



# SLOVENSKI STANDARD

## SIST EN 1254-20:2021

01-julij-2021

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### Baker in bakrove zlitine - Fitingi - 20. del: Definicije, mere navojev, preskusne metode, referenčni podatki in dodatne informacije

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

Kupfer und Kupferlegierungen - Fittings - Teil 20: Definitionen, Gewindeabmessungen, Prüfverfahren, Referenzdaten und ergänzende Informationen

Cuivre et alliages de cuivre - Raccords - Partie 20 : Définitions, dimensions de filetage, méthodes d'essai, données de référence et informations complémentaires

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Ta slovenski standard je istoveten z: EN 1254-20:2021

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EUROPEAN STANDARD

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## Copper and copper alloys - Plumbing fittings - Part 20: Definitions, thread dimensions, test methods, reference data and supporting information

Cuivre et alliages de cuivre - Raccords - Partie 20 :  
Définitions, dimensions de filetage, méthodes d'essai,  
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Kupfer und Kupferlegierungen - Fittings - Teil 20:  
Definitionen, Gewindeabmessungen, Prüfverfahren,  
Referenzdaten und ergänzende Informationen

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

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

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## European foreword

This document (EN 1254-20:2021) 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of an identical text or by endorsement, at the latest by November 2021, and conflicting national standards shall be withdrawn at the latest by November 2021.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 is a supporting standard describing the test methods used by the other parts of the EN 1254 series.

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

- *Part 1: Capillary fittings for soldering or brazing to copper tubes*
- *Part 2: Compression fittings for use with copper tubes*
- *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.

**EN 1254-20:2021 (E)****1 Scope**

This document contains definitions, thread dimension, reference data (minimum bore), supporting information (assembling instructions) and describes the test methods referenced by other parts of the EN 1254 series.

Thread dimensions comprise: wall thickness at threaded portions of fittings, dimensions of tail pipe ends for swivel fittings, dimensions of gas union connectors, thread dimensions and thread profile.

Test methods comprise: leak tightness under internal hydrostatic pressure, leak tightness under internal pneumatic pressure, integrity of fabricated fitting bodies or having an 'as cast' microstructure, resistance to pull out of joints to metallic tubes, resistance of joints with metallic tube to vibration, resistance of joints to static flexural force, leak tightness of joints under vacuum, the resistance of joints to temperature cycling, detecting non-pressed fitting ends, resistance to stress corrosion, detection of a carbon film on the surface of copper fittings, determination of mean depth of dezincification, resistance of joints to pressure cycling, disconnection and re-use, determining if the diameter and/or the length of engagement of a capillary end is/are within the specified tolerance, determining the minimum length of engagement of an integral solder or brazing ring socket having a formed groove.

**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 723, *Copper and copper alloys - Combustion method for determination of the carbon content on the inner surface of copper tubes or fittings*

EN 1057, *Copper and copper alloys - Seamless, round copper tubes for water and gas in sanitary and heating applications*

EN 1333:2006, *Flanges and their joints - Pipework components - Definition and selection of PN*

EN 10226-1, *Pipe threads where pressure tight joints are made on the threads - Part 1: Taper external threads and parallel internal threads - Dimensions, tolerances and designation*

EN ISO 228-1, *Pipe threads where pressure-tight joints are not made on the threads - Part 1: Dimensions, tolerances and designation (ISO 228-1)*

EN ISO 6509-1:2014, *Corrosion of metals and alloys - Determination of dezincification resistance of copper alloys with zinc - Part 1: Test method (ISO 6509-1:2014)*

EN ISO 6708:1995, *Pipework components - Definition and selection of DN (nominal size) (ISO 6708:1995)*

EN ISO 21003-1:2008, *Multilayer piping systems for hot and cold water installations inside buildings - Part 1: General (ISO 21003-1:2008)*

ISO 7-1:1994, *Pipe threads where pressure-tight joints are made on the threads - Part 1: Dimensions, tolerances and designation*

ISO 7-2, *Pipe threads where pressure-tight joints are 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 6957:1988, *Copper alloys - Ammonia test for stress corrosion resistance*



### 3 Terms and definitions

For the purposes of this document and other parts of the EN 1254 series, the following terms and definitions 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 <https://www.iso.org/obp>

#### 3.1

##### **plumbing fitting**

device used in a tube system for the purpose of connecting the tubes or pipes either to each other or to a component part of the system

