INTERNATIONAL STANDARD

ISO 16486-2

> 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 —

iTeh STPart 2: NDARD PREVIEW Pipes (standards.iteh.ai) AMENDMENT 1

ISO 16486-2:2012/Amd 1:2014

https://standards.itch.aSystèmes de canalisations en matières plastiques pour la distribution fid0274de combustibles gazeux — Systèmes de canalisations en polyamide non plastifié (PA-U) avec assemblages par soudage et assemblages mécaniques —

Partie 2: Tubes

AMENDEMENT 1



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Foreword

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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.

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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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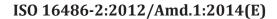
Part 2: **Pipes**

AMENDMENT 1

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 $d_n \le 50$ 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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