

STN	Meď a zliatiny meďi Potrubné armatúry Časť 20: Definície, závitové rozmery, skúšobné metódy, referenčné údaje a podporné informácie	STN EN 1254-20+A1 13 8400
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Copper and copper alloys - Plumbing fittings - Part 20: Definitions, thread dimensions, test methods, reference data and supporting information

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. 04/25

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EN 1254-20:2021+A1

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English Version

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

Cuivre et alliages de cuivre - Raccords - Partie 20 :
Définitions, dimensions de filetage, méthodes d'essai,
données de référence et informations complémentaires

Kupfer und Kupferlegierungen - Fittings - Teil 20:
Definitionen, Gewindemaße, Prüfverfahren,
Referenzdaten und ergänzende Informationen

This European Standard was approved by CEN on 23 November 2020 and includes Amendment 1 approved by CEN on 5 December 2024.

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

EN 1254-20:2021+A1:2025 (E)**Contents**

Page

European foreword.....	5
1 Scope	6
2 Normative references	6
3 Terms and definitions	7
4 Thread dimensions.....	10
4.1 Wall thickness at threaded portions of fittings.....	10
4.2 Dimensions of tail pipe ends for swivel fittings.....	11
4.3 Dimensions of gas union connectors.....	13
4.4 Threaded end dimensions.....	14
4.5 Minimum bore and cross-sectional area of fittings	20
5 Test method for leak tightness under internal hydrostatic pressure.....	24
5.1 Introduction	24
5.2 Principle	25
5.3 Apparatus.....	25
5.4 Test piece	25
5.5 Procedure.....	26
6 Test method for leak tightness under internal pneumatic pressure	26
6.1 Introduction	26
6.2 Principle	26
6.3 Apparatus.....	27
6.4 Test piece	27
6.5 Procedure.....	28
7 Integrity of fabricated fitting bodies or having an 'as cast' microstructure	29
7.1 Introduction	29
7.2 Principle	29
7.3 Apparatus.....	29
7.4 Test piece	29
7.5 Procedure.....	30
8 Test method for resistance to pull out of joints to metallic tubes	30
8.1 Introduction	30
8.2 Principle	30
8.3 Apparatus.....	30
8.4 Test assembly	31
8.5 Procedure.....	31
9 Test method for the resistance of joints with metallic tube to vibration	31
9.1 Introduction	31
9.2 Principle	31
9.3 Apparatus.....	32
9.4 Test assembly	32
9.5 Procedure.....	33
10 Test method for the resistance of joints to static flexural force	33
10.1 Introduction	33
10.2 Principle	33

10.3	Apparatus	33
10.4	Test piece.....	33
10.5	Procedure	34
11	Test method for leak tightness of joints under vacuum	35
11.1	Introduction.....	35
11.2	Principle.....	35
11.3	Apparatus	35
11.4	Test piece.....	36
11.5	Procedure	36
12	Test method for the resistance of joints to temperature cycling (liquid applications)	37
12.1	Introduction.....	37
12.2	Principle.....	37
12.3	Apparatus	37
12.4	Test assembly	37
12.5	Procedure	39
13	Test method for the resistance of joints to temperature cycling (fuel gas applications).....	39
13.1	Introduction.....	39
13.2	Principle.....	40
13.3	Apparatus	40
13.4	Test assembly	40
13.5	Procedure	40
14	Method for detecting non-pressed fitting ends.....	41
14.1	Introduction.....	41
14.2	Principle.....	41
14.3	Apparatus	41
14.4	Test piece.....	42
14.5	Procedure	42
14.6	Results	42
15	Determination of resistance to stress corrosion.....	43
15.1	Introduction.....	43
15.2	Test piece.....	43
15.3	Procedure	43
15.4	Test report.....	43
16	Test method for detection of a carbon film on the surface of copper fittings.....	43
16.1	Preparation of the test piece	43
16.2	Procedure	43
16.3	Detection and assessment of films	44
17	Determination of mean depth of dezincification	44
17.1	Introduction.....	44
17.2	Procedure	44
17.3	Expression of results	44
18	Test method for the resistance of joints to pressure cycling.....	45
18.1	Introduction.....	45
18.2	Principle.....	45
18.3	Apparatus	45
18.4	Test pieces.....	47
18.5	Procedure	47
19	Test method for disconnection and re-use.....	48

