SLOVENSKI STANDARD
SIST EN 12608-1:2016/oprA1:2019

01-julij-2019

Profili iz trdega polivinilklorida (PVC-U) za izdelavo oken in vrat - Razvrščanje, zahteve in preskusne metode - 1. del: Neprevlečeni PVC-U profili s svetlo površino - Dopolnilo A1

Unplasticized poly(vinyl chloride) (PVC-U) profiles for the fabrication of windows and doors - Classification, requirements and test methods - Part 1: Non-coated PVC-U profiles with light coloured surfaces

Profile aus weichmacherfreiem Polyvinylchlorid (PVC-U) zur Herstellung von Fenstern und Türen - Klassifizierung, Anforderungen und Prüfverfahren - Teil 1: Nicht beschichtete PVC-U Profile mit hellen Oberflächen

Profilés de poly(chlorure de vinyle) non plastifié (PVC-U) pour la fabrication des fenêtres et des portes - Classification, exigences et méthodes d'essai - Partie 1 : Profilés en PVC-U non revêtus avec des faces de teinte claire

Ta slovenski standard je istoveten z: **EN 12608-1:2016/prA1**

ICS:

83.140.99	Drugi izdelki iz gume in polimernih materialov	Other rubber and plastics products
91.060.50	Vrata in okna	Doors and windows

SIST EN 12608-1:2016/oprA1:2019 **en,fr,de**

EUROPEAN STANDARD

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ICS 83.140.99; 91.060.50

English Version

Unplasticized poly(vinyl chloride) (PVC-U) profiles for the fabrication of windows and doors - Classification, requirements and test methods - Part 1: Non-coated PVC-U profiles with light coloured surfaces - Amendment 1

Profilés de poly(chlorure de vinyle) non plastifié (PVC-U) pour la fabrication des fenêtres et des portes - Classification, exigences et méthodes d'essai - Partie 1 : Profilés en PVC-U non revêtus avec des faces de teinte claire - Amendement 1

Profile aus weichmacherfreiem Polyvinylchlorid (PVC-U) zur Herstellung von Fenstern und Türen - Klassifizierung, Anforderungen und Prüfverfahren - Teil 1: Nicht beschichtete PVC-U Profile mit hellen Oberflächen - Änderung 1

This draft amendment is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 249.

This draft amendment A1, if approved, will modify the European Standard EN 12608-1:2016. If this draft becomes an amendment, CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant national standard without any alteration.

This draft amendment was established by CEN 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.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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European foreword

This document (EN 12608-1:2016/prA1:2019) has been prepared by Technical Committee CEN/TC 249 "Plastics"[1], the secretariat of which is held by NBN.

This document is currently submitted to the CEN Enquiry.

1 Through its working group WG 21, "Profiles for windows and doors" (secretariat: DIN).

1 Modifications to Clause 2, Normative references

Delete the following references:

EN 477, *Unplasticized polyvinylchloride (PVC-U) profiles for the fabrication of windows and doors — Determination of the resistance to impact of main profiles by falling mass*

EN 478, *Unplasticized polyvinylchloride (PVC-U) profiles for the fabrication of windows and doors — Appearance after exposure at 150 °C — Test method*

EN 479, *Unplasticized polyvinylchloride (PVC-U) profiles for the fabrication of windows and doors — Determination of heat reversion*

EN 513, *Unplasticized polyvinylchloride (PVC-U) profiles for the fabrication of windows and doors — Determination of the resistance to artificial weathering*

EN 514, *Unplasticized polyvinylchloride (PVC-U) profiles for the fabrication of windows and doors — Determination of the strength of welded corners and T-joints*

EN ISO 1163-2:1999, *Plastics — Unplasticized poly(vinyl chloride) (PVC-U) moulding and extrusion materials — Part 2: Preparation of test specimens and determination of properties (*ISO 1163-2*:*1995*)*

Add the following references:

EN 477, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the resistance to impact of profiles by falling mass*

EN 478, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the appearance after exposure at 150 °C*

EN 479, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of heat reversion*

EN 513, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the resistance to artificial weathering*

EN 514, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the strength of welded corners and T-joints*

EN ISO 21306-2:—[2], *Plastics — Unplasticized poly(vinyl chloride) (PVC-U) moulding and extrusion materials — Part 2: Preparation of test specimens and determination of properties (*ISO 21306-2*:—)*

[2] Under preparation. Stage at the time of publication: Fpr EN ISO 21306-2:—.

2 Modification to Clause 3, Terms and definitions

Delete Figure 1

*Replace Note 1 to entry of term **3.2.6 sight surface** with:*

Note 1 to entry: See Figure C.1 in Annex C.

*Replace Note 1 to entry of term **3.3.3 depth (of a profile)** with:*

Note 1 to entry: See "*d*" in Figure 1.

*Replace Note 1 to entry of term **3.3.4 overall width (of a profile)** with:*

Note 1 to entry: See "*w*" in Figure 1.

Change Title of current Figure 2 to "Figure 1"

*Introduce abbreviations to terms **3.4.4** and **3.4.5** as follows:*

3.4.4
non-UV resistant virgin material
NUVM

3.4.5
own reprocessed material
ORM

3 Modification to 4.2, Classification of climatic zones

Add the following NOTE after the last paragraph:

NOTE For the purpose of this document, "moderate climate" refers in general to warm and humid weathering conditions and "severe climate" to hot and dry weathering conditions. The relevant moderate and severe test methods for artificial weathering can be found in EN 513.

