



SLOVENSKI STANDARD

SIST EN 1254-8:2021

01-julij-2021

Nadomešča:
SIST EN 1254-8:2014

Baker in bakrove zlitine - Fitingi - 8. del: Fitingi s stiskalnimi priključki za spajanje s plastičnimi in večplastnimi cevmi

Copper and copper alloys - Plumbing fittings - Part 8: Press fittings for use with plastics and multilayer pipes

Kupfer und Kupferlegierungen - Fittings - Teil 8: Pressfittings für den Einsatz mit Kunststoff- und Mehrschichtverbundrohren

Cuivre et alliages de cuivre - Raccords - Partie 8 : Raccords à sertir pour tubes en matières plastiques et multicouches

Ta slovenski standard je istoveten z: EN 1254-8:2021

ICS:

23.040.40	Kovinski fittingi	Metal fittings
77.150.30	Bakreni izdelki	Copper products

SIST EN 1254-8:2021

en,fr,de

iTeh STANDARD PREVIEW
(standards.iteh.ai)

[SIST EN 1254-8:2021](#)

<https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021>

EUROPEAN STANDARD

EN 1254-8

NORME EUROPÉENNE

EUROPÄISCHE NORM

May 2021

ICS 23.040.40

Supersedes EN 1254-8:2012

English Version

Copper and copper alloys - Plumbing fittings - Part 8: Press fittings for use with plastics and multilayer pipes

Cuivre et alliages de cuivre - Raccords - Partie 8 :
Raccords à sertir pour tubes en matières plastiques et
multicouches

Kupfer und Kupferlegierungen - Fittings - Teil 8:
Pressfittings für den Einsatz mit Kunststoff- und
Mehrschichtverbundrohren

This European Standard was approved by CEN on 23 November 2020.

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 CEN-CENELEC 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents		Page
European foreword.....		4
Introduction		5
1 Scope		6
2 Normative references		7
3 Terms and definitions		9
4 Product characteristics		9
4.1 Internal pressure		9
4.2 Tightness		9
4.3 Resistance to high temperature for fittings with elastomeric seals (for heating networks)		10
4.4 Release of dangerous substances		11
4.5 Durability		11
4.6 Wall thickness at threaded portions of adaptor fittings		12
4.7 Dimensions of tail pipe ends for swivel fittings		12
4.8 Dimensions of gas union connectors		12
4.9 Threaded end dimensions		12
4.10 Other adapter ends (not defined in EN 1254-20:2021)		12
4.11 Bore dimensions		12
4.12 Identity of elastomeric sealing material for liquid applications		12
4.13 Identity of elastomeric sealing material for gas applications		13
4.14 Pipe abutment		13
4.15 Alignment of the fitting ends		13
4.16 Shapes for tightening systems		13
4.17 Surface condition		13
4.18 Plated or coated surfaces		13
4.19 Internal support		13
5 Testing, assessment and sampling methods		13
5.1 General		13
5.2 Internal pressure		14
5.3 Tightness		15
5.4 Durability		18
5.5 Wall thickness at threaded portions of adaptor fittings		19
5.6 Dimensions of tail pipe ends for swivel fittings		19
5.7 Dimensions of gas union connectors		20
5.8 Threaded end dimensions		20
5.9 Bore dimensions		20
5.10 Identity of elastomeric sealing material for liquid applications		20
5.11 Identity of elastomeric sealing material for gas applications		20
5.12 Alignment of the fitting ends		20
6 Evaluation of conformity		20
6.1 General		20
6.2 Type testing		21
6.3 Factory production control (FPC)		26
7 Designation		30
8 Marking, labelling and packaging		30
8.1 General		30

8.2	Additional marking	30
8.3	Dezincification resistant copper zinc alloys	31
	Bibliography	32

iTeh STANDARD PREVIEW
(standards.iteh.ai)

[SIST EN 1254-8:2021](https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021)

<https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021>

EN 1254-8:2021 (E)**European foreword**

This document (EN 1254-8:2021) has been prepared by Technical Committee CEN/TC 133 “Copper and copper alloys”, the secretariat of which is held by DIN.