EN 1254-20:2021+A1:2025 (E)

19.1	Introduction	48
19.2	Principle	48
19.3	Apparatus.....	48
19.4	Test assembly	48
19.5	Procedure.....	48
20	Method for determining if the diameter and/or the length of engagement of a capillary end is/are within the specified tolerance.....	48
20.1	Principle	48
20.2	Apparatus.....	49
20.3	Test piece	53
20.4	Procedure.....	53
20.5	Results.....	53
21	Method for determining the minimum length of engagement of an integral solder or brazing ring socket having a formed groove.....	53
21.1	Introduction	53
21.2	Principle	53
21.3	Apparatus.....	53
21.4	Test piece	54
21.5	Procedure.....	54
21.6	Results.....	54
22	⌈A1⌋ Minimum wall thickness ⌈A1⌋.....	55
Annex A (informative) Assembling instructions.....		56
Bibliography		64

European foreword

This document (EN 1254-20:2021+A1:2025) 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 August 2025, and conflicting national standards shall be withdrawn at the latest by August 2025.

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 includes Amendment 1 approved by CEN on 5 December 2024.

This document supersedes A1 EN 1254-20:2021 A1.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

A1 The need for an amendment was based on the following points:

- include a wall thickness table for copper alloy fittings used in systems according to EN ISO 15874, EN ISO 15875, EN ISO 15876, EN ISO 15877, EN ISO 21003 and EN ISO 22391. A1

This document is a supporting standard describing the test methods used by the other parts of the EN 1254 series.

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.

EN 1254-20:2021+A1:2025 (E)

1 Scope

This document contains definitions, thread dimension, reference data (minimum bore $\sqrt{A_1}$) and wall thickness ($\sqrt{A_1}$), supporting information (assembling instructions) and describes the test methods referenced by other parts of the EN 1254 series.

Thread dimensions comprise: wall thickness at threaded portions of fittings, dimensions of tail pipe ends for swivel fittings, dimensions of gas union connectors, thread dimensions and thread profile.

Test methods comprise: leak tightness under internal hydrostatic pressure, leak tightness under internal pneumatic pressure, integrity of fabricated fitting bodies or having an 'as cast' microstructure, resistance to pull out of joints to metallic tubes, resistance of joints with metallic tube to vibration, resistance of joints to static flexural force, leak tightness of joints under vacuum, the resistance of joints to temperature cycling, detecting non-pressed fitting ends, resistance to stress corrosion, detection of a carbon film on the surface of copper fittings, determination of mean depth of dezincification, resistance of joints to pressure cycling, disconnection and re-use, determining if the diameter and/or the length of engagement of a capillary end is/are within the specified tolerance, determining the minimum length of engagement of an integral solder or brazing ring socket having a formed groove.

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 723, *Copper and copper alloys - Combustion method for determination of the carbon content on the inner surface of copper tubes or fittings*

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

EN 1333:2006, *Flanges and their joints - Pipework components - Definition and selection of PN*

EN 10226-1, *Pipe threads where pressure tight joints are made on the threads - Part 1: Taper external threads and parallel internal threads - Dimensions, tolerances and designation*

EN ISO 228-1, *Pipe threads where pressure-tight joints are not made on the threads - Part 1: Dimensions, tolerances and designation (ISO 228-1)*

EN ISO 6509-1:2014, *Corrosion of metals and alloys - Determination of dezincification resistance of copper alloys with zinc - Part 1: Test method (ISO 6509-1:2014)*

EN ISO 6708:1995, *Pipework components - Definition and selection of DN (nominal size) (ISO 6708:1995)*

EN ISO 21003-1:2008, *Multilayer piping systems for hot and cold water installations inside buildings - Part 1: General (ISO 21003-1:2008)*

ISO 7-1:1994, *Pipe threads where pressure-tight joints are made on the threads - Part 1: Dimensions, tolerances and designation*

ISO 7-2, *Pipe threads where pressure-tight joints are 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 6957:1988, *Copper alloys - Ammonia test for stress corrosion resistance*

koniec náhl'adu – text ďalej pokračuje v platenej verzii STN