii.....	16
6.5.8 Twist of polygonal hollow rod	16
6.6 Surface quality.....	17
7 Sampling.....	17
7.1 General.....	17
7.2 Analysis.....	17
7.3 Mechanical tests	18
7.4 Dezincification resistance and stress corrosion resistance tests.....	18
8 Test methods	18
8.1 Analysis.....	18
8.2 Tensile test	18
8.2.1 General.....	18
8.2.2 Location of test pieces	18
8.2.3 Shape and size of test pieces	19
8.2.4 Procedure for testing.....	19
8.2.5 Determination of results	19
8.3 Hardness test	19

8.4	Dezincification resistance test.....	19
8.5	Stress corrosion resistance test	19
8.6	Retests	19
8.6.1	Analysis, tensile, hardness and dezincification resistance tests.....	19
8.6.2	Stress corrosion resistance test	20
8.7	Rounding of results.....	20
9	Declaration of conformity and inspection documentation	20
9.1	Declaration of conformity.....	20
9.2	Inspection documentation	20
10	Marking, packaging, labelling	20
	Bibliography	41

Figures

Figure 1	— Examples of hollow rod cross-sections	8
Figure 2	— Measurement of twist of polygonal hollow rod.....	17

Tables

Table 1	— Composition of low alloyed copper alloys	21
Table 2	— Composition of copper-zinc alloys.....	22
Table 3	— Composition of copper-zinc-lead alloys	23
Table 4	— Composition of complex copper-zinc alloys.....	26
Table 5	— Mechanical properties of low alloyed copper alloys.....	27
Table 6	— Mechanical properties of copper-zinc alloys.....	28
Table 7	— Mechanical properties of copper-zinc-lead alloys.....	31
Table 8	— Mechanical properties of complex copper-zinc alloys.....	34
Table 9	— Tolerances on external diameter or width across-flats.....	38
Table 10	— Tolerances on wall thickness.....	38
Table 11	— Tolerances on diameter of the bore	38
Table 12	— Tolerances on eccentricity.....	39
Table 13	— Tolerances on straightness of hollow rod.....	39
Table 14	— Tolerances on length of hollow rod.....	39
Table 15	— Corner radii for hollow rod with square, hexagonal or octagonal external shape	39
Table 16	— Maximum twist for hollow rod with square, hexagonal or octagonal external shape	40
Table 17	— Sampling rate.....	40

European foreword

This document (EN 12168:2016) has been prepared by Technical Committee CEN/TC 133 “Copper and copper alloys”, the secretariat of which is held by DIN.

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 January 2017, and conflicting national standards shall be withdrawn at the latest by January 2017.

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

This document supersedes EN 12168:2011.

Within its programme of work, Technical Committee CEN/TC 133 requested CEN/TC 133/WG 4 “Extruded and drawn products, forgings and scrap” to revise the following standard:

- EN 12168:2011, *Copper and copper alloys — Hollow rod for free machining purposes.*

This document is one of a series of European Standards for the copper and copper alloy products rod, wire, profile and forgings. Other products are specified as follows:

- EN 12163, *Copper and copper alloys — Rod for general purposes;*
- EN 12164, *Copper and copper alloys — Rod for free machining purposes;*
- EN 12165, *Copper and copper alloys — Wrought and unwrought forging stock;*
- EN 12166, *Copper and copper alloys — Wire for general purposes;*
- EN 12167, *Copper and copper alloys — Profiles and bars for general purposes;*
- EN 13601, *Copper and copper alloys — Copper rod, bar and wire for general electrical purposes;*
- EN 13602, *Copper and copper alloys — Drawn, round copper wire for the manufacture of electrical conductors;*
- EN 13605, *Copper and copper alloys — Copper profiles and profiled wire for electrical purposes.*

In comparison with EN 12168:2011, the following significant technical changes were made:

- a) addition of four new materials: CuZn37Pb1 (CW605N), CuZn35Pb1,5AlAs (CW625N), CuZn33Pb1,5AlAs (CW626N) and CuZn33Pb1AlSiAs (CW725R) due to the market requirements on restriction of lead and modification of the chemical composition for CuZn39Pb1 (CW611N);
- b) introduction of an optional procedure how to refer to restrictions to the chemical composition imposed by the 4 MS Common Composition List for materials used for products accepted for contact with drinking water;
- c) requirements and test methods for resistance of dezincification modified;
- d) provisions for surface quality added;

e) mechanical properties for CuZn21Si3P (CW724R) modified.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

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Introduction

The European Committee for Standardization (CEN) draws attention to the fact that it is claimed that compliance with this document may involve the use of a patent concerning the alloy CuZn21Si3P (CW724R) and CuZn33Pb1AlSiAs (CW725R) given in 6.1.

CEN takes no position concerning the evidence, validity and scope of this patent right.