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 November 2021, and conflicting national standards shall be withdrawn at the latest by November 2021.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 1254-8:2012.

The main changes compared to EN 1254-8:2012 are:

- improved alignment with plastics and multilayer pipe standards for hot and cold water applications;
- separation of test methods into part 20.

This part of the standard (EN 1254-8) should be read in conjunction with EN 1254-20:2021.

EN 1254 comprises the following parts under the general title “Copper and copper alloys — Plumbing fittings”:

- STANDARD PREVIEW**
(standards.iteh.ai)
- Part 1: Capillary fittings for soldering or brazing to copper tubes
SIST EN 1254-8:2021
 - Part 2: Compression fittings for use with copper tubes
<https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021>
 - Part 3: Compression fittings for use with plastics and multilayer pipes
 - Part 4: Threaded fittings
 - Part 5: Capillary fittings with short ends for brazing to copper tubes
 - Part 6: Push-fit fittings for use with metallic tubes, plastics and multilayer pipes
 - Part 7: Press fittings for use with metallic tubes
 - Part 8: Press fittings for use with plastics and multilayer pipes
 - Part 20: Definitions, thread dimensions, test methods, reference data and supporting information

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Introduction

Products complying with this document may be used for several fluids including the transport of water intended for human consumption if they comply with the relevant national, regional or local regulatory provisions applicable in the place of use.

iTeh STANDARD PREVIEW (standards.iteh.ai)

[SIST EN 1254-8:2021](https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021)

<https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021>

EN 1254-8:2021 (E)**1 Scope**

This document specifies product characteristics, assessment methods, compliance criteria of test results and a designation system for fittings with radial and axial press ends for use with plastics and multilayer pipes. The fitting ends have a nominal diameter from 10 mm to 160 mm. The fittings are designed for a service lifetime up to fifty.

This document applies to copper alloy fittings. A non-exhaustive list of these copper alloys is given in CEN/TS 13388.

Adaptor fittings for use with plastics and multilayer pipes may combine press ends with fitting ends defined in the other parts of EN 1254.

Press fittings for use with plastics and multilayer pipes may also have flanged end connections according to EN 1092-3.

Press fittings for use with plastics and multilayer pipes may also have a plated or other decorative surface coating.

Fittings can be produced by machining, metal forming, casting, or fabrication.

Products covered by this document are intended to be used in:

a) liquid applications:

- hot, cold or combined hot and cold water, including systems according to EN 806;
- closed heating systems according to EN 12828;
- cooling systems;
- drainage systems;
- fire protection systems including sprinkler systems according to EN 12845;
- supply systems for points of consumption with liquid fuels according to EN 12514.

b) gas applications:

- natural gas and liquefied petroleum gas systems with a maximum operating pressure less than or equal to 5 bar according to EN 1775;
- compressed air systems.

iTech STANDARD PREVIEW
(standards.iteh.ai)

[SIST EN 1254-8:2021](https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021)

<https://standards.iteh.ai/catalog/standards/sist/73460342-a0b1-4d1c-aecd-71079ad10167/sist-en-1254-8-2021>

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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.

EN 549:2019, *Rubber materials for seals and diaphragms for gas appliances and gas equipment*

EN 681-1:1996, *Elastomeric seals — Materials requirements for pipe joint seals used in water and drainage applications — Part 1: Vulcanized rubber*

EN 682, *Elastomeric seals — Materials requirements for seals used in pipes and fittings carrying gas and hydrocarbon fluids*

EN 1254-20:2021, *Copper and copper alloys — Plumbing fittings — Part 20: Definitions, thread dimensions, test methods, reference data and supporting information*

EN 10226-3, *Pipes threads where pressure tight joints are made on the threads — Part 3: Verification by means of limit gauges*

EN 12201-2, *Plastics piping systems for water supply, and for drainage and sewerage under pressure - Polyethylene (PE) — Part 2: Pipes*

