

**SLOVENSKI
STANDARD**

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Plastics piping systems for hot and cold water installations - Crosslinked polyethylene (PE-X) - Part 2: Pipes (ISO 15875-2:2003)

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ICS 23.040.20; 91.140.60

English version

Plastics piping systems for hot and cold water installations -
Crosslinked polyethylene (PE-X) - Part 2: Pipes (ISO 15875-
2:2003)

Systèmes de canalisations en plastique pour les
installations d'eau chaude et froide - Polyéthylène réticulé
(PE-X) - Partie 2: Tubes (ISO 15875-2:2003)

Kunststoff-Rohrleitungssysteme für die Warm- und
Kaltwasserinstallation - Vernetztes Polyethylen (PE-X) - Teil
2: Rohre (ISO 15875-2:2003)

This European Standard was approved by CEN on 14 March 2003.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

This European Standard 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 Management Centre 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, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and United Kingdom.

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

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Contents

Contents	2
Introduction	4
1 Scope	5
2 Normative references	5
3 Terms and definitions, symbols and abbreviated terms	5
4 Material	6
4.1 Pipe material	6
4.2 Evaluation of σ_{LCL} -values	6
4.3 Influence on water intended for human consumption	8
5 General characteristics	8
5.1 Appearance	8
5.2 Opacity	8
6 Geometrical characteristics	8
6.1 General.....	8
6.2 Dimensions of pipes	8
7 Mechanical characteristics	11
8 Physical and chemical characteristics	12
9 Performance requirements	13
10 Marking	13
10.1 General requirements	13
10.2 Minimum required marking.....	13
Annex A (informative) Derivation of $S_{calc,max}$ values	15
A.1 General.....	15
A.2 Design stress	15
A.3 Derivation of maximum value of S_{calc} ($S_{calc,max}$).....	16
A.4 Use of $S_{calc,max}$ to determine wall thickness.....	16
Bibliography	17

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Foreword

This document (EN ISO 15875-2:2003) has been prepared by Technical Committee CEN/TC 155 "Plastics piping systems and ducting systems", the secretariat of which is held by NEN, in collaboration with Technical Committee ISO/TC 138 "Plastics pipes, fittings and valves for the transport of fluids".

NOTE This draft was submitted for CEN enquiry as prEN 12318-2:1996.

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 June 2004, and conflicting national standards shall be withdrawn at the latest by December 2005.

This standard is part of a System Standard for plastics piping systems of a particular material for a specified application. There are a number of such System Standards.

System Standards are based on the results of the work undertaken in ISO/TC 138 "Plastics pipes, fittings and valves for the transport of fluids", which is a Technical Committee of the International Organization for Standardization (ISO).

They are supported by separate standards on test methods to which references are made throughout the System Standard.

The System Standards are consistent with general standards on functional requirements and recommended practices for installation.

EN ISO 15875 consists of the following Parts ¹⁾, under the general title *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X)*

- Part 1: *General*
- Part 2: *Pipes* (the present standard)
- Part 3: *Fittings*
- Part 5: *Fitness for purpose of the system*
- Part 7: *Guidance for the assessment of conformity* (CEN ISO/TS 15875-7).

This Part of EN ISO 15875 includes the following:

- Annex A (informative): Derivation of $S_{calc,max}$
- Bibliography

At the date of publication of this standard, System Standards for piping systems of other plastics materials used for the same application are the following:

EN ISO 15874:2003, *Plastics piping systems for hot and cold water installations — Polypropylene (PP)* (ISO 15875:2003)

EN ISO 15876:2003, *Plastics piping systems for hot and cold water installations — Polybutylene (PB)* (ISO 15876:2003)

EN ISO 15877:2003, *Plastics piping systems for hot and cold water installations — Chlorinated poly(vinyl chloride) (PVC-C)* (ISO 15877:2003)

For pipes and fittings which have conformed to the relevant national standard before 1st November 2003, as shown by the manufacturer or by a certification body, the national standard may continue to apply until 30th November 2005.

1) This System Standard does not incorporate a Part 4 *Ancillary equipment* or a Part 6 *Guidance for installation*. For ancillary equipment separate standards can apply. Guidance on installation of plastics piping systems made from different materials, intended to be used for hot and cold water installations, is given by ENV 12108:2001 [1].

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

Introduction

The System Standard, of which this is Part 2, specifies the requirements for a piping system when made from crosslinked polyethylene (PE-X). The piping system is intended to be used for hot and cold water installations.

