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**Plastics piping systems for hot and cold  
water installations — Crosslinked  
polyethylene (PE-X) —**

**Part 2:  
Pipes**

*Systèmes de canalisations en plastique pour les installations d'eau  
chaude et froide — Polyéthylène réticulé (PE-X) —*

*Partie 2: Tubes*



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## Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15875-2 was prepared by the European Committee for Standardization (CEN) in collaboration with 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).

Throughout the text of this document, read “...this European Standard...” to mean “...this International Standard...”.

ISO 15875 consists of the following parts, under the general title *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X)*:

- *Part 1: General*
- *Part 2: Pipes*
- *Part 3: Fittings*
- *Part 5: Fitness for purpose of the system*
- *Part 7: Guidance for the assessment of conformity* [Technical Specification]

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## Foreword

This document (EN ISO 15875-2:2003) has been prepared by Technical Committee CEN/TC 155 "Plastics piping systems and ducting systems", the secretariat of which is held by NEN, in collaboration with Technical Committee ISO/TC 138 "Plastics pipes, fittings and valves for the transport of fluids".

NOTE This draft was submitted for CEN enquiry as prEN 12318-2:1996.

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 June 2004, and conflicting national standards shall be withdrawn at the latest by December 2005.

This standard is part of a System Standard for plastics piping systems of a particular material for a specified application. There are a number of such System Standards.

System Standards are based on the results of the work undertaken in ISO/TC 138 "Plastics pipes, fittings and valves for the transport of fluids", which is a Technical Committee of the International Organization for Standardization (ISO).

They are supported by separate standards on test methods to which references are made throughout the System Standard.

The System Standards are consistent with general standards on functional requirements and recommended practices for installation.

EN ISO 15875 consists of the following Parts <sup>1)</sup>, under the general title *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X)*

- Part 1: General
- Part 2: Pipes (the present standard)
- Part 3: Fittings
- Part 5: Fitness for purpose of the system
- Part 7: Guidance for the assessment of conformity (CEN ISO/TS 15875-7).

This Part of EN ISO 15875 includes the following:

- Annex A (informative): Derivation of  $S_{calc,max}$
- Bibliography

At the date of publication of this standard, System Standards for piping systems of other plastics materials used for the same application are the following:

EN ISO 15874:2003, *Plastics piping systems for hot and cold water installations — Polypropylene (PP)* (ISO 15875:2003)

EN ISO 15876:2003, *Plastics piping systems for hot and cold water installations — Polybutylene (PB)* (ISO 15876:2003)

EN ISO 15877:2003, *Plastics piping systems for hot and cold water installations — Chlorinated poly(vinyl chloride) (PVC-C)* (ISO 15877:2003)

For pipes and fittings which have conformed to the relevant national standard before 1<sup>st</sup> November 2003, as shown by the manufacturer or by a certification body, the national standard may continue to apply until 30th November 2005.

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1) This System Standard does not incorporate a Part 4 *Ancillary equipment* or a Part 6 *Guidance for installation*. For ancillary equipment separate standards can apply. Guidance on installation of plastics piping systems made from different materials, intended to be used for hot and cold water installations, is given by ENV 12108:2001 <sup>[1]</sup>.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and the United Kingdom.

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## Introduction

The System Standard, of which this is Part 2, specifies the requirements for a piping system when made from crosslinked polyethylene (PE-X). The piping system is intended to be used for hot and cold water installations.

In respect of potential adverse effects on the quality of water intended for human consumption, caused by the product covered by this standard:

- This standard provides no information as to whether the product may be used without restriction in any of the Member States of the EU or EFTA;
- It should be noted that, while awaiting the adoption of verifiable European criteria, existing national regulations concerning the use and/or the characteristics of this product remain in force.

Requirements and test methods for material and components, other than pipes are specified in Part 1 and Part 3 of EN ISO 15875:2003. Characteristics for fitness for purpose (mainly for joints) are covered in Part 5. Part 7 (CEN ISO/TS 15875-7) gives guidance for the assessment of conformity.