#### 3.2

##### **capillary end**

end in which the joint is made by the flow of solder or brazing alloy by capillary action into the annular space between the capillary end and its connecting part

#### 3.3

##### **end feed fitting**

##### **EF**

plumbing fitting including one or more capillary ends where the solder or brazing alloy for the capillary action is introduced externally into the annular space when a connection is made

#### 3.4

##### **integral solder ring fitting**

##### **ISR**

plumbing fitting including one or more capillary ends that contains the solder alloy needed to make the connection

#### 3.5

##### **integral brazing ring fitting**

##### **IBR**

plumbing fitting including one or more capillary ends that contains the brazing alloy needed to make the connection

#### 3.6

##### **socket**

type of end defined by its internal diameter

#### 3.7

##### **male end**

type of end defined by its external diameter

#### 3.8

##### **compression end**

end in which a mechanical joint is formed by the tightening of a nut to compress a ring or sleeve onto the outside wall of the tube, or clamp a flared portion of the tube to the body of a fitting

**EN 1254-20:2021 (E)****3.8.1****compression end, Type A, non manipulative**

end that requires no preparation of the ends of the tube or pipe other than that they are cut square and deburred, or chamfered when specified, and in which the joint is made by the compression of a ring or sleeve onto the outside wall of the tube or pipe with or without additional sealing elements and with or without an internal tube support

Note 1 to entry: The sealing element may be metallic or non-metallic.

**3.8.2****compression end, Type B, manipulative**

end that requires forming of the tube or pipe at its end, and in which the joint is made by compressing the formed portion of the tube or pipe against the formed end of the fitting or a loose ring or sleeve within the fitting/tube/pipe

**3.9****union end**

end which enables connection and disconnection with minimal disturbance of other pipe sections

Note 1 to entry: Union ends can be sphere to cone, cone to cone, cone to radius or flat face with a sealing member.

Note 2 to entry: Component parts of union ends from different manufacturers should not be regarded as interchangeable.

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**3.10****interface thread**

end that has male or female jointing or fastening thread, used to connect with a corresponding threaded pipe or fitting

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**3.11****jointing thread**

thread on a fitting end in which the joint is made pressure tight on the thread

**3.12****fastening thread**

thread to provide mechanical assembly of a joint in which the seal is not made on the thread

**3.13****push-fit end**

end which incorporates a sealing element and a gripping device

Note 1 to entry: The joint is made by pushing the tube into the fitting and a seal is achieved without the use of heat or tools.

Note 2 to entry: In some designs, this type of joint can be disconnected and re-connected or disconnected and the fitting re-used elsewhere.

**3.14****supporting sleeve**

device permanently inserted in the tube end to provide internal support for low strength tube or pipe materials

**3.15****press connection**

press end in which the joint is effected by the compression and permanent deformation of the ends of the fitting and/or the tube or male end of a fitting with a pressing tool

**3.15.1****radial press end**

press end in which the joint is effected by radial compression of the ends of the fitting and the tube with a pressing tool

**3.15.2****axial press end**

press end in which the joint is effected by axial movement of a compression sleeve with a tool to compress the ends of the fitting and the tube

**3.15.3****compression sleeve**

sleeve moved along the axis of a pipe to compress a fitting end

**3.16****pressing tools and jaws**

mechanical device which, by closing jaws, either directly or indirectly (axial press end) causes radial compression of the plumbing fitting end onto the connecting tube

**3.17****reducer**

fitting or an adaptor used to enable connections between pipework components of different nominal diameters

**3.18****adaptor fitting**

fitting combining more than one type of end

**3.19****nominal diameter**

nominal diameter of the fitting end expressed as the nominal outside diameter of the connecting tube or pipe

**3.20****multilayer pipe**

pipe comprising more than one layer, see definitions according to EN ISO 21003-1:2008, 3.1.1, 3.1.2 and 3.1.3

**3.21****fuel gas**

combustible gases which are gaseous at 15 °C and 1 013 mbar and are generally odorized for safety reasons, are commonly referred to as manufactured gas, natural gas or liquefied petroleum gases (LPG)

Note 1 to entry: They are also referred to as first, second or third family gases (see EN 437:2018, Table 1).

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**EN 1254-20:2021 (E)****3.22****maximum operating pressure****MOP**

maximum operating pressure at which pipework intended for fluids can be operated under normal operating conditions

**3.23****PN**

alphanumeric designation used for reference purposes related to a combination of mechanical and dimensional characteristics of a component of a pipework system

Note 1 to entry: It comprises the letters PN followed by a dimensionless number.

