

<b>STN P</b>	<b>Potrúbné systémy z plastov na tlakové a beztlakové kanalizačné potrubia a stoky a na zásobovanie vodou Sklenené lamináty (GRP) na báze nenasýtenej polyesterovej živice (UP) Odporúčania na posudzovanie zhody</b>	<b>STN P CEN/TS 14632</b>  64 3160
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Plastics piping systems for drainage, sewerage and water supply, pressure and non-pressure - Glass-reinforced thermosetting plastics (GRP) based on unsaturated polyester resin (UP) - Guidance for the assessment of conformity

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. 09/23

Táto predbežná slovenská technická norma je určená na overenie. Prípadné pripomienky pošlite do júna 2025 Úradu pre normalizáciu, metrológiu a skúšobníctvo SR.

Obsahuje: CEN/TS 14632:2023

Oznámením tejto normy sa ruší  
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TECHNICAL SPECIFICATION  
SPÉCIFICATION TECHNIQUE  
TECHNISCHE SPEZIFIKATION

# CEN/TS 14632

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Supersedes CEN/TS 14632:2012

English Version

## Plastics piping systems for drainage, sewerage and water supply, pressure and non-pressure - Glass-reinforced thermosetting plastics (GRP) based on unsaturated polyester resin (UP) - Guidance for the assessment of conformity

Kunststoff-Rohrleitungssysteme für die Entwässerung und Wasserversorgung mit und ohne Druck - Glasfaserverstärkte duroplastische Kunststoffe (GFK) auf der Basis von Polyesterharz (UP) - Empfehlungen für die Beurteilung der Konformität

This Technical Specification (CEN/TS) was approved by CEN on 7 May 2023 for provisional application.

The period of validity of this CEN/TS is limited initially to three years. After two years the members of CEN will be requested to submit their comments, particularly on the question whether the CEN/TS can be converted into a European Standard.

CEN members are required to announce the existence of this CEN/TS in the same way as for an EN and to make the CEN/TS available promptly at national level in an appropriate form. It is permissible to keep conflicting national standards in force (in parallel to the CEN/TS) until the final decision about the possible conversion of the CEN/TS into an EN is reached.

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**CEN/TS 14632:2023 (E)**

<b>Contents</b>	<b>Page</b>
<b>European foreword</b> .....	<b>4</b>
<b>Introduction</b> .....	<b>6</b>
<b>1 Scope</b> .....	<b>8</b>
<b>2 Normative references</b> .....	<b>8</b>
<b>3 Terms and definitions</b> .....	<b>10</b>
<b>4 Abbreviated terms</b> .....	<b>12</b>
<b>5 General</b> .....	<b>12</b>
<b>6 Testing and inspection</b> .....	<b>13</b>
<b>6.1 General</b> .....	<b>13</b>
<b>6.2 Type testing</b> .....	<b>13</b>
<b>6.3 Audit tests (AT)</b> .....	<b>16</b>
<b>6.4 Quality control tests</b> .....	<b>18</b>
<b>Annex A (normative) Procedures for dealing with test data provided by the manufacturer and for witnessed tests in a manufacturer's laboratory</b> .....	<b>20</b>
<b>A.1 General</b> .....	<b>20</b>
<b>A.2 Test data provided by the manufacturer</b> .....	<b>20</b>
<b>A.3 Witnessed tests in a manufacturer's laboratory</b> .....	<b>20</b>
<b>A.3.1 General</b> .....	<b>20</b>
<b>A.3.2 Control of witnessed tests</b> .....	<b>20</b>
<b>Annex B (normative) Definitions of changes in material, design and process</b> .....	<b>21</b>
<b>B.1 General</b> .....	<b>21</b>
<b>B.2 Change in materials — Reinforcements</b> .....	<b>21</b>
<b>B.3 Resins</b> .....	<b>21</b>
<b>B.3.1 General</b> .....	<b>21</b>
<b>B.3.2 Curing agents or systems</b> .....	<b>22</b>
<b>B.3.3 Fillers and/or aggregates</b> .....	<b>22</b>
<b>B.3.4 Joint materials</b> .....	<b>22</b>
<b>B.3.4.1 Gasket sealed joints</b> .....	<b>22</b>
<b>B.3.4.2 Bonded joints</b> .....	<b>22</b>
<b>B.4 Change in design</b> .....	<b>23</b>
<b>B.5 Change in process</b> .....	<b>23</b>
<b>Annex C (normative) Tests to assess the effects of changes</b> .....	<b>24</b>
<b>C.1 Tests</b> .....	<b>24</b>
<b>C.2 Evaluation of test results</b> .....	<b>24</b>