In respect of potential adverse effects on the quality of water intended for human consumption, caused by the product covered by this standard:

- This standard provides no information as to whether the product may be used without restriction in any of the Member States of the EU or EFTA;
- It should be noted that, while awaiting the adoption of verifiable European criteria, existing national regulations concerning the use and/or the characteristics of this product remain in force.

Requirements and test methods for material and components, other than pipes are specified in Part 1 and Part 3 of EN ISO 15875:2003. Characteristics for fitness for purpose (mainly for joints) are covered in Part 5. Part 7 (CEN ISO/TS 15875-7) gives guidance for the assessment of conformity.

This Part of EN ISO 15875 specifies the characteristics of pipes.

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1 Scope

This Part of EN ISO 15875 specifies the characteristics of pipes made from crosslinked polyethylene (PE-X) for piping systems intended to be used for hot and cold water installations within buildings for the conveyance of water, whether or not intended for human consumption (domestic systems), and for heating systems, under design pressures and temperatures appropriate to the class of application (see Table 1 of EN ISO 15875-1:2003).

This standard covers a range of service conditions, (application classes), design pressures and pipe dimension classes. For values of T_D , T_{max} and T_{mal} in excess of those in Table 1 of Part 1, this standard does not apply.

NOTE 1 It is the responsibility of the purchaser or specifier to make the appropriate selections from these aspects, taking into account their particular requirements and any relevant national regulations and installation practices or codes.

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

In conjunction with the other Parts of EN ISO 15875 (see Foreword) it is applicable to PE-X pipes, their joints and to joints with components of PE-X, other plastics and non-plastics materials intended to be used for hot and cold water installations.

It is applicable to pipes with or without (a) barrier layer(s).

NOTE 2 In the case of plastics pipes provided with a thin barrier layer, e.g. to prevent or greatly diminish the diffusion of gases and the transmission of light into or through the pipe wall, the design stress requirements are totally met by the base polymer (PE-X).

2 Normative references

This Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies (including amendments).

EN 578, *Plastics piping systems — Plastics pipes and fittings — Determination of the opacity*

EN 579, *Plastics piping systems — Crosslinked polyethylene (PE-X) pipes — Determination of degree of crosslinking by solvent extraction*

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

EN 921:1994, *Plastics piping systems — Thermoplastics pipes — Determination of resistance to internal pressure at constant temperature*

EN ISO 15875-1:2003, *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X) — Part 1: General (ISO 15875-1:2003)*

EN ISO 15875-5, *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X) — Part 5: Fitness for purpose of the system (ISO 15875-5:2003)*

EN ISO 3126, *Plastics piping systems - Plastics piping components - Determination of dimensions (ISO 3126:2003)*

EN ISO 9080, *Plastics piping and ducting systems — Determination of the long-term hydrostatic strength of thermoplastics materials in pipe form by extrapolation (ISO 9080:2003)*

3 Terms and definitions, symbols and abbreviated terms

For the purposes of this standard the terms and definitions, symbols and abbreviated terms given in EN ISO 15875-1:2003 apply.

4 Material

4.1 Pipe material

The material from which the pipes are made shall be polyethylene (PE) which is crosslinked during or after the manufacturing of the pipe.

The material may be crosslinked by any process (peroxide, silane, electron beam and azo), which change the chemical structure in such a way that the polymer chains are connected with each other to a three-dimensional net by chemical bonds.

NOTE The new structure makes it no longer possible to melt or dissolve the polymer unless first destroying its structure. It is therefore possible to assess the level of crosslinking by measurement of the degree of gelation.

4.2 Evaluation of σ_{LCL} -values

The pipe material shall be evaluated in accordance with EN ISO 9080 or equivalent where internal pressure tests are made in accordance with EN 921:1994 to find the σ_{LCL} -values. The σ_{LCL} -value thus determined shall at least be as high as the corresponding values of the reference curves given in Figure 1 over the complete range of times.

NOTE 1 One equivalent way of evaluation is to calculate the σ_{LCL} -value for each temperature (for example 20 °C, 60 °C and 95 °C) individually.