4 Modification to 4.4, Classification of main profiles according to the wall thickness of the external walls

Replace the first two paragraphs with:

For the wall thickness of the external walls, the main profiles shall be classified according to Figure 2 and Table 3.

Figure 2 shows the areas of typical profiles where the wall thicknesses of external walls shall satisfy the requirements given in Table 3.

Replace current Figure 3 with new Figure 2:

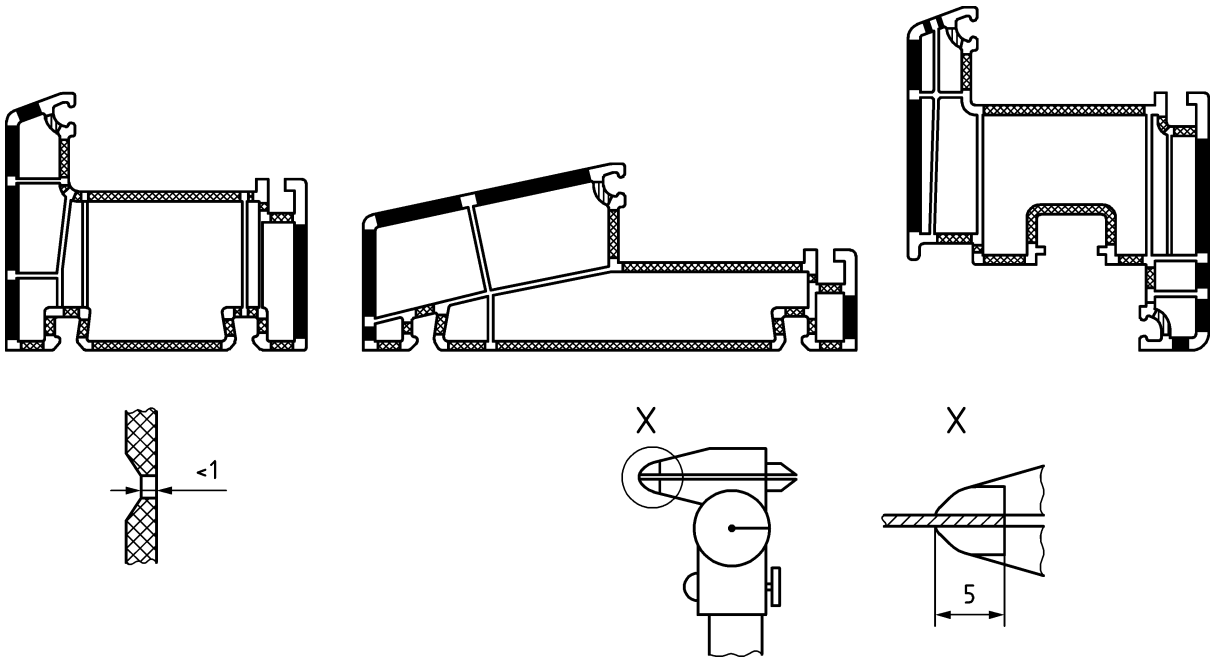

Figure 2 — Areas of three typical profiles with required wall thicknesses

Replace Table 3 with:

Table 3 — Classification of main profiles according to wall thickness

Type of wall	Class A	Class B	Class C
sight surface	≥ 2,8 mm	≥ 2,5 mm	No requirement
non-sight surface	≥ 2,5 mm	≥ 2,0 mm	No requirement
seal groove	≥ 2,0 mm	≥ 2,0 mm	No requirement
not to consider	No requirement	No requirement	No requirement

Replace the last paragraph with:

Sight surfaces of typical profiles are shown in Figure C.1 in Annex C.

5 Modification to 5.3.2, Nominal shape

Replace the second paragraph with:

The tolerances of the external dimensions of the profile (see Figure 1) with respect to the nominal profile shape shall be in accordance with Table 5.

6 Modification to 5.3.3, Wall thickness of main profiles

Replace the first paragraph with:

The wall thickness of the main profile according to Figure 2 shall be declared by the manufacturer according to Table 3.

Delete Figure 4

7 Modification to 5.9.1, Exposure procedure

Replace the 1st paragraph with:

Test specimens shall be taken from sight surfaces of the profiles and shall be exposed in accordance with EN 513, Method 1 or Method 2, for a time period representing five years of outdoor weathering in the climatic zone M or S, respectively.

8 Modification to 5.9.3, Colour fastness

Replace the 1st paragraph with:

After an exposure in accordance with 5.9.1, the change in colour, evaluated in accordance with 6.5, between the unexposed and exposed test specimens, expressed as ΔE^*, shall be ≤ 5 and $| \Delta b^* |$ shall be ≤ 3.

9 Modification to Clause 7, Marking

Change the Title of Clause 7 to:

7 Traceability

Replace the body text with:

7.1 Main profiles

7.1.1 For main profiles, the profile producers shall ensure traceability according to 7.1.2.

7.1.2 The following minimum information shall be traceable:

— the name or trade mark of the manufacturer;

— reference to EN 12608-1;

— climatic zone classification;

— resistance to impact by falling mass classification;

— wall thickness classification;

— in case of use of recycled material: RM_a;

— production code sufficient to enable traceability (e.g. date, machine and/or shift number).

EXAMPLE ABC LTD — EN 12608-1 — M — II — C — 12.04.17,38,2 [in case of writing]

Optional additional information contained within the traceability may include, e.g.:

— profile type/code;

— level of third party involvement (attestation).