



SLOVENSKI STANDARD
SIST ISO 1167:1997

01-april-1997

**Plastomerne cevi za pretok tekočin in plinov - Odpornost na notranji tlak -
Preskusna metoda**

Thermoplastics pipes for the conveyance of fluids -- Resistance to internal pressure --
Test method

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Tubes en matières thermoplastiques pour le transport des fluides -- Résistance à la
pression interne -- Méthode d'essai

[SIST ISO 1167:1997](https://standards.iTeh.ai/catalog/standards/sist/eh2b4293-5e2d-433e-bc46-6030259693e0/sist-iso-1167-1997)

Ta slovenski standard je istoveten z: ISO 1167:1996

ICS:

23.040.20 Cevi iz polimernih materialov Plastics pipes

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en

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INTERNATIONAL
STANDARD

ISO
1167

Second edition
1996-11-01

**Thermoplastics pipes for the conveyance of
fluids — Resistance to internal pressure —
Test method**

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*Tubes en matières thermoplastiques pour le transport des fluides —
Résistance à la pression intérieure — Méthode d'essai*

<https://standards.iteh.ai/catalog/standards/sist/eb2b4293-5e2d-433e-bc46-b03b239693e0/sist-iso-1167-1997>



Reference number
ISO 1167:1996(E)

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.

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.

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International Standard ISO 1167 was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 5, *General properties of pipes, fittings and valves of plastic materials and their accessories — Test methods and basic specifications*.

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This second edition cancels and replaces the first edition (ISO 1167:1973), of which it constitutes a technical revision.

Annex A of this International Standard is for information only.

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Thermoplastics pipes for the conveyance of fluids — Resistance to internal pressure — Test method

1 Scope

This International Standard specifies a method for determination of the resistance of thermoplastics pipes to constant internal water pressure at constant temperature.

It is applicable to thermoplastics pipes intended for the conveyance of fluids.

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2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 161-1:1996, *Thermoplastics pipes for the conveyance of fluids — Nominal outside diameters and nominal pressures — Part 1: Metric series*.

ISO 3126:1974, *Plastics pipes — Measurement of dimensions*.

ISO/TR 9080:1992, *Thermoplastics pipes for the transport of fluids — Methods of extrapolation of hydrostatic stress rupture data to determine the long-term hydrostatic strength of thermoplastics pipe materials*.

3 Definitions

For the purposes of this International Standard, the definitions given in ISO 161-1 apply.

4 Principle

After conditioning, test pieces are subjected to a specified constant internal hydrostatic pressure for a specified period of time or until failure.

Throughout the test, the test pieces are kept in an environment at a specified constant temperature: this is water ("water-in-water" test), another liquid ("water-in-liquid" test) or air ("water-in-air" test).

5 Test parameters

The following test parameters are set by the standard making reference to this International Standard:

- a) the type of end cap to be used (see 6.1);
- b) the size and S-series of pipe to be used (see 7.1);
- c) the test temperature (see 6.2 and 10.1);
- d) for pipes of nominal outside diameter d_n greater than 315 mm, the free length of the test piece, if other than 1 000 mm (see 7.1.1);
- e) the number of test pieces (see 7.2);
- f) the test pressure p or the hoop stress σ to be induced by the test pressure (see 8.2.2);
- g) the conditioning period (see clause 9), if other than as specified in table 1;
- h) the type of test, i.e. water-in-water/air/liquid (see clause 4 and 10.1);
- i) the duration of the test under pressure and the criteria for a failure (see 10.3);
- j) the requirements, or patterns of requirements, if any, which determine the initiation of additional testing.

6 Apparatus

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6.1 End caps, fixed to the ends of the pipe.

By means of an appropriate system, they shall allow sealing and connection to the pressurizing equipment.

The end cap shall be of one of the following types.

- a) Type A: Fittings rigidly connected to the test piece but not to each other, and hence transmitting the hydrostatic end thrust to the test piece, e.g. as shown in figure 1 a). They may comprise flanged plates on the ends of a large-diameter pipe, optionally welded when flanges, caps, plugs or plates are of a material compatible with that of the test pieces.
- b) Type B: Sockets, made of metal, fitted with joints ensuring sealing onto the external surface of the test piece and connected to one another, and hence not transmitting the hydrostatic end thrust to the test piece. They may comprise one or more metal rods, as shown in figure 1 b), allowing sufficient longitudinal movement at the ends of the test piece to avoid buckling due to thermal expansion.

Other than toothed grips, any sharp edges which would come into contact with the outside surface of the pipe shall be rounded off.

The constituent material of the end cap shall not have any known adverse effect on the pipe under test.