This Part of EN ISO 15875 specifies the characteristics of pipes.





## 1 Scope

This Part of EN ISO 15875 specifies the characteristics of pipes made from crosslinked polyethylene (PE-X) for piping systems intended to be used for hot and cold water installations within buildings for the conveyance of water, whether or not intended for human consumption (domestic systems), and for heating systems, under design pressures and temperatures appropriate to the class of application (see Table 1 of EN ISO 15875-1:2003).

This standard covers a range of service conditions, (application classes), design pressures and pipe dimension classes. For values of  $T_D$ ,  $T_{max}$  and  $T_{mal}$  in excess of those in Table 1 of Part 1, this standard does not apply.

NOTE 1 It is the responsibility of the purchaser or specifier to make the appropriate selections from these aspects, taking into account their particular requirements and any relevant national regulations and installation practices or codes.

It also specifies the test parameters for the test methods referred to in this standard.

In conjunction with the other Parts of EN ISO 15875 (see Foreword) it is applicable to PE-X pipes, their joints and to joints with components of PE-X, other plastics and non-plastics materials intended to be used for hot and cold water installations.

It is applicable to pipes with or without (a) barrier layer(s).

NOTE 2 In the case of plastics pipes provided with a thin barrier layer, e.g. to prevent or greatly diminish the diffusion of gases and the transmission of light into or through the pipe wall, the design stress requirements are totally met by the base polymer (PE-X).

## 2 Normative references

This Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 578, *Plastics piping systems — Plastics pipes and fittings — Determination of the opacity*

EN 579, *Plastics piping systems — Crosslinked polyethylene (PE-X) pipes — Determination of degree of crosslinking by solvent extraction*

EN 743:1994, *Plastics piping and ducting systems — Thermoplastics pipes — Determination of the longitudinal reversion*

EN 921:1994, *Plastics piping systems — Thermoplastics pipes — Determination of resistance to internal pressure at constant temperature*

EN ISO 15875-1:2003, *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X) — Part 1: General (ISO 15875-1:2003)*

EN ISO 15875-5, *Plastics piping systems for hot and cold water installations — Crosslinked polyethylene (PE-X) — Part 5: Fitness for purpose of the system (ISO 15875-5:2003)*

EN ISO 3126, *Plastics piping systems - Plastics piping components - Determination of dimensions (ISO 3126:2003)*

EN ISO 9080, *Plastics piping and ducting systems — Determination of the long-term hydrostatic strength of thermoplastics materials in pipe form by extrapolation (ISO 9080:2003)*

## 3 Terms and definitions, symbols and abbreviated terms

For the purposes of this standard the terms and definitions, symbols and abbreviated terms given in EN ISO 15875-1:2003 apply.

## 4 Material

### 4.1 Pipe material

The material from which the pipes are made shall be polyethylene (PE) which is crosslinked during or after the manufacturing of the pipe.

The material may be crosslinked by any process (peroxide, silane, electron beam and azo), which change the chemical structure in such a way that the polymer chains are connected with each other to a three-dimensional net by chemical bonds.

NOTE The new structure makes it no longer possible to melt or dissolve the polymer unless first destroying its structure. It is therefore possible to assess the level of crosslinking by measurement of the degree of gelation.

### 4.2 Evaluation of $\sigma_{LCL}$ -values

The pipe material shall be evaluated in accordance with EN ISO 9080 or equivalent where internal pressure tests are made in accordance with EN 921:1994 to find the  $\sigma_{LCL}$ -values. The  $\sigma_{LCL}$ -value thus determined shall at least be as high as the corresponding values of the reference curves given in Figure 1 over the complete range of times.

NOTE 1 One equivalent way of evaluation is to calculate the  $\sigma_{LCL}$ -value for each temperature (for example 20 °C, 60 °C and 95 °C) individually.

