INTERNATIONAL STANDARD

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Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems jointed by solvent cement —

Part 1: General

Systèmes de canalisations en matières plastiques pour la distribution de combustibles gazeux — Systèmes de canalisations en polyamide non plastifié (PA-U) avec assemblage par collage —

Partie 1: Généralités

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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 17467-1 was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 4, *Plastics pipes and fittings for the supply of gaseous fuels*.

This first edition of ISO 17467-1 cancels and replaces the first edition of ISO 15439-1:2007, which has been technically revised.

ISO 17467 consists of the following parts, under the general title *Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems jointed by solvent cement*:

- *Part 1: General*
- *Part 2: Pipes*
- *Part 3: Fittings*

Introduction

Thin wall thickness unplasticized polyamide (PA-U) pipes and solvent cement joints are used typically for low pressures, while thicker wall thickness pipes and butt fusion, electrofusion or mechanical joints are typically used for high pressures.

For technical and safety reasons, it is not possible to mix the components of the two types of piping system (thin wall thickness pipes cannot be jointed by butt fusion or mechanical joints and vice versa). In particular, solvent cement joints must not be used for jointing for high pressure piping systems.

So for the time being, the standardisation programme dealing with unplasticized polyamide (PA-U) piping systems for the supply of gaseous fuels is split into two series of International Standards, with one series (ISO 17467) covering piping systems the components of which are connected by solvent cement jointing and the other (ISO 16486) the components of which are connected by fusion jointing and/or mechanical jointing. When more experience will be gained from the field, it might be reasonable to merge ISO 17467 series and ISO 16486 series in one single series applicable to PA-U piping systems.

A similar series (ISO 17135) of International Standards for fusion and mechanically jointed plasticized polyamide (PA-P) piping systems is in preparation.

NOTE A list of standards related to polyamide pipes and fittings for the supply of gas is given in the Bibliography. See References [1] to [8].

Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems jointed by solvent cement —

Part 1: General

1 Scope

This part of ISO 17467 specifies the general properties of unplasticized polyamide (PA-U) compounds for the manufacturing of pipes, fittings and valves made from such compounds, intended to be buried and used for the supply of gaseous fuels for maximum operating pressure up to and including 4 bar.

It also specifies the test parameters for the test methods to which it refers.

This part of ISO 17467 specifies a calculation and design scheme on which the maximum operating pressure (MOP) of piping systems is based.

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 179-1, *Plastics — Determination of Charpy impact properties — Part 1: Non-instrumented impact test*

ISO 291, *Plastics — Standard atmospheres for conditioning and testing*

ISO 307, Plastics — *Polyamides — Determination of viscosity number*

ISO 472, *Plastics — Vocabulary*

ISO 527-1, *Plastics — Determination of tensile properties — Part 1: General principles*

ISO 527-2, *Plastics — Determination of tensile properties — Part 2: Test conditions for moulding and extrusion plastics*

ISO 1043-1, *Plastics — Symbols and abbreviated terms — Part 1: Basic polymers and their special characteristics*

ISO 1167-1, *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 1: General method*

ISO 1167-2, *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 2: Preparation of pipe test pieces*

ISO 1167-4, *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 4: Preparation of assemblies*

ISO 1183-1, *Plastics — Methods for determining the density of non-cellular plastics — Part 1: Immersion method, liquid pyknometer method and titration method*

ISO 1183-2, *Plastics — Methods for determining the density of non-cellular plastics — Part 2: Density gradient column method*

ISO 1874-1, *Plastics — Polyamide (PA) moulding and extrusion materials — Part 1: Designation system and basis for specification*

ISO 1874-2, *Plastics — Polyamide (PA) moulding and extrusion materials — Part 2: Preparation of test specimens and determination of properties*

ISO 2505, *Thermoplastics pipes — Longitudinal reversion — Test method and parameters*

ISO 6259-1, *Thermoplastics pipes — Determination of tensile properties — Part 1: General test method*

ISO 6259-3, *Thermoplastics pipes — Determination of tensile properties — Part 3: Polyolefin pipes*