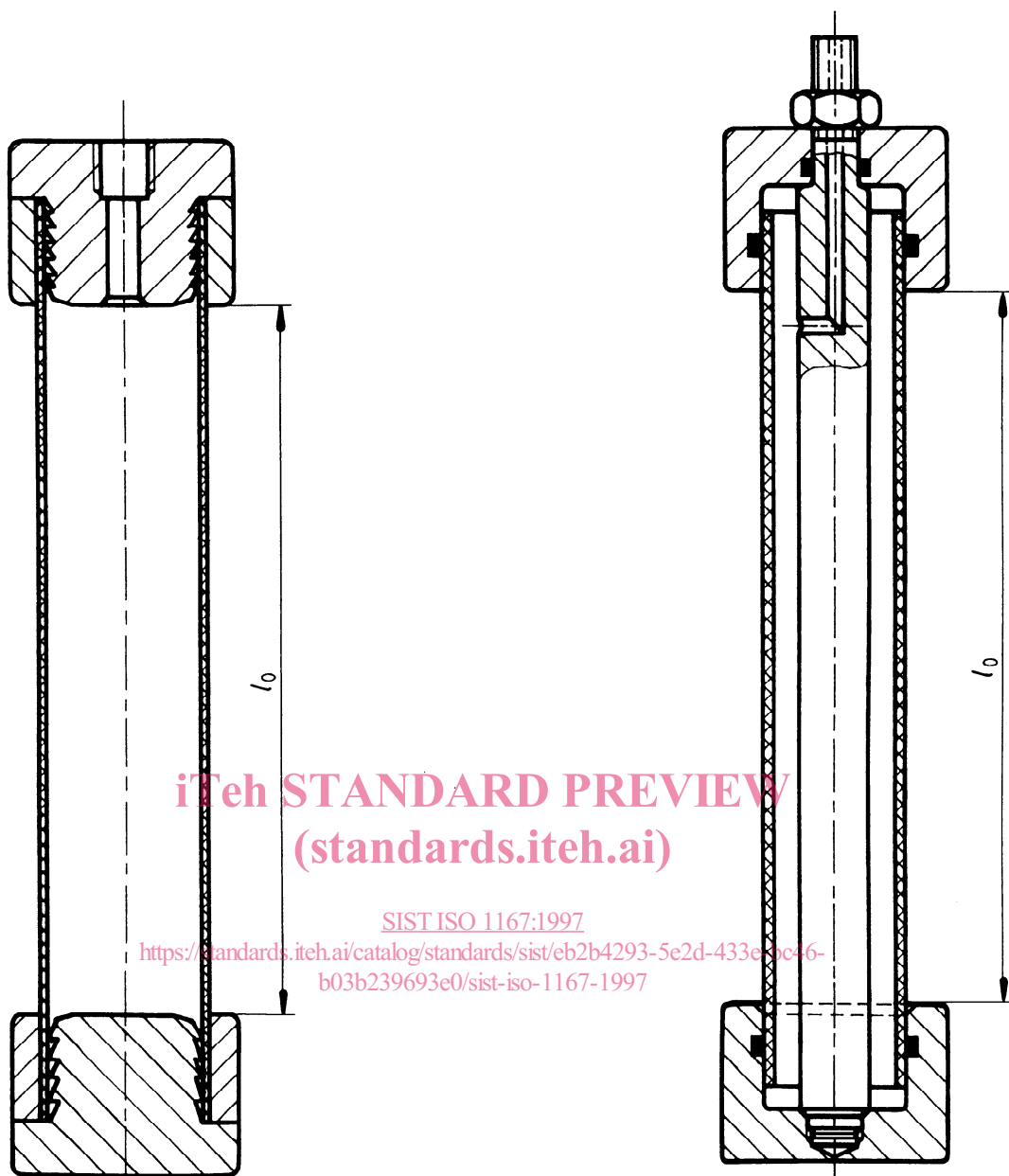
NOTES

1 In general, times to failure with type B end caps are shorter than those obtained with type A end caps because of differences of stress in deformation.

2 When no precautions are taken, type B end caps can cause buckling of the test piece when the test piece is assembled with the end caps at a lower temperature than the test temperature.

For the evaluation of pipe and/or fitting materials in accordance with ISO/TR 9080, type A end caps shall be used unless otherwise specified in the referring standard.