Note 2 to entry: The maximum allowable pressure of a pipework component depends on the PN number, the material and design of the component, its maximum allowable temperature, etc.

[SOURCE: EN 1333:2006, 2.1]

**3.24****AQL**

Acceptance Quality Limit (AQL) is defined in ISO 2859-1:1999, Table I and IIA

**3.25****DN**

alphanumeric designation of size for components of a pipework system, which is used for reference purposes. It comprises the letters DN followed by a dimensionless whole number which is indirectly related to the physical size, in millimetres, of the bore or outside diameter of the end connections

[SOURCE; EN ISO 6708:1995, 2.1]

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**4 Thread dimensions****4.1 Wall thickness at threaded portions of fittings**

The minimum wall thickness at threaded portions of fittings, see Figure 1, shall be as expressed in Table 1 for the relevant diameters.

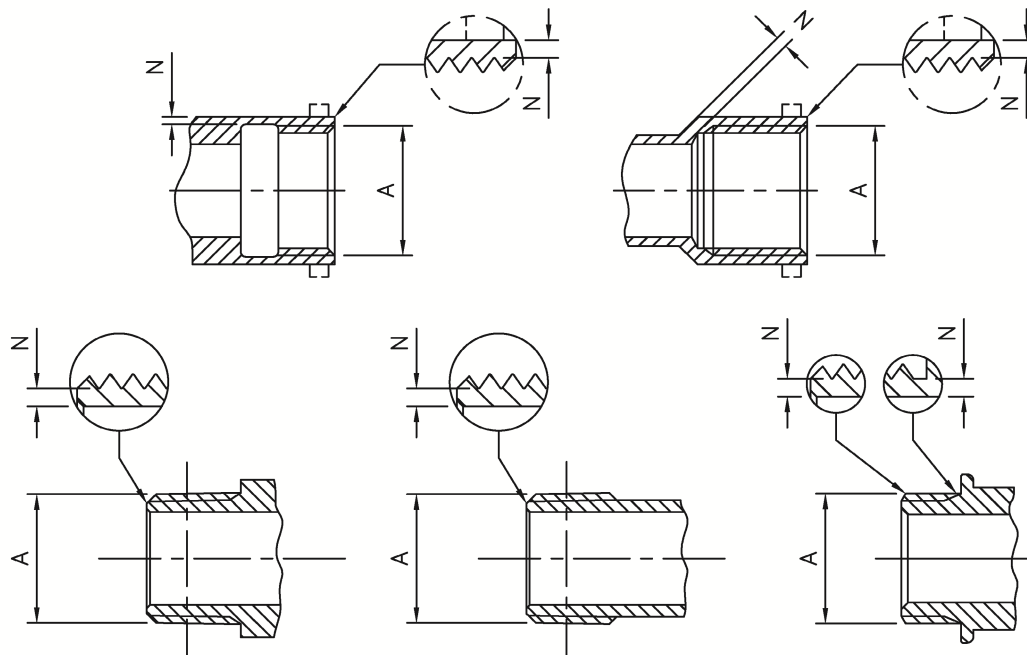


Figure 1 — Minimum wall thickness at threaded portions of fittings

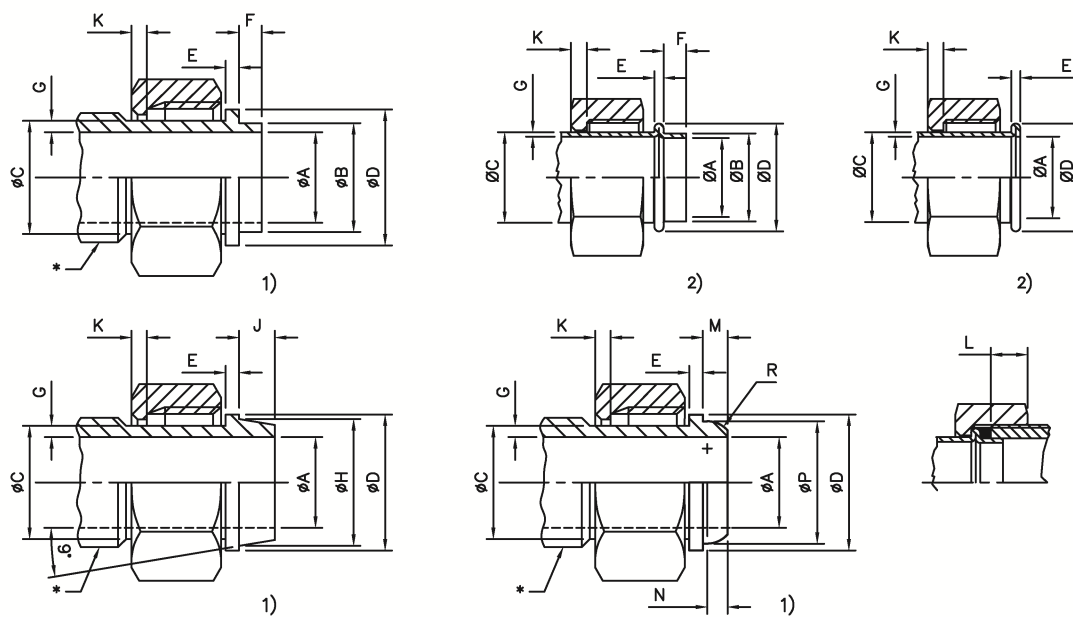
Table 1 — Minimum wall thickness at threaded portions of fittings

