

First edition
2012-06-01

AMENDMENT 1
2014-04-01

**Plastics piping systems for the supply
of gaseous fuels - Unplasticized
polyamide (PA-U) piping systems
with fusion jointing and mechanical
jointing —**

Part 2:
Pipes

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AMENDMENT 1

ISO 16486-2:2012/Amd 1:2014

<https://standards.iteh.ai/standards/iso/16486-2/2012/amd-1/2014>
Systèmes de canalisations en matières plastiques pour la distribution
de combustibles gazeux — Systèmes de canalisations en polyamide
non plastifié (PA-U) avec assemblages par soudage et assemblages
mécaniques —

Partie 2: Tubes

AMENDEMENT 1



Reference number
ISO 16486-2:2012/Amd.1:2014(E)

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Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
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Published in Switzerland

Foreword

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Amendment 1 to ISO 16486-2:2012 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*.

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Page 9, A.3.6

Replace the existing third paragraph with the following one:

“Plug in the heater and bring the surface temperatures up to the temperature range (220 °C to 260 °C). Install the heater in the butt fusion machine and bring the pipe ends into full contact with the heater. To ensure that full and proper contact is made between the pipe ends and the heater, the initial contact should be under moderate pressure. After holding the pressure very briefly, it should be released without breaking contact. Continue to hold the components in place, without force, while a bead of molten PA-U develops between the heater and the pipe ends. When the proper bead size is formed against the heater surfaces, the heater should be removed. The bead size is dependent on the pipe size. For $d_n \leq 50$ mm, a bead size of approximately 1,5 mm should be present and for $d_n > 50$ mm, a bead size of 3 mm to 5 mm should be present before removing the heater.”

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