
Cevni sistemi iz polimernih materialov za napeljave z vročo in hladno vodo - Polietilen s povišano temperaturno odpornostjo (PE-RT) - 3. del: Fitingi - Dopolnilo A2 (ISO 22391-3:2009/DAM 2:2020)

Plastics piping systems for hot and cold water installations - Polyethylene of raised temperature resistance (PE-RT) - Part 3: Fittings - Amendment 2 (ISO 22391-3:2009/DAM 2:2020)

Kunststoff-Rohrleitungssysteme für die Warm- und Kaltwasser-Installation - Polyethylen erhöhter Temperaturbeständigkeit (PE-RT) - Teil 3: Formstücke - Änderung 2 (ISO 22391-3:2009/DAM 2:2020)

Systèmes de canalisations en plastique pour les installations d'eau chaude et froide - Polyéthylène de meilleure résistance à la température (PE-RT) - Partie 3: Raccords - Amendment 2 (ISO 22391-3:2009/DAM 2:2020)

Ta slovenski standard je istoveten z: EN ISO 22391-3:2009/prA2

ICS:

23.040.45	Fitingi iz polimernih materialov	Plastics fittings
91.140.60	Sistemi za oskrbo z vodo	Water supply systems

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DRAFT AMENDMENT

ISO 22391-3:2009/DAM 2

ISO/TC 138/SC 2

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Plastics piping systems for hot and cold water installations — Polyethylene of raised temperature resistance (PE-RT) —

Part 3: Fittings

AMENDMENT 2

Systèmes de canalisations en plastique pour les installations d'eau chaude et froide — Polyéthylène de meilleure résistance à la température (PE-RT) —

Partie 3: Raccords
AMENDEMENT 2

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This document was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 155, *Plastics piping systems and ducting systems*, in collaboration with ISO Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 2, *Plastics pipes and fittings for water supplies*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

A list of all parts in the ISO 15875 series can be found on the ISO website.

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Plastics piping systems for hot and cold water installations — Polyethylene of raised temperature resistance (PE-RT) —

Part 3: Fittings

AMENDMENT 2

Page 1, Clause 2

Add the normative references

ISO 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

ISO 2768-2, *General tolerances — Part 2: Geometrical tolerances for features without individual tolerance indications*

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

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

ISO 6509-2, *Corrosion of metals and alloys — Determination of dezincification resistance of copper alloys with zinc — Part 2: Assessment criteria*

ISO 6957, *Copper alloys — Ammonia test for stress corrosion resistance*

Delete the normative reference

EN 1254-3, *Copper and copper alloys — Plumbing fittings — Part 3: Fittings with compression ends for use with plastics pipes*

Page 3, [Clause 3.2.1](#)

Replace the existing [Clause 3.2.1](#) with the new [Clause 3.2.1](#) below.

3.2.1 compression fitting

fitting with internal support in which the joint is made by screwing a union nut along a thread to compress a ring on the outside wall of the pipe and finally to cause a clamping of the pipe between the ring and the inner support of the fitting

Note 1 to entry: The fitting may be with or without sealing element

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Page 3, [Clause 3.2.2](#)

Replace the existing [Clause 3.2.2](#) with the new [Clause 3.2.2](#) below.

3.2.2**radial press fitting**

fitting, with internal support in which the joint is made by a radial compression of a ring with a pressing tool on the outside wall of the pipe to cause a clamping of the pipe between the ring and the inner support of the fitting

Note 1 to entry: The fitting may be with or without sealing element

Page 3, new term

Add new term [3.2.5](#) below.

3.2.5**axial press fitting**

fitting with internal support in which the joint is made by an axial movement of a sleeve with a pressing tool to cause a clamping of the pipe between the sleeve and the inner support of the fitting

Note 1 to entry: The fitting may be with or without sealing element

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Page 3, new term

Add new term [3.2.6](#) below.

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3.2.6**Push-fit fitting**

fitting, which incorporates a sealing element, a gripping device and uses an internal support. The joint is made by pushing the pipe into the fitting and a seal is achieved without the use of heat or tools.

Note 1 to entry: In some designs, this type of joint can be disconnected and re-connected or disconnected and the fitting re-used elsewhere.

Note 2 to entry: The internal support can be an integrated part of the fitting or a separate part (supporting sleeve).

Page 5, [Clause 4.2](#)

Replace the existing [Clause 4.2](#) with the new [Clause 4.2](#) below.

4.2 Metallic fitting material

Metallic materials for fittings intended to be used with components conforming to ISO 15875 shall be either copper alloys or stainless steel alloys. The alloys shall be defined according to a standard or regulatory document.

NOTE Examples for such standards and regulatory documents are listed in the bibliography.

For copper alloys, the fittings made thereof have to comply with the corrosion resistance requirements according to [Clause 8.2](#)

Page 5, Clause 5.1

Replace the existing Clause 5.1 with the new clause below.

5.1 Appearance

5.1.1 Appearance of plastic fittings

When viewed without magnification, the internal and external surfaces of fittings shall be smooth, clean and free from scoring, cavities and other surface defects to an extent that would prevent conformance with this standard. The material shall not contain visible impurities. Slight variations in appearance of the colour shall be permitted. Each end of a fitting shall be square to its axis.

5.1.2 Appearance of metal fittings

When viewed without magnification, the internal and external surfaces of fittings shall be clean, free from any residues from the production (e.g. free from cast sand, grease or release agent) and shall have no sharp edges or cracks.

Page 6, Clause 5.2

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Replace the existing title of Clause 5.2 with the new title below.

5.2 Opacity of plastic fittings

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Page 6, Clause 6.1, first sentence

Replace the existing 1st sentence of Clause 6.1 with the new two sentences below

Dimensions of plastic fittings shall be measured in accordance with ISO 3126.

Dimensions of metal fittings shall be measured in accordance with ISO 2768-1 and/or part 2.

Page 9, Clause 6.3

Replace the existing Clause 6.3 with the new Clause 6.3 below.

6.3 Dimensions of metallic fittings - minimum wall thickness of fittings made of copper alloys

The minimum wall thickness shall be measured with a calibrated micrometer or equivalent instrument. The wall thickness shall be measured at three or more discrete places and efforts shall be made to find the minimum.

The minimum wall thickness at points A, B and C of the fitting (see [Annex A, Figure A.1, Figure A.2 and Figure A.3](#)) shall be in accordance with [Annex A, Table A.1](#) and [Figure A.1, A.2 and A.3](#) for fittings from rod, pressings or castings

The minimum wall thickness specified does not apply along the cone angle or to the thickness of the loose ring or sleeve where such a ring or sleeve has been or is intended to be deformed to form a seal. It also does not apply to internal pipe supports.