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AMENDMENT 1
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Plastics piping systems for the supply of gaseous fuels - Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing —

Part 3: **Fittings**

AMENDMENT 1

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 3: Raccords

AMENDEMENT 1

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Foreword

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AMENDMENT 1

Page 6, 6.2.1, Table 1

Replace the existing table with the following one:

Table 1 — Electrofusion socket dimensions

Dimensions in millimetres

Nominal diameter d_n	Depth of penetration $L_{1,min}$	$L_{1,max}$	Fusion zone $L_{2,min}$
20	25	41	10
25	25	41	10
32	25	44	10
40	25	49	12
50	28	55	15
63	31	63	19
75	35	70	22
90	40	79	26
110	53	82	32
125	58	87	36
140	62	92	40
160	68	98	46
180	74	105	52
200	80	112	57
225	88	120	64
250	95	129	71

Page 8, 6.3, Figure 2

Replace the existing key with the following one:

Key

D_1 mean outside diameter of fusion end piece[a]

D_2 bore comprising minimum diameter of flow channel through body of fitting[b]

E body wall thickness of fitting[c]

E_1 fusion face wall thickness[d]

L_1 cut-back length of fusion end piece[e]

L_2 tubular length of fusion end piece[f]

a D_1 is measured in any plane parallel to the plane of the entrance face at a distance $L_2/2$.

b The measurement of this diameter does not include the fusion bead (if present).

c It comprises the thickness measured at any point of the wall of the fitting.

d It is measured at any point at a maximum distance of L_1 (cut-back length) from the entrance face and shall be equal to the pipe wall thickness and tolerance to which it is intended to be butt fused.

e It comprises the initial depth of the spigot end necessary for butt fusion or reweld and may be obtained by joining a length of pipe to the spigot end of the fitting provided the wall thickness of the pipe is equal to E_1 for its entire length.

f It comprises the initial length of the fusion end piece and shall allow the following (in any combination): the use of clamps required in the case of butt fusion; assembly with an electrofusion fitting.

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