EN 12201-5, *Plastics piping systems for water supply, and for drainage and sewerage under pressure - Polyethylene (PE) — Part 5: Fitness for purpose of the system*

EN 12502-2, *Protection of metallic materials against corrosion — Guidance on the assessment of corrosion likelihood in water distribution and storage systems — Part 2: Influencing factors for copper and copper alloys*

EN ISO 3501, *Plastics piping systems — Mechanical joints between fittings and pressure pipes — Test method for resistance to pull-out under constant longitudinal force (ISO 3501)*

EN ISO 3503, *Plastics piping systems — Mechanical joints between fittings and pressure pipes — Test method for leaktightness under internal pressure of assemblies subjected to bending (ISO 3503)*

EN ISO 6506-1, *Metallic materials — Brinell hardness test — Part 1: Test method (ISO 6506-1)*

EN ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method (ISO 6507-1)*

EN ISO 1167 (all parts), *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure (ISO 1167)*

EN ISO 13056, *Plastics piping systems — Pressure systems for hot and cold water — Test method for leaktightness under vacuum (ISO 13056)*

EN ISO 15874-2, *Plastics piping systems for hot and cold water installations — Polypropylene (PP) — Part 2: Pipes (ISO 15874-2)*

EN ISO 15874-5, *Plastics piping systems for hot and cold water installations — polypropylene (PP) — Part 5: Fitness for purpose of the system (ISO 15874-5)*

EN ISO 15875-2, *Plastics piping systems for hot and cold water installations — Cross-linked polyethylene (PE-X) — Part 2: Pipes (ISO 15875-2)*

EN 1254-8:2021 (E)

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)*

EN ISO 15876-2, *Plastics piping systems for hot and cold water installations — Polybutylene (PB) — Part 2: Pipes (ISO 15876-2)*

EN ISO 15876-5, *Plastics piping systems for hot and cold water installations — Polybutylene (PB) — Part 5: Fitness for purpose of the system (ISO 15876-5)*

EN ISO 15877-2, *Plastics piping systems for hot and cold water installations — Chlorinated poly(vinyl chloride) (PVC-C) — Part 2: Pipes (ISO 15877-2)*

EN ISO 15877-5, *Plastics piping systems for hot and cold water installations — Chlorinated poly(vinyl chloride) (PVC-C) — Part 5: Fitness for purpose of the system (ISO 15877-5)*

EN ISO 19892, *Plastics piping systems — Thermoplastics pipes and associated fittings for hot and cold water — Test method for resistance of joints to pressure cycling (ISO 19892)*

EN ISO 19893, *Plastics piping systems — Thermoplastics pipes and fittings for hot and cold water — Test method for the resistance of mounted assemblies to temperature cycling (ISO 19893)*

EN ISO 21003-2, *Multilayer pipe systems for hot and cold water installations inside buildings — Part 2: Pipes (ISO 21003-2)*

EN ISO 21003-5, *Multilayer pipe systems for hot and cold water installations inside buildings — Part 5: Fitness for purpose of the system (ISO 21003-5)*

EN ISO 22391-2, *Plastics piping systems for hot and cold water installations — Polyethylene of raised temperature resistance (PE-RT) — Part 2: Pipes (ISO 22391-2)*

EN ISO 22391-5, *Plastics piping systems for hot and cold water installations — Polyethylene of raised temperature resistance (PE-RT) — Part 5: Fitness for purpose of the system (ISO 22391-5)*

ISO 7-2, *Pipe threads where pressure tight joints are made on the threads — Part 2: Verification by means of limit gauges*

ISO 228-2, *Pipe threads where pressure tight joints are not made on the threads — Part 2: Verification by means of limit gauges*

ISO 2859-1:1999, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

ISO 9924-1, *Rubber and rubber products — Determination of the composition of vulcanizates and uncured compounds by thermogravimetry — Part 1: Butadiene, ethylene-propylene copolymer and terpolymer, isobutene-isoprene, isoprene and styrene-butadiene rubbers*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 1254-20:2021 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

4 Product characteristics

4.1 Internal pressure

4.1.1 For liquid applications

When tested according to the method in 5.2.1 fittings shall show no signs of leakage or permanent distortion.