<b>C.2.1</b>	<b>Initial properties</b> .....	<b>24</b>
<b>C.2.2</b>	<b>Reduced long-term tests</b> .....	<b>24</b>
<b>Annex D</b>	<b>(normative) Parameters and criteria for reduced long-term tests (RLTT)</b> .....	<b>26</b>
<b>D.1</b>	<b>General</b> .....	<b>26</b>
<b>D.2</b>	<b>Reduced long-term test parameters</b> .....	<b>26</b>
<b>D.2.1</b>	<b>Reduced parameters for long-term failure pressure</b> .....	<b>26</b>
<b>D.2.2</b>	<b>Reduced parameters for the resistance to strain corrosion</b> .....	<b>26</b>
<b>D.2.2.1</b>	<b>General</b> .....	<b>26</b>
<b>D.2.2.2</b>	<b>Procedure using failure points</b> .....	<b>26</b>
<b>D.2.2.3</b>	<b>Procedure using specified levels</b> .....	<b>27</b>
<b>D.2.2.3.1</b>	..... <b>General</b>	<b>27</b>
<b>D.2.2.3.2</b>	..... <b>Using deflection</b>	<b>27</b>
<b>D.2.2.3.3</b>	..... <b>Using strain</b>	<b>27</b>
<b>D.2.3</b>	<b>Reduced parameters for ultimate long-term resistance to failure in a deflected condition</b>	<b>27</b>
<b>D.3</b>	<b>Evaluation of results of destructive RLTTs (see D.2.1, D.2.2 and D.2.3)</b> .....	<b>28</b>
<b>D.3.1</b>	<b>General</b> .....	<b>28</b>
<b>D.3.2</b>	<b>Example</b> .....	<b>29</b>
<b>Annex E</b>	<b>(normative) Reduced long-term testing (RLTT) of the determination of wet creep factor</b>	<b>32</b>
<b>E.1</b>	<b>General</b> .....	<b>32</b>
<b>E.2</b>	<b>Evaluation of results and criteria</b> .....	<b>32</b>
<b>E.2.1</b>	<b>General</b> .....	<b>32</b>
<b>E.2.2</b>	<b>Example</b> .....	<b>33</b>
<b>Annex F</b>	<b>(normative) Additional statements for manholes and inspection chambers</b> .....	<b>36</b>
<b>F.1</b>	<b>General</b> .....	<b>36</b>
<b>F.2</b>	<b>Tests specific to manholes and chambers</b> .....	<b>36</b>
<b>F.2.1</b>	<b>Longitudinal compressive strength</b> .....	<b>36</b>
<b>F.2.2</b>	<b>Determination of the resistance of installed steps to vertical and horizontal loading</b> .....	<b>36</b>
<b>F.3</b>	<b>Type tests</b> .....	<b>36</b>
<b>F.4</b>	<b>Audit tests</b> .....	<b>36</b>
<b>F.5</b>	<b>Batch release tests</b> .....	<b>36</b>
<b>Annex G</b>	<b>(informative) Consequence Classes and Quality Levels</b> .....	<b>37</b>
<b>G.1</b>	<b>General</b> .....	<b>37</b>
<b>Bibliography</b>	.....	<b>39</b>

**CEN/TS 14632:2023 (E)****European foreword**

This document (CEN/TS 14632:2023) has been prepared by Technical Committee CEN/TC 155 “Plastics piping systems and ducting systems”, the secretariat of which is held by NEN.

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 CEN/TS 14632:2012.