NOTE 2 The reference curves in figure 1 in the temperature range of 10 °C to 95 °C are derived from the following equation:

$$\log t = -105,8618 - \frac{18506,15 \log \sigma}{T} + \frac{57895,49}{T} - 24,7997 \log \sigma$$

To demonstrate conformance to the reference lines pipe samples should be tested at following temperatures and at various hoop stresses such that, at each of the temperatures given, at least three failure times fall in each of the following time intervals:

Temperatures 20; 60-70; 95; °C

Time intervals 10-100 h, 100-1000 h, 1000-8760 h and above 8760 h

In tests lasting more than 8760 h, once failure is reached at a stress and time at least on or above the reference line, any time after that can be considered as the failure time. Testing should be carried out in accordance with EN 921:1994.

Conformance to the reference lines should be demonstrated by plotting the individual experimental results on the graph. At least 97.5% of them should lie on or above the reference line.

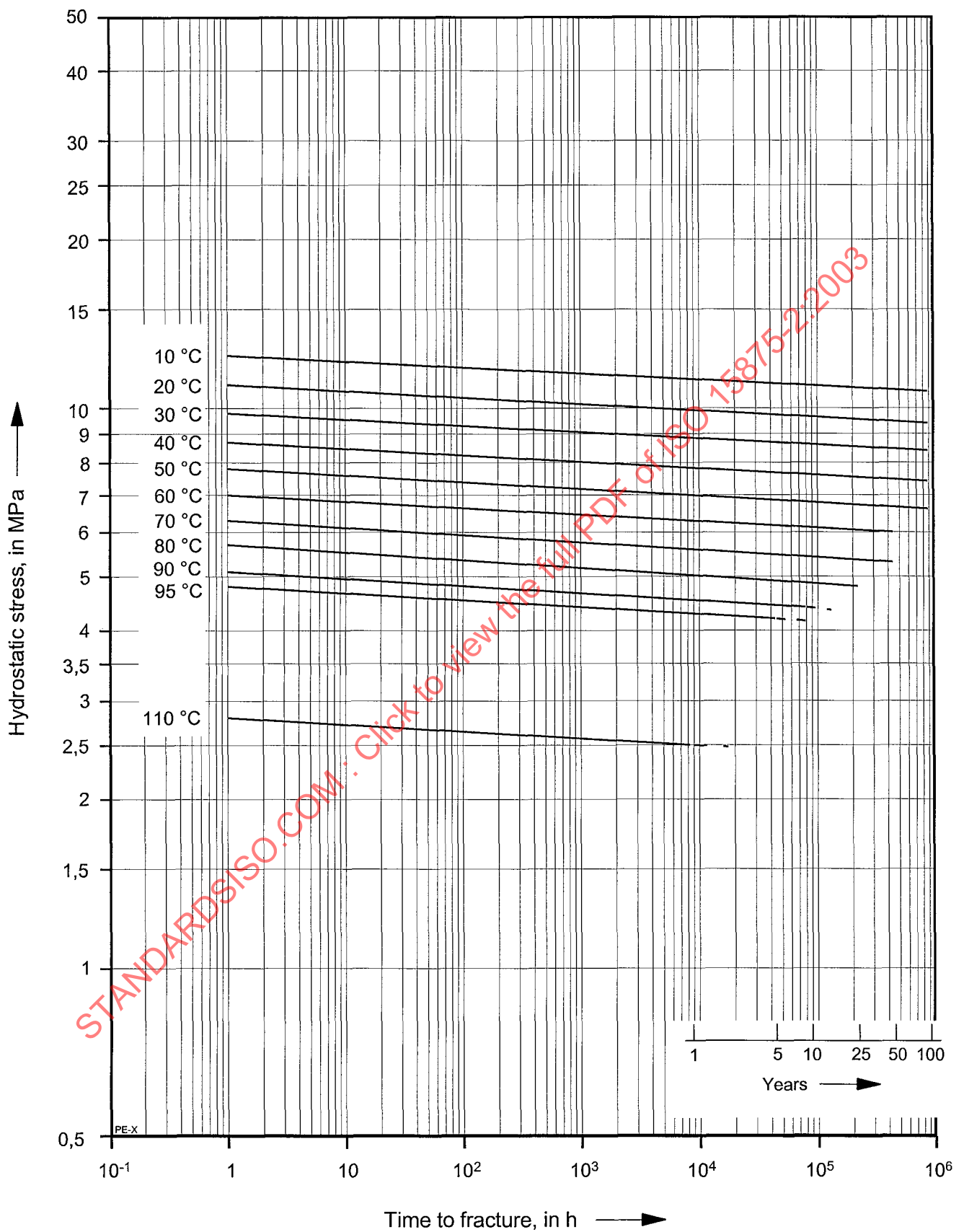


Figure 1 — Reference curves for expected strength of crosslinked polyethylene

### 4.3 Influence on water intended for human consumption

The material shall conform to EN ISO 15875-1:2003.

## 5 General characteristics

### 5.1 Appearance

When viewed without magnification the internal and external surfaces of pipes 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. The ends of the pipe shall be cut cleanly and square to the axis of the pipe.

### 5.2 Opacity

Crosslinked polyethylene pipes that are declared to be opaque shall not transmit more than 0,2 % of visible light, when tested in accordance with EN 578.

## 6 Geometrical characteristics

### 6.1 General

6.1.1 Dimensions shall be measured in accordance with EN ISO 3126.

6.1.2 The maximum calculated pipe value,  $S_{\text{calc,max}}$ , for the applicable class of service conditions and design pressure,  $p_D$ , shall conform to Table 1.