NOTE 2 The reference curves in figure 1 in the temperature range of 10 °C to 95 °C are derived from the following equation:

$$\log t = -105,8618 - \frac{18506,15 \log \sigma}{T} + \frac{57895,49}{T} - 24,7997 \log \sigma$$

To demonstrate conformance to the reference lines pipe samples should be tested at following temperatures and at various hoop stresses such that, at each of the temperatures given, at least three failure times fall in each of the following time intervals:

Temperatures 20; 60-70; 95; °C

Time intervals 10-100 h, 100-1000 h, 1000-8760 h and above 8760 h

In tests lasting more than 8760 h, once failure is reached at a stress and time at least on or above the reference line, any time after that can be considered as the failure time. Testing should be carried out in accordance with EN 921:1994.

Conformance to the reference lines should be demonstrated by plotting the individual experimental results on the graph. At least 97.5% of them should lie on or above the reference line.

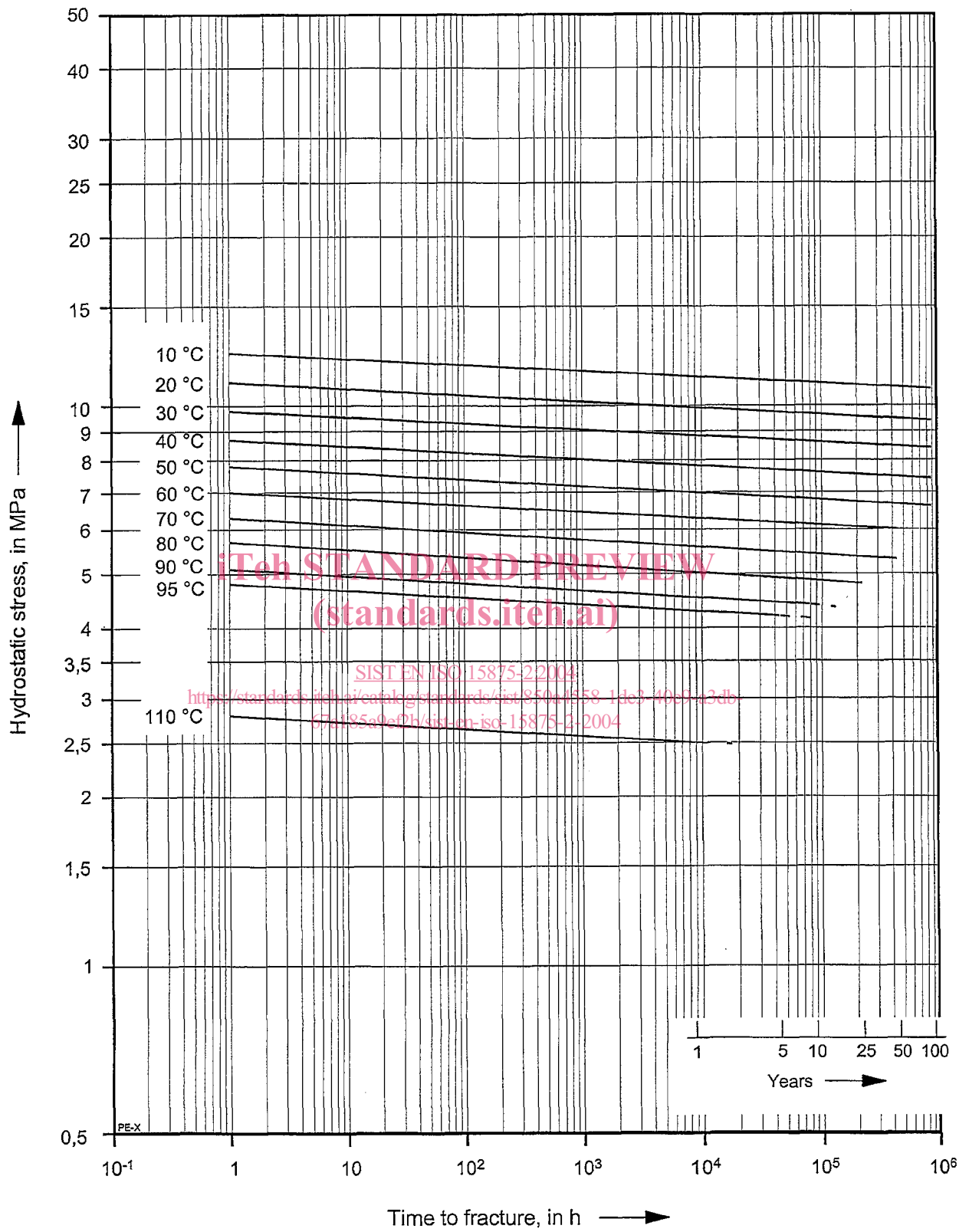


Figure 1 — Reference curves for expected strength of crosslinked polyethylene

4.3 Influence on water intended for human consumption

The material shall conform to EN ISO 15875-1:2003.