Compared with CEN/TS 14362:2012, the following changes have been made:

- In the scope references to ISO 25780 and ISO 16611 have been added and reference to EN ISO 23856 replaces reference to the previous product standards. References to appropriate accreditation standards have also been corrected. This also applies in other parts of the document;
- In Clause 2 references to several standards have been added and updated;
- In Clause 3.6 on type testing the note has been removed;
- In Table 3, 4 and 5, the term “Long-term failure pressure” has been replaced with “Resistance to internal pressure” and the term “strain corrosion” has been replaced with “chemical attack”. Also, the reference to EN 1447 has been replaced with reference to ISO 7509;
- In Clause 6.2.3.4 a sentence has been added with reference to EN 681-1 and ISO 4633;
- Clause 6.2.5 has been rewritten;
- In Table 4 reference to ISO 7510 has been added. The notes to the table have been rewritten;
- In Clause 6.4.1.1 the words “the production” have been replaced with “each production batch”;
- Table 6 has been rewritten;
- First paragraph of Clause 6.4.2 has been reworded;
- In Clause B.1 the penultimate paragraph has been deleted;
- In Clause B.2 the items e), f), and g) have been deleted;
- Two items have been added to Clause B.3.4.1;
- Clause B.5 has been reworded and item b) deleted;
- Table C.1 has been completely reworked;
- Note a in Table C.2 has been removed and the table corrected accordingly, a column has been added, and reference to  $\alpha$  and  $\beta$  factors removed;
- In Clause D.2.2.3.2 the word “deflection” has been replaced with “initial ring stiffness”
- Throughout the document the words “specific ring stiffness” have been replaced with “ring stiffness”;

- Annex E has been completely rewritten;
- A new Annex G has been introduced;
- Typographical and grammatical errors have been corrected throughout the document.

This document can be used to support elaboration of national third-party certification procedures for GRP products (glass-reinforced thermosetting plastics based on unsaturated polyester resin) to be used in piping systems for the transport of water, drainage and sewage.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

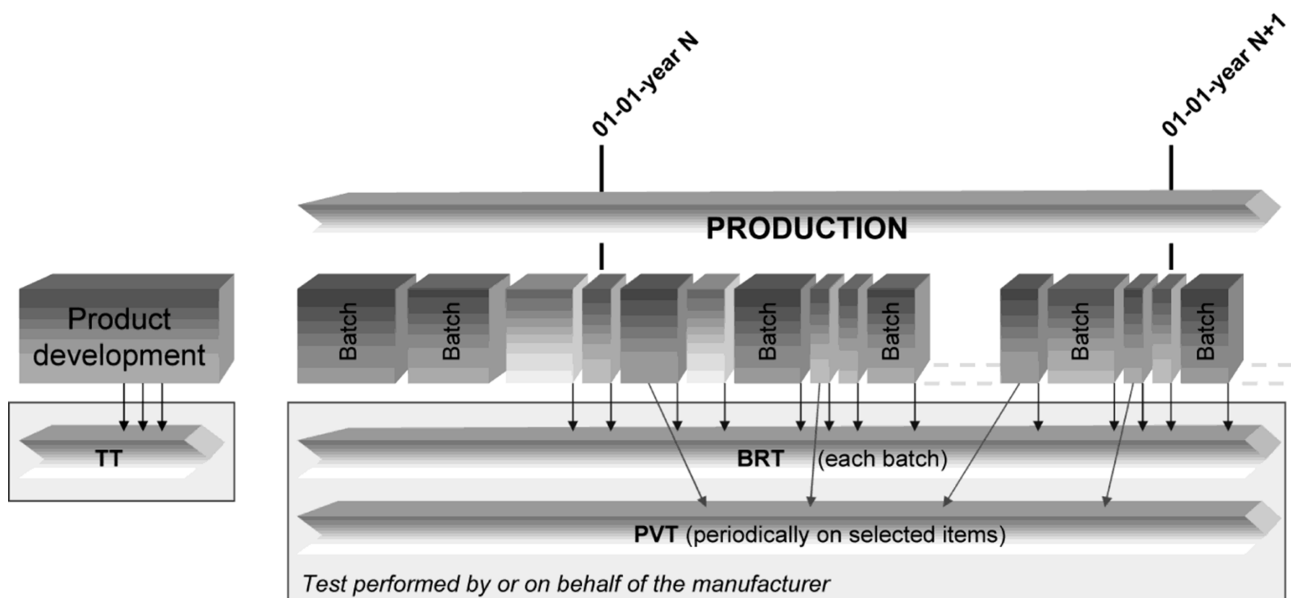
According to the CEN/CENELEC Internal Regulations, the national standards organisations of the following countries are bound to announce this Technical Specification: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