Table 1 —  $S_{\text{calc,max}}$ -values

$p_D$ bar	Application class			
	Class 1	Class 2	Class 4	Class 5
	$S_{\text{calc,max}}$ -values <sup>a</sup>			
4	7,6 <sup>b</sup>	7,6 <sup>b</sup>	7,6 <sup>b</sup>	7,6 <sup>b</sup>
6	6,4	5,9	6,6	5,4
8	4,8	4,4	5,0	4,0
10	3,8	3,5	4,0	3,2
<sup>a</sup> The values are rounded to the first place of decimals. <sup>b</sup> The 20 °C, 10 bar, 50 years, cold water requirement, being higher, determines this value (see clause 4 of EN ISO 15875-1:2003).				

NOTE The derivation of  $S_{\text{calc,max}}$  is provided in annex A. The method described takes account of the properties of PE-X under service conditions for the classes given in Table 1 of EN ISO 15875-1:2003.

6.1.3 The values of outside diameter and/or wall thickness apply to the crosslinked polyethylene pipe and are exclusive of any barrier layer thickness.

### 6.2 Dimensions of pipes

#### 6.2.1 Outside diameters

For the applicable pipe dimension class, the mean outside diameter,  $d_{\text{em}}$ , of a pipe shall conform to Table 2, 3, 4 or 5, as applicable.

### 6.2.2 Wall thicknesses and their tolerances

For any particular class of service conditions, design pressure and nominal size, the minimum wall thickness,  $e_{\min}$ , shall be chosen in such a way that the corresponding S series or  $S_{\text{calc}}$ -value is equal to or less than the values of  $S_{\text{calc,max}}$  given in Table 1.

For the applicable pipe dimension class, the wall thicknesses,  $e_{\min}$  and  $e_n$  respectively, shall conform to Table 2, 3, 4 or 5, as applicable, in relation to the pipe series S and  $S_{\text{calc}}$ -values, respectively. However, pipes intended to be joined together by fusion shall have a minimum wall thickness of 1,9 mm.

The tolerance on the wall thickness,  $e$ , shall conform to Table 6.

