

STN	Rúry, tvarovky a príslušenstvo z tvárnej liatiny Požiadavky a skúšobné metódy Časť 1: Polyetylénové (PE) povlaky	STN EN 14628-1 13 8132
------------	---	--

Ductile iron pipes, fittings and accessories - Requirements and test methods - Part 1: PE coatings

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 12/20

Obsahuje: EN 14628-1:2020

Oznámením tejto normy sa ruší
STN EN 14628 (13 8132) z mája 2006

131890

EUROPEAN STANDARD

EN 14628-1

NORME EUROPÉENNE

EUROPÄISCHE NORM

July 2020

ICS 23.040.10; 23.040.40

Supersedes EN 14628:2005

English Version

Ductile iron pipes, fittings and accessories - Requirements and test methods - Part 1: PE coatings

Tuyaux, raccords et accessoires en fonte ductile -
Prescriptions et méthodes d'essai - Partie 1 :
Revêtements en PE

Rohre, Formstücke und Zubehörteile aus duktilem
Gusseisen - Anforderungen und Prüfverfahren - Teil 1:
Polyethylenumhüllung von Rohren

This European Standard was approved by CEN on 9 April 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.

CEN members are the national standards bodies of 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 United Kingdom.



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

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

EN 14628-1:2020 (E)

Contents	Page
European foreword	4
Introduction	5
1 Scope	6
2 Normative references	6
3 Terms and definitions	6
4 Ordering information	8
4.1 General	8
4.2 Mandatory	8
4.3 Options to be indicated by the purchaser	8
5 Technical requirements	9
5.1 Surface condition	9
5.2 Material properties	9
5.3 Finished polyethylene coating	9
5.4 Repairs	11
5.5 Marking	11
5.6 Peeling strength	11
5.7 Non-porosity	11
6 Performance requirements	11
6.1 Impact strength	11
6.2 Indentation resistance	12
6.3 Elongation at break	12
6.4 Specific coating resistance	13
6.5 Heat ageing	13
6.6 Light ageing	13
7 Test methods	13
7.1 Peel resistance of the adhesive	13
7.2 Coating thickness	15
7.3 Non-porosity	15
7.4 Impact strength	15
7.5 Indentation resistance	16
7.6 Elongation at break	16
7.7 Specific coating resistance	16
7.8 Heat ageing	17
7.9 Light ageing	17
Annex A (informative) Quality assurance	18
A.1 General	18
A.2 Performance test	20
A.3 Quality assessment system	20
Annex B (informative) Application process	21
B.1 General	21
B.2 Tubular extrusion method	21

B.3	Flat die wrapping extrusion method	22
	Annex C (informative) Coating material.....	23
C.1	General	23
C.2	Polyethylene.....	23
C.3	Adhesive.....	23
	Bibliography	24

EN 14628-1:2020 (E)**European foreword**

This document (EN 14628-1:2020) has been prepared by Technical Committee CEN/TC 203 “Cast iron pipes, fittings and their joints”, the secretariat of which is held by AFNOR.

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 January 2021, and conflicting national standards shall be withdrawn at the latest by January 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 document supersedes EN 14628:2005.

In comparison with the previous edition, the following technical modifications have been made:

- a) EN 14628 has been split into two parts. This part covers factory applied extruded polyethylene coatings for the external corrosion protection of ductile iron pipes.

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

This document is in conformity with the general requirements already established by CEN/TC 164 in the field of water supply (e.g. potable water) and CEN/TC 165 in the field of waste water.

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

- a) this document provides no information as to whether the product can be used without restriction in any of the member states of the EU or EFTA;
- b) it is also 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.

EN 14628-1:2020 (E)**1 Scope**

This document specifies the requirements and test methods applicable to factory applied extruded polyethylene coatings for the external corrosion protection of ductile iron pipes according to EN 545, EN 598 and EN 969 for use at operating temperatures up to 50 °C.

This document is not applicable to ductile iron pipes protected with thin PE sleeve. Special works at site like drilling, tapping, etc. can influence the corrosion protection properties. Those job steps are intended to be included in the instructions of pipe saddle and accessory manufacturers and all other essential installation instructions. These instructions are not part of this document.

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 545, *Ductile iron pipes, fittings, accessories and their joints for water pipelines - Requirements and test methods*

EN 598, *Ductile iron pipes, fittings, accessories and their joints for sewerage application - Requirements and test methods*

EN 969, *Ductile iron pipes, fittings, accessories and their joints for gas pipelines - Requirements and test methods*

EN 1238, *Adhesives - Determination of the softening point of thermoplastic adhesives (ring and ball)*

EN ISO 527-1, *Plastics - Determination of tensile properties - Part 1: General principles (ISO 527-1)*

EN ISO 527-2, *Plastics - Determination of tensile properties - Part 2: Test conditions for moulding and extrusion plastics (ISO 527-2)*

EN ISO 1133-1, *Plastics - Determination of the melt mass-flow rate (MFR) and melt volume-flow rate (MVR) of thermoplastics - Part 1: Standard method (ISO 1133-1)*

EN ISO 3681, *Binders for paints and varnishes - Determination of saponification value - Titrimetric method (ISO 3681)*

EN ISO 4892-2, *Plastics - Methods of exposure to laboratory light sources - Part 2: Xenon-arc lamps (ISO 4892-2)*

koniec náhľadu – text ďalej pokračuje v platenej verzii STN