## CEN/TS 14632:2023 (E)

## Introduction

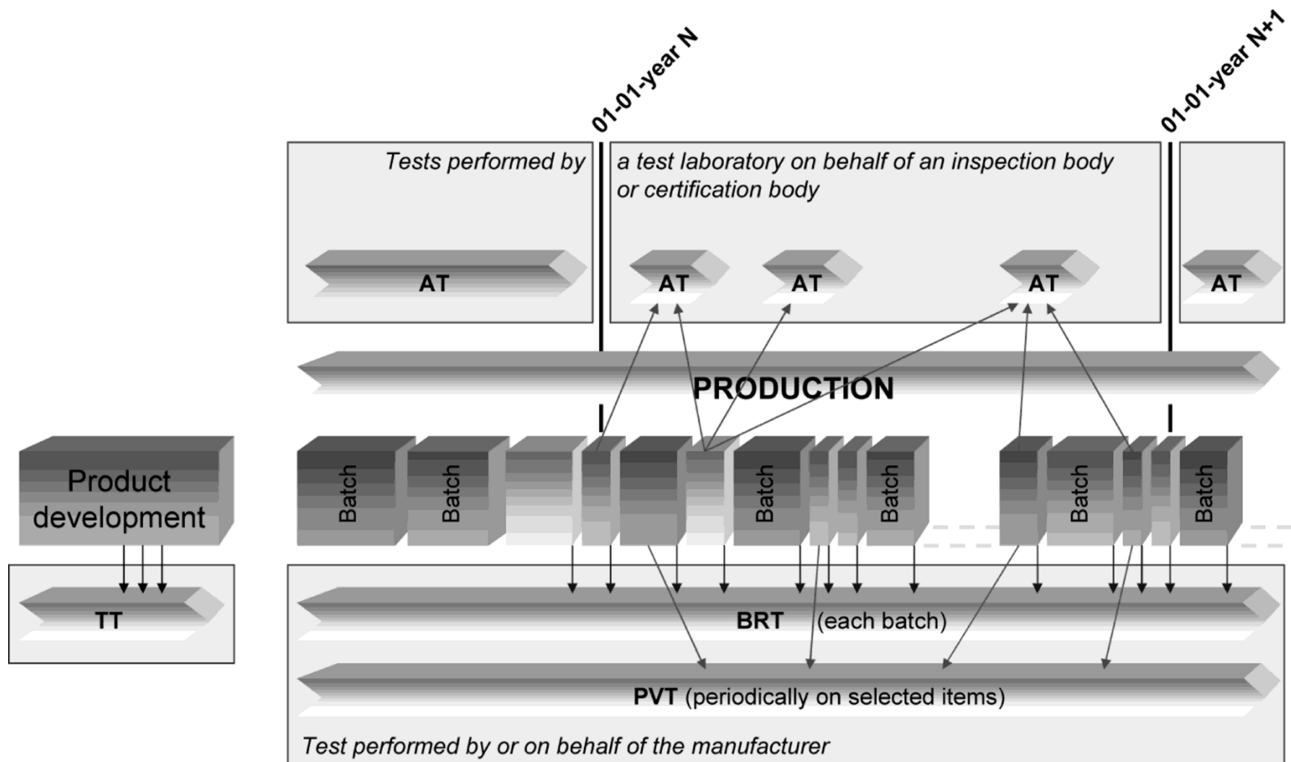
Figures 1 and 2 are intended to provide general information on the concept of testing and organization of those tests used for the purpose of the assessment of conformity. For each type of test (i.e. type testing (TT), batch release test (BRT), process verification test (PVT) and audit test (AT), this document details the applicable characteristics to be assessed and the frequency and sampling of testing.

A typical scheme for the assessment of conformity of pipes, fittings and assemblies by manufacturers is given in Figure 1.



**Figure 1** — Typical scheme for the assessment of conformity by a manufacturer

A typical scheme for the assessment of conformity of pipes, fittings and assemblies by manufacturers, including a third-party certification, is given in Figure 2.



**Figure 2 — Typical scheme for the assessment of conformity by a manufacturer, including a third-party certification**

The quality management system conforms to or is no less stringent than the relevant requirements to EN ISO 9001 [1].



## CEN/TS 14632:2023 (E)

### 1 Scope

This document gives guidance on the assessment of conformity of GRP-UP (glass-reinforced thermosetting resins based on unsaturated polyesters) piping products and assemblies in accordance with EN ISO 23856. ISO 25780 and ISO 16611 intended to be included in the manufacturer's quality plan as part of the quality management system and for the establishment of third-party certification procedures.