The holder of this patent right has ensured the CEN that he is willing to negotiate licenses under reasonable and non-discriminatory terms and conditions with applicants throughout the world. In this respect, the statement of the holder of this patent right is registered with CEN.

— For CuZn21Si3P (CW724R) information may be obtained from:

Wieland-Werke AG
Graf Arco Straße 36
D-89079 Ulm
GERMANY

— For CuZn33Pb1AlSiAs (CW725R) information may be obtained from:

Diehl Metall Messing
Heinrich-Diehl-Straße 9
D-90552 Röthenbach/Pegnitz
GERMANY

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

CEN and CENELEC maintain online lists of patents relevant to their standards. Users are encouraged to consult the lists for the most up to date information concerning patents (<ftp://ftp.cenelec.eu/EN/IPR/Patents/IPRdeclaration.pdf>).

Due to developing legislation, the composition of a material may be restricted to the composition specified in this European Standard with respect to individual uses (e.g. for the use in contact with drinking water in some Member States of the European Union). These individual restrictions are not part of this European Standard. Nevertheless, for materials for which traditional and major uses are affected, these restrictions are indicated. The absence of an indication, however, does not imply that the material can be used in any application without any legal restriction.

1 Scope

This European Standard specifies the composition, property requirements and dimensional tolerances for copper alloy hollow rod, finally produced by drawing or extruding, specifically intended for free machining purposes.

NOTE Hollow products having an outside diameter greater than 80 mm and/or a wall thickness less than 2 mm are specified in EN 12449.

The sampling procedures, the methods of test for verification of conformity to the requirements of this European Standard, are also specified.

2 Normative references

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

EN 1173, *Copper and copper alloys - Material condition designation*

EN 1412, *Copper and copper alloys - European numbering system*

EN 1655, *Copper and copper alloys - Declarations of conformity*

EN 10204, *Metallic products - Types of inspection documents*

EN 14977, *Copper and copper alloys - Detection of tensile stress - 5 % ammonia test*

EN ISO 6506-1, *Metallic materials - Brinell hardness test - Part 1: Test method (ISO 6506-1)*

EN ISO 6507-1, *Metallic materials - Vickers hardness test - Part 1: Test method (ISO 6507-1)*

EN ISO 6509-1, *Corrosion of metals and alloys - Determination of dezincification resistance of copper alloys with zinc - Part 1: Test method (ISO 6509-1)*

EN ISO 6892-1, *Metallic materials - Tensile testing - Part 1: Method of test at room temperature (ISO 6892-1)*

ISO 1190-1, *Copper and copper alloys — Code of designation — Part 1: Designation of materials*

ISO 6957, *Copper alloys — Ammonia test for stress corrosion resistance*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

hollow rod

straight product, of uniform cross-section along its whole length with an enclosed void for which the longitudinal axes of its external contour and its internal contour, which is the boundary with the enclosed void, are coincidental

EN 12168:2016 (E)

Note 1 to entry: The external and internal contours of the rod, at any cross-section, can be that of a circle, square, rectangle, hexagon, or octagon, or with slight modification of those basic shapes by inclusion of detail(s) of relatively small size to the remainder of the cross-section. Examples of hollow rod cross-sections are shown in Figure 1.

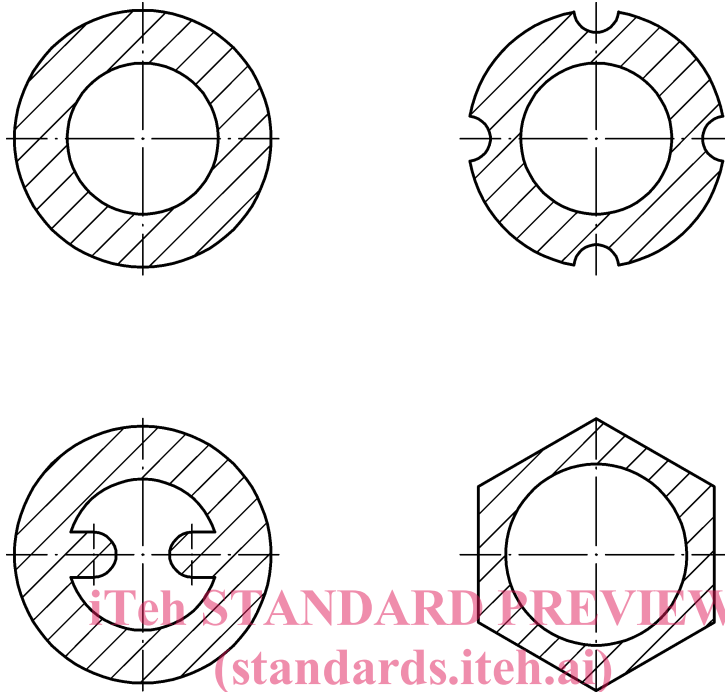


Figure 1 — Examples of hollow rod cross-sections

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3.2

deviation from circular form

difference between the maximum and the minimum outside diameters measured at any one cross-section of the product

[SOURCE: EN 12163:2016, 3.2, modified — The definition was adapted.]