The reference end cap is the type A end cap.



a) Type A, without metal rod
(hydrostatic end thrust transmitted to the test piece)

b) Type B, with metal rod
(hydrostatic end thrust not transmitted to the test piece)

Figure 1 — Examples of devices for the internal pressure testing of pipes

6.2 Tank, filled with water or another liquid, kept at a constant temperature, as specified in the referring standard, to within a mean of ± 1 °C and a maximum deviation of ± 2 °C (see 10.2), or **oven**, the temperature of which shall be kept at the specified value to within a mean of ± 3 °C and maximum deviations of ± 4 °C.

When an environment other than water is used, all necessary precautions shall be taken, in particular those concerning safety and any interaction between liquids and the material(s) of the test piece.

When environments other than water are used, tests which are intended to be comparative shall be carried out in the same environment.

As the results are strongly influenced by temperature, the tolerance on temperature shall be kept as small as possible within the specified limits, e.g. by using forced circulation of the fluid. When testing in air, it is recommended that the pipe surface temperature is checked in addition to the air temperature.

The water shall not contain any impurities which could affect the results.

6.3 Supports or hangers, enabling test pieces to be placed in the tank or oven (6.2) in such a way that there is no contact between them or with the side walls of the tank or oven.

6.4 Pressurizing equipment, capable of applying the required pressure gradually and smoothly in accordance with 10.1 and then of keeping it constant to within $\pm 1\%$ for the duration of the test.

As the results are strongly influenced by pressure, the tolerance on pressure shall be kept as small as possible within the specified limits.

NOTES

1 The pressure should preferably be applied individually to each test piece. However, the use of equipment enabling the pressure to be applied simultaneously to several test pieces is also permitted if there is no danger of interference when failure occurs (e.g. by the use of an isolation valve or a test based on the first failure in a batch).

2 To maintain the pressure within the specified tolerance, it is recommended that a system be introduced which automatically resets the pressure, if it drops slightly (e.g. because of swelling of the test piece), to the specified value.

6.5 Pressure measurement devices, capable of checking conformity to the specified test pressure [see 8.2.2 and item f) in clause 5]. In the case of gauges or similar calibrated pressure measurement devices, the range of the gauge shall be such that the required pressure setting lies within the calibrated range of the device used (see 8.1).

The pressure measurement devices shall not contaminate the test fluid.

The use of master gauges for calibration of the apparatus is recommended.

6.6 Thermometer or equivalent, capable of checking conformity to the specified test temperature [see 6.2 and item c) in clause 5].

6.7 Timer, capable of recording the duration of the pressure applications up to the moment of failure or leakage.

NOTE — It is recommended that equipment be used which is sensitive to pressure variations due to leaks or a failure and which is capable of stopping the timer and, if necessary, closing the pressure circuit for the test piece concerned.

6.8 Means of measuring the wall thickness, conforming to ISO 3126, with hemispherical tips, and of such a design that measurements can be made along the whole length of the pipe.

NOTE — A calibrated ultrasonic measuring device can be used.

6.9 Means of measuring the mean outside diameter of the pipe, conforming to ISO 3126, e.g. a metal tape.

7 Test pieces

7.1 Dimensions

7.1.1 Free length

The free length l_0 of each test piece between the end caps shall be at least three times the outside diameter for pipes with a nominal outside diameter less than or equal to 315 mm, with a minimum of 250 mm. For pipes with a nominal outside diameter greater than 315 mm, a minimum free length of greater than or equal to 1 000 mm shall be used.

7.1.2 Total length

For type B end caps, the total length of the test piece shall be such that the test piece does not make contact with the end surface of the end caps during the test.

7.2 Number

Prepare a minimum of three test pieces unless specified in the referring standard.

The number of test pieces depends on the purpose of the test (e.g. performance test, internal and/or external quality control test).

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8 Calibration of the apparatus and calculation of the test pressure

8.1 Calibration of the apparatus

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The temperature and pressure control systems, and the equipment for measuring temperature, pressure and time, shall be calibrated to an accuracy compatible with the scales used and at a frequency commensurate with the conditions of use.

8.2 Calculation of the test pressure

8.2.1 Determine, in accordance with ISO 3126, the minimum wall thickness and the mean outside diameter of the free length of the test piece, using apparatus conforming to 6.8 and 6.9, respectively.

8.2.2 If necessary [see item f) in clause 5], calculate the test pressure p in bars²⁾, to three significant figures, using the following equation:

$$p = 10\sigma \frac{2e_{\min}}{d_{\text{em}} - e_{\min}}$$

where

σ is the hoop stress, in megapascals, to be induced by the applied pressure;

d_{em} is the measured mean outside diameter, in millimetres, of the test piece;

e_{\min} is the measured minimum wall thickness, in millimetres, of the free length of the test piece.

1) 1 bar = 10⁵ Pa = 0,1 MPa