This document also gives guidance on the assessment of conformity of GRP-UP manholes and inspection chambers (see EN 15383 for additional information). Pipes (see EN ISO 23856) are used for manufacturing the shafts and chamber units. Additional statements as needed to assess the conformity of manholes and inspection chambers are given in Annex F.

NOTE 1 For the purpose of this document, the term polyester resin (UP) also includes vinyl-ester resins (VE).

NOTE 2 If third-party certification is involved, the certification body is accredited to ISO/IEC 17065 or EN ISO/IEC 17021 [3] as applicable.

### 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 681-1, *Elastomeric seals - Materials requirements for pipe joint seals used in water and drainage applications - Part 1: Vulcanized rubber*

ISO 4633, *Rubber seals – Joint rings for water supply, drainage and sewerage pipelines – Specifications for materials*

ISO 7509, *Plastics piping systems — Glass-reinforced thermosetting plastics (GRP) pipes — Determination of time to failure under sustained internal pressure*

EN 1990, *Eurocode - Basis of structural and geotechnical design*

EN 15383, *Plastics piping systems for drainage and sewerage — Glass-reinforced thermosetting plastics (GRP) based on polyester resin (UP) — Manholes and inspection chambers*

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

EN ISO 23856, *Plastics piping systems for pressure and non-pressure water supply, drainage or sewerage - Glass-reinforced thermosetting plastics (GRP) systems based on unsaturated polyester (UP) resin (ISO 23856)*

ISO 25780, *Plastics piping systems for pressure and non-pressure water supply, irrigation, drainage or sewerage — Glass-reinforced thermosetting plastics (GRP) systems based on unsaturated polyester (UP) resin — Pipes with flexible joints intended to be installed using jacking techniques*

ISO 16611, *Plastics piping systems for drainage and sewerage without pressure — Non-circular pipes and joints made of glass-reinforced thermosetting plastics (GRP) based on unsaturated polyester resins (UP) — Dimensions, requirements and tests*

ISO 7432, *Glass-reinforced thermosetting plastics (GRP) pipes and fittings — Test methods to prove the design of locked socket-and-spigot joints, including double-socket joints, with elastomeric seals*

ISO 7510, *Plastics piping systems — Glass-reinforced plastics (GRP) components — Determination of the amounts of constituents*

ISO 7685, *Glass-reinforced thermosetting plastics (GRP) pipes — Determination of initial ring stiffness*

ISO 8513, *Plastics piping systems — Glass-reinforced thermosetting plastics (GRP) pipes — Determination of longitudinal tensile properties*

ISO 8521, *Glass-reinforced thermosetting plastic (GRP) pipes — Test methods for the determination of the initial circumferential tensile wall strength*

ISO 8533, *Glass-reinforced thermosetting plastics (GRP) pipes and fittings — Test methods to prove the design of cemented or wrapped joints*

ISO 8639, *Glass-reinforced thermosetting plastics (GRP) pipes and fittings — Test methods for leaktightness and proof of structural design of flexible joints*

ISO 10466, *Glass-reinforced thermosetting plastics (GRP) pipes — Test method to prove the resistance to initial ring deflection*

ISO 10468, *Glass-reinforced thermosetting plastics (GRP) pipes — Determination of the creep properties under wet or dry conditions*

ISO 10471, *Glass-reinforced thermosetting plastics (GRP) pipes — Determination of the long-term ultimate bending strain and the long-term ultimate relative ring deflection under wet conditions*

ISO 10928, *Plastics piping systems — Glass-reinforced thermosetting plastics (GRP) pipes and fittings — Methods for regression analysis and their use*

ISO 10952, *Glass-reinforced thermosetting plastics (GRP) pipes and fittings — Determination of the resistance to chemical attack for the inside of a section in a deflected condition*

ISO 18851, *Plastics piping systems — Glass-reinforced thermosetting plastics (GRP) pipes and fittings — Test method to prove the structural design of fittings*

ISO/TS 20656-1, *Plastics piping systems — General rules for structural design of glass-reinforced thermosetting plastics (GRP) pipes — Part 1: Buried pipes*

ISO 178, *Plastics — Determination of flexural properties*

**koniec náhľadu – text ďalej pokračuje v platenej verzii STN**