4.1.2 For fuel gas applications

When tested according to the method in 5.2.2 fittings shall show no signs of leakage or permanent distortion.

4.1.3 For compressed air applications

When tested according to the method in 5.2.3 fittings shall show no signs of leakage or permanent distortion.

4.2 Tightness

4.2.1 Integrity of fabricated fitting bodies or having an 'as cast' microstructure

This requirement only applies to fitting bodies with an 'as cast' microstructure (excluding continuously cast materials) or fabricated by welding or brazing.

When tested according to the method in 5.3.1.1 fitting bodies shall show no visual indication of leakage.

4.2.2 Requirements for liquid applications

4.2.2.1 Leak tightness under internal hydrostatic pressure

Fittings assessed as indicated in 4.1.1 are considered to be leak tight under internal hydrostatic pressure.

4.2.2.2 Leak tightness under vacuum

When tested according to the method in 5.3.2.1 the change in pressure shall not be greater than 0,05 bar at the conclusion of the test.

4.2.2.3 Leak tightness under temperature cycling (for heating networks)

When tested according to the method in 5.3.2.2 fittings shall show no signs of leakage or permanent distortion.

EN 1254-8:2021 (E)**4.2.2.4 Resistance to pull-out**

When tested according to the method in 5.3.1.2 the joint assemblies shall withstand the pull-out force without being separated and shall show no signs of leakage when subjected to the subsequent leak tightness under internal hydrostatic pressure test as described in 5.2.1.

4.2.2.5 Leak tightness under internal hydrostatic pressure while subject to bending

When tested according to the method in 5.3.2.3 fittings shall show no signs of leakage or permanent distortion.

4.2.2.6 Leak before press

If the manufacturer claims this feature, then when tested according to the method in 5.3.2.4 fittings shall leak at least one water drop per second.

4.2.3 Requirements for gas applications**4.2.3.1 Leak tightness under internal pneumatic pressure**

Fittings assessed as indicated in 4.1.2 and 4.1.3 are considered to be leak tight under internal pneumatic pressure.

4.2.3.2 Resistance to pull-out

When tested according to the method in 5.3.1.2 the joint assemblies shall withstand the pull-out force without being separated and shall show no signs of leakage when subsequently tested according to the method in 5.2.2 and/or 5.2.3 according to the application, fittings shall show no signs of leakage or permanent distortion.

4.2.3.3 Leak tightness under temperature cycling for fuel gas applications

When tested according to the test method in 5.3.3.1 fittings shall show no signs of leakage.

4.2.3.4 Leak before press

If the manufacturer claims this feature, then when tested according to the method in 5.3.3.2 fittings shall leak at least one bubble per second when tested pneumatically.

4.2.3.5 Press fitting with elastomeric seals for fuel gas application inside buildings

The main aspect for the durability of tightness for fuel gas application inside buildings is the ozone behaviour of the elastomer. Therefore the elastomer shall be ozone resistant and comply with the requirements of EN 549 class B2 or higher.

4.2.3.6 Press fitting with elastomeric seals for fuel gas application outside buildings

The main aspect for the durability of tightness for fuel gas application outside buildings depends on the elastomeric sealing element. Therefore, the elastomer shall comply with the requirements of EN 682 types GAL or GBL.

4.3 Resistance to high temperature for fittings with elastomeric seals (for heating networks)

The main aspect for the resistance to high temperature liquid applications depends on the elastomeric sealing element. Therefore the elastomer shall have the appropriate characteristics as specified in EN 681-1. The elastomeric sealing elements shall conform to the requirements of EN 681-1:1996, Table 3 for continuous hot water supply up to 110 °C except for Isoprene-Isobutylene Copolymer (IIR) where a volume change in water up to and including 15 % is permitted.