3.3

eccentricity

difference between the maximum and the minimum wall thickness, measured in the same cross-section perpendicular to the axis of the hollow rod, expressed as a percentage of the sum of the maximum and minimum wall thicknesses ($s_{\max.}$ and $s_{\min.}$):

$$e = \frac{s_{\max.} - s_{\min.}}{s_{\max.} + s_{\min.}} \times 100$$

Note 1 to entry: For polygons, wall thickness is measured perpendicular to the mid-points of the flat outside surfaces.

4 Designations

4.1 Material

4.1.1 General

The material is designated either by symbol or by number (see Tables 1 to 4).

4.1.2 Symbol

The material symbol designation is based on the designation system given in ISO 1190-1.

NOTE Although material symbol designations used in this standard might be the same as those in other standards using the designation system given in ISO 1190-1, the detailed composition requirements are not necessarily the same.

4.1.3 Number

The material number designation is in accordance with the system given in EN 1412.

4.2 Material condition

For the purposes of this standard, the following designations, which are in accordance with the system given in EN 1173, apply for the material condition:

M	material condition for the product as manufactured without specified mechanical properties;
R...	material condition designated by the minimum value of tensile strength requirement for the product with mandatory tensile property requirements;
H...	material condition designated by the minimum value of hardness requirement for the product with mandatory hardness requirements;

S (suffix) material condition for a product which is stress relieved.

Products in the M or H... material condition may be specially processed (i.e. mechanically or thermally stress relieved) in order to lower the residual stress level to improve the resistance to stress corrosion and the dimensional stability on machining [see Clause 5 list entry k), list entry l) and 8.5].

Except when the suffix S is used, material condition is designated by only one of the above designations.

4.3 Product

The product designation provides a standardized pattern of designation from which a rapid and unequivocal description of a product can be conveyed in communication. It provides mutual comprehension at the international level with regard to products which meet the requirements of the relevant European Standard.

The product designation is no substitute for the full content of the standard.

The product designation for products to this standard shall consist of:

- denomination (hollow rod);
- number of this European Standard (EN 12168);
- material designation, either symbol or number (see Tables 1 to 4);

EN 12168:2016 (E)

- d) DW for compliance in the chemical composition according to the 4 MS Common Composition List. This information is mandatory in the case in which the product is used for drinking water applications according to the 4 MS Common Composition List and not to be given in other cases;
- e) material condition designation (see Tables 5 to 8);
- f) external and/or internal cross-sectional shape (the following designations shall be used as appropriate: RND for round, SQR for square, RCT for rectangular, HEX for hexagonal, OCT for octagonal, PFL for profile);
- g) nominal cross-sectional dimensions (see Clause 5, list entry g)) or, for profiles, the number of the profile or a fully dimensioned and toleranced drawing, and:
 - 1) tolerance class A, B or C added to the external dimension (see Table 9); and/or
 - 2) tolerance class A or B added to the bore diameter (see Table 11);
- h) wall thickness (the following designation shall be used for wall thickness: WT) (see Table 10);
- i) for square, hexagonal or octagonal external shape, the corner shape (the following designations shall be used as appropriate: SH for sharp, RD for rounded) (see Table 15).

A typical product designation is shown in the following examples.

EXAMPLE 1 Hollow rod for free machining purposes conforming to this standard, in material designated either CuZn40Pb2 or CW617N, for standard applications, in material condition H090, round external shape and bore, nominal outside diameter 40 mm, tolerance Class B, and nominal wall thickness 10 mm will be designated as follows:

SIST EN 12168:2016

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Hollow rod EN 12168 — CuZn40Pb2 — H090 — RND40B × WT10

or

Hollow rod EN 12168 — CW617N — H090 — RND40B × WT10

Denomination

Number of European Standard

Material designation

Material condition designation

Cross-sectional shape, nominal cross-sectional dimensions in millimetres,
tolerance class, nominal wall thickness

EXAMPLE 2 Hollow rod for free machining purposes conforming to this standard, in material designated either CuZn40Pb2 or CW617N, for drinking water applications according to the 4 MS Common Composition List, in material condition H090, round external shape and bore, nominal outside diameter 40 mm, tolerance Class B, and nominal wall thickness 10 mm will be designated as follows:

Hollow rod EN 12168 — CuZn40Pb2 — DW — H090 — RND40B × WT10

or

Hollow rod EN 12168 — CW617N — DW — H090 — RND40B × WT10

Denomination

Number of European Standard

Material designation

For the use in contact with drinking water
according to 4 MS Common Composition List,
(restriction in chemical composition)

Material condition designation

Cross-sectional shape, nominal cross-sectional dimensions in millimetres,
tolerance class, nominal wall thickness

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