Thread designation	Minimum wall thickness of fitting	
	Wrought coppers and copper alloys and continuously cast bar mm	Cast coppers and copper alloys mm
1/8	1,0	1,0
1/4	1,0	1,0
3/8	1,1	1,1
1/2	1,2	1,2
3/4	1,4	1,5
1	1,5	1,8
1 1/4	1,6	1,8
1 1/2	1,8	2,0
2	1,9	2,3
2 1/2	2,0	2,4
3	2,3	2,6
4	2,8	2,9

#### 4.2 Dimensions of tail pipe ends for swivel fittings

The dimensions of tail pipe ends for swivel fittings, see Figure 2, shall be as expressed in Table 2 for the relevant thread size.

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## Key

- 1 wrought or cast alloy body  
2 drawn tubular body

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Figure 2 — Tail pipe ends for swivel fittings

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Table 2 — Dimensions of tail pipe ends for swivel fittings

Dimension	A		B	C	D		E		F		G			
	Nut thread size	Min. (Wrought or drawn tube)	Min. (casting)	Max.	Max.	Max.	Min.	Min. (Wrought or cast)	Min. (Draw tube)	Max.	Min.	Min. (Draw tube)	Min. (Wrought)	Min. (Casting)
	in	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
1/2		11,0	10,2	14,6	15,1	18,5	18,0	2,4	1,4	6,4	4,7	0,7	1,2	1,4
3/4		16,1	15,3	19,8	20,0	24,0	23,5	2,4	1,8	6,4	4,7	0,9	1,4	1,6
1		21,2	20,4	25,7	25,7	30,2	29,4	3,0	1,8	6,4	4,7	0,9	1,5	1,8
1 1/4		25,4	25,4	34,0	33,6	38,9	38,0	3,3	2,0	8,0	6,3	1,0	1,6	1,9
1 1/2		31,7	31,7	39,6	39,2	44,8	43,9	3,8	2,2	9,6	7,9	1,1	1,8	2,2
2		44,4	43,7	50,8	50,7	56,6	55,4	4,0	2,4	9,6	7,9	1,2	2,0	2,3
2 1/2		50,8	50,8	56,6	62,0	71,9	71,0	4,3	2,4	9,6	7,9	1,2	2,0	2,4

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Dimension	H	J	K	L		M	N	P		R	
	Nut thread size	Max.	Min.	Min.	Min. (Taper spigot)	Min. (Parallel and flat)	±0,25	±0,25	Max.	Min.	±0,25
	in	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
1/2		17,0	7,9	2,5	4,5	6,0	5,5	4,5	15,1	14,9	6,0
3/4		22,3	7,9	3,1	4,5	6,0	5,5	4,5	20,4	20,2	6,0
1		28,0	7,9	3,4	5,5	8,0	5,5	4,5	27,1	26,9	6,0
1 1/4		36,9	9,5	3,9	5,5	8,0	7,0	5,5	34,6	34,4	6,0
1 1/2		42,6	9,5	4,7	5,5	8,0	7,0	5,5	41,2	41,1	6,0
2		54,3	12,7	4,7	5,5	8,0	7,5	5,5	50,1	49,9	6,0
2 1/2		60,2	12,7	5,0	6,5	8,0	8,5	6,5	65,2	64,9	7,0

Only dimensions A, B, D and F are relevant for the interface. The other dimensions are informative.