ISO 6964, *Polyolefin pipes and fittings — Determination of carbon black content by calcination and pyrolysis — Test method and basic specification*

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

ISO 12162:2009, *Thermoplastics materials for pipes and fittings for pressure applications — Classification, designation and design coefficient*

ISO 13477, *Thermoplastics pipes for the conveyance of fluids — Determination of resistance to rapid crack propagation (RCP) — Small-scale steady-state test (S4 test)*

ISO 13478, *Thermoplastics pipes for the conveyance of fluids — Determination of resistance to rapid crack propagation (RCP) — Full-scale test (FST)*

ISO 13480, *Polyethylene pipes — Resistance to slow crack growth — Cone test method*

ISO 15512, *Plastics — Determination of water content*

ISO 16871, *Plastics piping and ducting systems — Plastics pipes and fittings — Method for exposure to direct (natural) weathering*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 472, ISO 1043-1, ISO 1874-1 and the following apply.

3.1 Geometrical definitions

NOTE The symbols d_e and e correspond to d_{ey} and e_y given in other International Standards such as ISO 11922-1[9].

3.1.1
nominal outside diameter
d_n
specified outside diameter of a component, identical to the minimum mean outside diameter, $d_{em,min}$, in millimetres

NOTE The nominal inside diameter of a socket is equal to the nominal outside diameter of the corresponding pipe.

3.1.2
outside diameter at any point
d_e
outside diameter measured through the cross-section at any point on a pipe, or the spigot end of a fitting, rounded up to the nearest 0,1 mm

3.1.3
mean outside diameter
d_{em}
measured length of the outer circumference of a pipe, or the spigot end of a fitting, divided by π (≈ 3,142), rounded up to the nearest 0,1 mm

3.1.4
minimum mean outside diameter
$d_{em,min}$
minimum value for the mean outside diameter as specified for a given nominal size

3.1.5
maximum mean outside diameter
$d_{em,max}$
maximum value for the mean outside diameter as specified for a given nominal size

3.1.6
out-of-roundness
difference between the measured maximum outside diameter and the measured minimum outside diameter in the same cross-sectional plane of a pipe, or the spigot end of a fitting, or the difference between the measured maximum inside diameter and the measured minimum inside diameter in the same cross-sectional plane of a socket

3.1.7
nominal wall thickness
e_n
wall thickness, in millimetres, corresponding to the minimum wall thickness, e_{min}

3.1.8
wall thickness at any point
e
measured wall thickness at any point around the circumference of a component, rounded up to the nearest 0,05 mm

3.1.9
minimum wall thickness at any point
e_{min}
minimum value for the wall thickness at any point around the circumference of a component, as specified

3.1.10
standard dimension ratio
SDR
ratio of the nominal outside diameter, d_n, of a pipe to its nominal wall thickness, e_n

3.2 Definitions of materials

3.2.1
compound
homogenous mixture of base polymer (PA-U) and additives, i.e. anti-oxidants, pigments, UV-stabilizers and others, at a dosage level necessary for the processing and use of components conforming to the requirements of this part of ISO 17467

3.2.2
virgin material
material in a form such as granules or powder, which has not been previously processed other than for compounding and to which no rework or recyclable materials have been added

3.2.3
own reprocessable material
material prepared from rejected unused pipes, fittings and valves, including trimmings from the production of pipes, fittings and valves, which will be reprocessed in a manufacturer's plant after having been previously processed by the same manufacturer by a process such as moulding or extrusion and for which the complete formulation or compound is known

3.2.4
external reprocessable material
material comprising either one of the following forms:

a) material from rejected unused pipes, fittings or valves or trimmings therefrom, which will be reprocessed and which were originally processed by another manufacturer;

b) material from the production of unused PA-U products other than pipes, fittings and valves, regardless of where they are manufactured

3.2.5
recyclable material
material comprising either one of the following forms:

a) material from used pipes, fittings or valves which have been cleaned and crushed or ground;

b) material from used PA-U products other than pipes, fittings or valves which have been cleaned and crushed or ground

3.3 Definitions related to material characteristics

3.3.1
lower confidence limit of the predicted hydrostatic strength
σ_{LPL}

quantity, with the dimensions of stress, which represents the 97,5 % lower confidence limit of the predicted hydrostatic strength at a temperature θ and time t

NOTE 1 The quantity is expressed in megapascals (MPa).