**Table 2 — Pipe dimensions for dimension class A**  
(sizes conform to ISO 4065:1996 [2] and are applicable for all classes of service conditions)

Dimensions in millimetres							
Nominal size DN/OD	Nominal outside diameter $d_n$	Mean outside diameter		Pipe series			
				S 6,3	S 5	S 4	S 3,2
		$d_{\text{em,min}}$	$d_{\text{em,max}}$	Wall thicknesses $e_{\min}$ and $e_n$			
12	12	12,0	12,3	—	1,3 <sup>a</sup>	1,4	1,7
16	16	16,0	16,3	1,3	1,5	1,8	2,2
20	20	20,0	20,3	1,5	1,9	2,3	2,8
25	25	25,0	25,3	1,9	2,3	2,8	3,5
32	32	32,0	32,3	2,4	2,9	3,6	4,4
40	40	40,0	40,4	3,0	3,7	4,5	5,5
50	50	50,0	50,5	3,7	4,6	5,6	6,9
63	63	63,0	63,6	4,7	5,8	7,1	8,6
75	75	75,0	75,7	5,6	6,8	8,4	10,3
90	90	90,0	90,9	6,7	8,2	10,1	12,3
110	110	110,0	111,0	8,1	10,0	12,3	15,1
125	125	125,0	126,2	9,2	11,4	14,0	17,1
140	140	140,0	141,3	10,3	12,7	15,7	19,2
160	160	160,0	161,5	11,8	14,6	17,9	21,9

<sup>a</sup> A non-preferred wall thickness of 1,1 mm is permitted for  $d_n = 12$ .

**Table 3 — Pipe dimensions for dimension class B1**  
(sizes based on copper pipe sizes and applicable for all classes of service conditions)

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter $d_n$	Mean outside diameter		Wall thickness		$S_{calc}$
		$d_{em,min}$	$d_{em,max}$	$e_n$	$e_{min}$	
10	10	9,9	10,2	1,5	1,5	2,8
				1,8	1,7	2,4
12	12	11,9	12,2	1,5	1,5	3,4
				2,0	1,9	2,6
15	15	14,9	15,2	1,5	1,5	4,4
				2,5	2,4	2,6
18	18	17,9	18,2	1,7	1,7	4,8
				2,5	2,4	3,2
22	22	21,9	22,2	2,0	2,0	5,0
				3,0	2,9	3,3
28	28	27,9	28,2	2,6	2,6	4,9
				4,0	3,9	3,1

**Table 4 — Pipe dimensions for dimension class B2**  
(sizes based on copper pipe sizes and applicable for all classes of service conditions)

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter $d_n$	Mean outside diameter		Wall thicknesses	$S_{calc}$
		$d_{em,min}$	$d_{em,max}$	$e_{min}$ and $e_n$	
14,7	14,7	14,63	14,74	1,6	4,1
21	21	20,98	21,09	2,05	4,6
27,4	27,4	27,33	27,44	2,6	4,8
34	34	34,08	34,19	3,15	4,9

**Table 5 — Pipe dimensions for dimension class C**  
(non-preferred pipe sizes used for example for heating systems)

Dimensions in millimetres

Nominal size DN/OD	Nominal outside diameter $d_n$	Mean outside diameter		Wall thicknesses $e_{\min}$ and $e_n$	$S_{\text{calc}}$
		$d_{\text{em,min}}$	$d_{\text{em,max}}$		
12	12	12,0	12,3	2,0	2,5
14	14	14,0	14,3	2,0	3,0
15	15	15,0	15,3	2,0	3,2
16	16	16,0	16,3	2,0	3,5
17	17	17,0	17,3	2,0	3,8
18	18	18,0	18,3	2,0	4,0
20	20	20,0	20,3	2,0	4,5

**Table 6 — Tolerance on wall thicknesses**

Dimensions in millimetres

Minimum wall thickness $e_{\min}$		Tolerance <sup>a</sup> $\times$	Minimum wall thickness $e_{\min}$		Tolerance <sup>a</sup> $\times$
>	≤		>	≤	
1,0	2,0	0,3	11,0	12,0	1,3
2,0	3,0	0,4	12,0	13,0	1,4
3,0	4,0	0,5	13,0	14,0	1,5
4,0	5,0	0,6	14,0	15,0	1,6
5,0	6,0	0,7	15,0	16,0	1,7
6,0	7,0	0,8	16,0	17,0	1,8
7,0	8,0	0,9	17,0	18,0	1,9
8,0	9,0	1,0	18,0	19,0	2,0
9,0	10,0	1,1	19,0	20,0	2,1
10,0	11,0	1,2	20,0	21,0	2,2
			21,0	22,0	2,3

<sup>a</sup> The tolerance is expressed in the form  $\pm \frac{x}{100}$  mm, where "x" is the value of the tolerance given. The level of the tolerances conforms to Grade V in ISO 11922-1:1997 [3].

