



SLOVENSKI STANDARD
SIST EN 12168:1999/A1:2002
01-februar-2002

6 U_Yf`]b`VU_fcj Yn`]h]bY!`Jch`Y`dU]W`n`f`U`h`] b]a]`df`Yf`Yn`]nUcVXYUj c`bUUj hca U]h

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

Ta slovenski standard je istoveten z: **EN 12168:1998/A1:2000**

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ICS:

77.150.30 Bakreni izdelki Copper products

SIST EN 12168:1999/A1:2002 en

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 12168:1998/A1

May 2000

ICS 77.150.30

English version

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 amendment A1 modifies the European Standard EN 12168:1998; it was approved by CEN on 22 April 2000.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This amendment exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Foreword

This Amendment EN 12168:1998/A1:2000 to EN 12168:1998 has been prepared by Technical Committee CEN/TC 133 "Copper and copper alloys", the secretariat of which is held by DIN.

This Amendment to the European Standard EN 12168:1998 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2000, and conflicting national standards shall be withdrawn at the latest by November 2000.

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, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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Introduction

Delete the second paragraph and substitute the following:

Requirements were previously included in this standard for two alloys, namely CuZn39Pb2Sn (CW613N) and CuZn40Pb2Sn (CW619N), which because of their higher permitted levels of tin, iron and aluminium, had inferior machinability to CuZn39Pb2 (CW612N) and CuZn40Pb2 (CW617N) respectively. In view of this CEN/TC 133 decided to withdraw these alloys from the standard but allowed sufficient time for their phasing out from production. These alloys, CuZn39Pb2Sn (CW613N) and CuZn40Pb2Sn (CW619N), were deleted from the standard on 1 January 2000.

Definition 3.1 hollow rod

Delete the present definition and substitute the following:

3.1 hollow rod

Wrought, straight product, of uniform cross-section along its whole length with an enclosed void. The longitudinal axes of the external form of the rod and its internal form, which is the boundary with the enclosed void, are coincidental. The external and internal contours of the rod, at any cross-section, can be round, square, rectangular, hexagonal, or octagonal, or with slight modification of those basic shapes by inclusion of detail(s) of relatively small size to the remainder of the cross-section. The product is intended specifically for free machining purposes.

NOTE: Examples of hollow rod cross-sections are shown in figure 1.

Table 2: Composition of copper-zinc-lead alloys

Delete from the table the block referring to Group E alloys, its contents and the footnote 2), i.e.

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Group E alloys - These alloys have good machinability and limited cold workability ²⁾													
CuZn39Pb2Sn ²⁾	CW613N ²⁾	min.	59,0	-	-	-	-	-	1,6	0,2	Rem.	-	8,4
		max.	60,0	0,1	-	0,4	-	0,3	2,5	0,5	-	0,2	
CuZn40Pb2Sn ²⁾	CW619N ²⁾	min.	57,0	-	-	-	-	-	1,6	0,2	Rem.	-	8,4
		max.	59,0	0,1	-	0,4	-	0,3	2,5	0,5	-	0,2	

²⁾ Products in these alloys are unsuitable for machining at the highest speeds. They are therefore not available in sizes below 18 mm outside diameter, or across-flats and less than 3 mm wall thickness. The alloys are to be deleted from this standard by 1 January 2000.

Table 5: Mechanical properties of copper-zinc-lead alloys

Delete 'CuZn39Pb2Sn', 'CW613N', 'CuZn40Pb2Sn' and 'CW619N' from the material symbol and number designations columns.