NOTE 2 Temperature, θ, is expressed in degrees Celsius and time, t, is expressed in years.

3.3.2
minimum required strength
MRS
value of σ_{LPL} at 20 °C and 50 years, rounded down to the next smaller value of the R10 series or the R20 series

NOTE The R10 series conforms to ISO 3[1] and the R20 series conforms to ISO 497[2].

3.3.3
categorized required strength at temperature θ and time t
$CRS_{\theta,t}$
value of σ_{LPL} at temperature θ and time t, rounded down to the next smaller value of the R10 series or the R20 series

NOTE 1 $CRS_{\theta,t}$ at 20 °C and 50 years equals MRS.

NOTE 2 Temperature, θ, is expressed in degrees Celsius and time, t, is expressed in years.

NOTE 3 The R10 series conforms to ISO 3[1] and the R20 series conforms to ISO 497[2].

3.3.4
design coefficient
C
coefficient with a value greater than 1, which takes into consideration service conditions as well as properties of the components of a piping system other than those represented in the lower confidence limit

3.3.5
design stress
σ_S
$\sigma_{S,\theta,t}$
stress derived by dividing the MRS or $CRS_{\theta,t}$ by the design coefficient C, i.e. $\sigma_S = MRS/C$, or $\sigma_{S,\theta,t} = CRS_{\theta,t}/C$

3.4 Definitions related to service conditions

3.4.1
gaseous fuel
any fuel that is in a gaseous state at a temperature of 15 °C, at a pressure of one bar (0,1 MPa)

3.4.2
maximum operating pressure
MOP
maximum effective pressure of the gas in the piping system, expressed in bar, which is allowed in continuous use

NOTE The MOP takes into account the physical and the mechanical characteristics of the components of a piping system and the influence of the gas on these characteristics.

4 Symbols and abbreviated terms

4.1 Symbols

C	design coefficient
d_e	outside diameter at any point
d_{em}	mean outside diameter
$d_{em,max}$	maximum mean outside diameter
$d_{em,min}$	minimum mean outside diameter
d_n	nominal outside diameter
b	wall thickness at any point
e_{min}	minimum wall thickness at any point
e_n	nominal wall thickness
σ_S	design stress
σ_{LPL}	lower confidence limit of the predicted hydrostatic strength

4.2 Abbreviations

$CRS_{\theta,t}$	categorized required strength at temperature θ and time t
MOP	maximum operating pressure
MRS	minimum required strength
PA-U	unplasticized polyamide
R	series of preferred numbers, conforming to the Renard series
SDR	standard dimension ratio

5 Material

5.1 Material of the components

The material from which the components, i.e. the pipes, fittings and valves, are made shall be unplasticized polyamide (PA-U) in accordance with ISO 1874-1.

5.2 Compound

5.2.1 Additives

The compound shall be made of the PA-U base polymer to which are added only those additives that are needed to facilitate the manufacture of pipes and fittings conforming to the applicable parts of ISO 17467.

All additives shall be used according to the national regulations.

5.2.2 Colour

The colour of the compound shall be yellow, black or natural. The natural colour is admitted only for compounds intended to be used for manufacturing fittings and valves.

5.2.3 Identification compound

When applicable, the compound used for identification stripes shall be manufactured from a PA-U polymer manufactured from the same type of base polymer as used in the compound for pipe production.

When applicable, the compound used for an identification layer shall be of the same base polymer and of the same MRS as the compound used for pipe production.

5.2.4 Reprocessable and recyclable materials

Own and external reprocessable materials and recyclable material shall not be used.

5.2.5 Characteristics

The compounds from which the components are manufactured shall be in accordance with Tables 1 and 2.

Unless otherwise specified in the applicable test method, the test pieces shall be conditioned for at least 16 h at 23 °C and 50 % relative humidity in accordance with ISO 291 before testing in accordance with Table 2.