

Copper and copper alloys - Plumbing fittings - Part 7:  
Press fittings for use with metallic tubes

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## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

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Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 26.05.2021.	Date of Availability of the European standard is 26.05.2021.
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EUROPEAN STANDARD

EN 1254-7

NORME EUROPÉENNE

EUROPÄISCHE NORM

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English Version

## Copper and copper alloys - Plumbing fittings - Part 7: Press fittings for use with metallic tubes

Cuivre et alliages de cuivre - Raccords - Partie 7 :  
Raccords à sertir pour tubes métalliques

Kupfer und Kupferlegierungen - Fittings - Teil 7:  
Pressfittings für den Einsatz mit metallischen Röhren

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.

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

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

<b>Contents</b>		Page
European foreword.....		4
Introduction .....		5
1	Scope.....	6
2	Normative references.....	7
3	Terms and definitions .....	8
4	Product characteristics.....	8
4.1	Internal pressure .....	8
4.2	Tightness.....	8
4.3	Resistance to high temperature (for heating networks) .....	10
4.4	Release of dangerous substances.....	10
4.5	Durability .....	10
4.6	Wall thickness at threaded portions of adaptor fittings.....	11
4.7	Dimensions of tail pipe ends for swivel fittings.....	11
4.8	Dimensions of gas union connectors .....	11
4.9	Threaded end dimensions .....	11
4.10	Other adapter ends (not defined in EN 1254-20:2021) .....	11
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.....	12
4.14	Tube abutment.....	12
4.15	Alignment of the fitting ends.....	12
4.16	Shapes for tightening systems.....	12
4.17	Surface condition .....	12
4.18	Plated or coated surfaces .....	13
5	Testing, assessment and sampling methods .....	13
5.1	General.....	13
5.2	Internal pressure .....	13
5.3	Tightness.....	14
5.4	Durability .....	16
5.5	Wall thickness at threaded portions of adaptor fittings.....	17
5.6	Dimensions of tail pipe ends for swivel fittings.....	17
5.7	Dimensions of gas union connectors .....	17
5.8	Threaded end dimensions .....	18
5.9	Bore dimensions.....	18
5.10	Identity of elastomeric sealing material for liquid applications .....	18
5.11	Identity of elastomeric sealing material for gas applications.....	18
5.12	Alignment of the fitting ends.....	18
6	Evaluation of conformity .....	18
6.1	General.....	18
6.2	Type testing.....	19
6.3	Factory production control (FPC) .....	25
7	Designation.....	29

<b>8</b>	<b>Marking, labelling and packaging</b> .....	<b>29</b>
<b>8.1</b>	<b>General</b> .....	<b>29</b>
<b>8.2</b>	<b>Additional marking</b> .....	<b>29</b>
<b>8.3</b>	<b>Dezincification resistant copper zinc alloys</b> .....	<b>30</b>
<b>Annex A (normative) Maximum operating temperatures and corresponding maximum operating pressures</b> .....		<b>31</b>
<b>Annex B (normative) Minimum nominal wall thicknesses of copper tube with R220, R250 and R290 temper conforming to EN 1057 suitable for jointing by press fittings</b> .....		<b>32</b>
<b>Bibliography</b> .....		<b>34</b>

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## European foreword

This document (EN 1254-7:2021) 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 part of the standard (EN 1254-7) 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”:

- *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.

## Introduction

Products complying with this document may be used several fluids including for 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.

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## 1 Scope

This document specifies product characteristics, assessment methods, compliance criteria of test results and a designation system for press fittings including their elastomeric seals, for connecting with metallic tubes. The fitting ends have a nominal diameter from 6 mm to 108 mm. The press fittings are designed for a service lifetime up to fifty years.

This document is applicable to press fittings for joining one or more of the following tubes:

- copper tubes to EN 1057; and
- stainless steel tubes to EN 10312;

with wall thicknesses and tempers as specified by the manufacturer.

The fittings are used up to the operating temperatures and maximum operating pressures as indicated in Annex A.

Press fittings are used with tubes with wall thicknesses greater than or equal to the wall thickness given in Annex B, to ensure that tubes can withstand the radial pressing forces involved.

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 copper tubes may combine press ends with fitting ends defined in the other parts of EN 1254.

Press fittings for use with metallic tubes may also have flanged end connections according to EN 1092-3.

Press fittings for use with metallic tubes 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 or 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.



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

EN 1254-4:2021, *Copper and copper alloys — Plumbing fittings — Part 4: Threaded fittings*

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

EN 1775:2007, *Gas supply — Gas pipework for buildings — Maximum operating pressure less than or equal to 5 bar - Functional recommendations*

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

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 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)*

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*