

Contents

Page

<i>European foreword</i>	4
1 Scope	5
2 Normative references	6
3 Terms and definitions	6
4 Technical requirements	10
4.1 General	10
4.1.1 Diameter range	10
4.1.2 Surface condition and repairs	10
4.1.3 Types of joints and interconnection	11
4.1.4 Materials in contact with water intended for human consumption	11
4.2 Dimensional requirements	12
4.2.1 Minimum wall thickness of ductile iron couplings and flange adaptors	12
4.2.2 Minimum wall thickness of steel couplings and flange adaptors	12
4.2.3 Joint gap and depth of engagement	13
4.2.4 Angular deflection	14
4.3 Material characteristics	14
4.3.1 Ductile iron	14
4.3.2 Mild steel for couplings and flange adaptors (DN600 to DN800 only)	14
4.3.3 Fastener for couplings and flange adaptors	15
4.4 Coatings	15
4.5 Product information	15
4.5.1 Marking requirements	15
4.5.2 Additional information	16
4.6 Water tightness	16
4.6.1 Couplings and flange adaptors	16
4.6.2 Joints	16
5 Performance requirements for joints	16
5.1 General	16
5.2 Pressure rating	17
5.3 Water tightness of flexible joints	17
5.3.1 General – performance tests principles	17
5.3.2 Test conditions	17
5.4 Restrained flexible joints	18
5.5 Long term hydrostatic strength test	21
5.5.1 PE pipes	21
5.5.2 Pull out test at 25 °C for PE restrained joints	21
5.5.3 PVC pipes	22
5.6 Flanged joints	22
6 Test methods	22
6.1 Tensile testing	22

6.1.1	Samples	22
6.1.2	Preparation of test bar	23
6.1.3	Apparatus and test method	23
6.1.4	Test results	23
6.2	Brinell hardness.....	24
6.3	Routine water tightness test	24
6.3.1	General.....	24
6.3.2	Air test	24
6.3.3	Hydrostatic pressure test.....	24
7	Performance tests	24
7.1	Positive internal pressure joint water tightness	24
7.1.1	Coupling	24
7.1.2	Flange adaptor	25
7.2	Negative internal pressure joint.....	26
7.3	Dynamic internal pressure joint water tightness.....	26
7.4	Long term hydrostatic strength test for joints for PE pipes.....	27
7.4.1	Test piece.....	27
7.4.2	Test procedure.....	27
7.5	Pull out test at 25 °C for restrained joints for PE pipes	27
7.5.1	Test assembly	27
7.5.2	Apparatus	27
7.5.3	Test procedure	27
7.6	Long term hydrostatic strength test for joints of fittings for PVC pipe.....	28
7.6.1	Test piece.....	28
7.6.2	Test procedure	28
Annex A (informative) Outside diameters of existing pipes.....		29
Annex B (informative) Quality assurance.....		32
B.1	General.....	32
B.2	Performance test	32
B.3	Manufacturing process.....	33
Bibliography		34