5 General characteristics

5.1 Appearance

When viewed without magnification the internal and external surfaces of pipes shall be smooth, clean and free from scoring, cavities and other surface defects to an extent that would prevent conformance with this standard. The material shall not contain visible impurities. Slight variations in appearance of the colour shall be permitted. The ends of the pipe shall be cut cleanly and square to the axis of the pipe.

5.2 Opacity

Crosslinked polyethylene pipes that are declared to be opaque shall not transmit more than 0,2 % of visible light, when tested in accordance with EN 578.

6 Geometrical characteristics

6.1 General

6.1.1 Dimensions shall be measured in accordance with EN ISO 3126.

6.1.2 The maximum calculated pipe value, $S_{calc,max}$, for the applicable class of service conditions and design pressure, p_D , shall conform to Table 1.

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Table 1 — $S_{calc,max}$ -values

p_D bar	Application class			
	Class 1	Class 2	Class 4	Class 5
	$S_{calc,max}$ -values ^a			
4	7,6 ^b	7,6 ^b	7,6 ^b	7,6 ^b
6	6,4	5,9	6,6	5,4
8	4,8	4,4	5,0	4,0
10	3,8	3,5	4,0	3,2

^a The values are rounded to the first place of decimals.
^b The 20 °C, 10 bar, 50 years, cold water requirement, being higher, determines this value (see clause 4 of EN ISO 15875-1:2003).

NOTE The derivation of $S_{calc,max}$ is provided in annex A. The method described takes account of the properties of PE-X under service conditions for the classes given in Table 1 of EN ISO 15875-1:2003.

6.1.3 The values of outside diameter and/or wall thickness apply to the crosslinked polyethylene pipe and are exclusive of any barrier layer thickness.

6.2 Dimensions of pipes

6.2.1 Outside diameters

For the applicable pipe dimension class, the mean outside diameter, d_{em} , of a pipe shall conform to Table 2, 3, 4 or 5, as applicable.

6.2.2 Wall thicknesses and their tolerances

For any particular class of service conditions, design pressure and nominal size, the minimum wall thickness, e_{\min} , shall be chosen in such a way that the corresponding S series or S_{calc} -value is equal to or less than the values of $S_{\text{calc,max}}$ given in Table 1.

For the applicable pipe dimension class, the wall thicknesses, e_{\min} and e_n respectively, shall conform to Table 2, 3, 4 or 5, as applicable, in relation to the pipe series S and S_{calc} -values, respectively. However, pipes intended to be joined together by fusion shall have a minimum wall thickness of 1,9 mm.

The tolerance on the wall thickness, e , shall conform to Table 6.

Table 2 — Pipe dimensions for dimension class A
(sizes conform to ISO 4065:1996 [2] and are applicable for all classes of service conditions)

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter d_n	Mean outside diameter $d_{em,min}$ $d_{em,max}$		Pipe series			
				S 6,3	S 5	S 4	S 3,2
				Wall thicknesses e_{\min} and e_n			
12	12	12,0	12,3	—	1,3 ^a	1,4	1,7
16	16	16,0	16,3	1,3	1,5	1,8	2,2
20	20	20,0	20,3	1,5	1,9	2,3	2,8
25	25	25,0	25,3	1,9	2,3	2,8	3,5
32	32	32,0	32,3	2,4	2,9	3,6	4,4
40	40	40,0	40,4	3,0	3,7	4,5	5,5
50	50	50,0	50,5	3,7	4,6	5,6	6,9
63	63	63,0	63,6	4,7	5,8	7,1	8,6
75	75	75,0	75,7	5,6	6,8	8,4	10,3
90	90	90,0	90,9	6,7	8,2	10,1	12,3
110	110	110,0	111,0	8,1	10,0	12,3	15,1
125	125	125,0	126,2	9,2	11,4	14,0	17,1
140	140	140,0	141,3	10,3	12,7	15,7	19,2
160	160	160,0	161,5	11,8	14,6	17,9	21,9

^a A non-preferred wall thickness of 1,1 mm is permitted for $d_n = 12$.