## 7 Mechanical characteristics

When tested in accordance with the test method as specified in Table 7 using the indicated parameters, the pipe shall withstand the hydrostatic (hoop) stress without bursting. In the case of pipes with (a) barrier layer(s) the test shall be carried out on test pieces without the barrier layer(s).

Table 7 — Mechanical characteristics of pipes

Characteristic	Requirement	Test parameters for the individual tests				Test method
Resistance to internal pressure	No failure during the test period	<b>Hydrostatic (hoop) stress</b> MPa	<b>Test temp.</b> °C	<b>Test period</b> h	<b>Number of test pieces</b>	EN 921 of 1994
		12,0 <sup>a</sup>	20	1	3	
		4,8	95	1	3	
		4,7	95	22	3	
		4,6	95	165	3	
		4,4	95	1000	3	
		<b>Test parameters for all tests</b>				
		Sampling procedure Type of end cap Orientation of test piece Type of test		<sup>b</sup> Type a) Not specified Water-in -water		
<sup>a</sup> The test stress is above the minimum expected strength curve as the real short term stress at 20 °C is higher than the strength curve.						
<sup>b</sup> The sampling procedure is not specified. For guidance see CEN ISO/TS 15875-7 [4].						

## 8 Physical and chemical characteristics

When tested in accordance with the test methods as specified in Table 8 using the indicated parameters, the pipe shall conform to the requirements given in this table.



Table 8 — Physical and chemical characteristics of pipes

Characteristic	Requirement	Test parameters		Test method
		Parameter	Value	
Longitudinal reversion	≤ 3 %	Temperature Duration of exposure for: $e_n \leq 8 \text{ mm}$ $8 \text{ mm} < e_n \leq 16 \text{ mm}$ $e_n > 16 \text{ mm}$ Number of test pieces	120 °C  1 h 2 h 4 h 3	Method B of EN 743:1994 (oven test)
Thermal stability by hydrostatic pressure testing	No bursting during the test period	Sampling procedure End cap Orientation Type of test Hydrostatic (hoop) stress Test temperature Test period Number of test pieces	a Type a) Not specified Water-in-air 2,5 MPa 110 °C 8760 h 1	EN 921:1994
Crosslinking - peroxide - silan - electron beam - azo	≥ 70 % ≥ 65 % ≥ 60 % ≥ 60 %	Shall conform to EN 579		EN 579

<sup>a</sup> The sampling procedure is not specified. For guidance see CEN ISO/TS 15875-7 <sup>[4]</sup>.

## 9 Performance requirements

When pipes conforming to this standard are jointed to each other or components conforming to EN ISO 15875-3 <sup>[5]</sup>, the pipes and the joints shall conform to EN ISO 15875-5.

## 10 Marking

### 10.1 General requirements

**10.1.1** Marking details shall be printed or formed directly on the pipe not less than once per meter in such a way that after storage, handling, and installation (e.g. in accordance with ENV 12108 <sup>[1]</sup>) legibility is maintained.

NOTE The manufacturer is not responsible for marking being illegible, due to actions such as painting, scratching, covering of the components or by use of detergent etc. on the components unless agreed or specified by the manufacturer.

**10.1.2** Marking shall not initiate cracks or other types of defects which adversely influence the performance of the pipe.

**10.1.3** If printing is used, the colouring of the printed information shall differ from the basic colouring of the pipe.

**10.1.4** The size of the marking shall be such that the marking is legible without magnification.

### 10.2 Minimum required marking

The minimum required marking of the pipe is specified in Table 9.