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- iii) requires additional national guidance or information

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Introduction

This draft standard is based on national and international discussions. Your comments on this draft are invited and will assist in the preparation of the consequent standard.

For international standards, comments will be reviewed by the relevant UK national committee before sending the consensus UK vote and comments to the international committee, which will then decide appropriate action. If the international standard is approved, it is usual for the text to be published as a British Standard.

For national standards, comments will be reviewed by the relevant UK national committee and the resulting standards published as a British Standard.

UK Vote

Please indicate whether you consider the UK should submit a negative (with supporting technical reasons) or positive vote on this draft. Please indicate if you are aware of any reason why this draft standard should not be published as a British Standard.

Submission of Comments

- **Annotated drafts are not acceptable and will be rejected.**
- All comments should be submitted online at <https://standardsdevelopment.bsigroup.com/>. You will need to register in order to comment.

Template for comments and secretariat observations

Date: xx/xx/20xx	Document: ISO/DIS xxxx
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1	2	(3)	4	5	(6)	7
MB	Clause No./ Subclause No./Annex (e.g. 3.1)	Paragraph/ Figure/Table/Note	Type of comment	Comment (justification for change) by the MB	Proposed change by the MB	Secretariat observations on each comment submitted
	3.1	Definition 1	ed	Definition is ambiguous and needs clarifying.	Amend to read '...so that the mains connector to which no connection...'	
	6.4	Paragraph 2	te	The use of the UV photometer as an alternative cannot be supported as serious problems have been encountered in its use in the UK.	Delete reference to UV photometer.	

English Version

Unplasticized poly(vinyl chloride) (PVC-U) profiles for the
fabrication of windows and doors - Classification,
requirements and test methods - Part 1: Non-covered PVC-
U profiles

Profils de poly(chlorure de vinyle) non plastifié (PVC-
U) pour la fabrication des fenêtres et des portes -
Classification, exigences et méthodes d'essai - Partie 1 :
Profils en PVC-U non revêtus

Profile aus weichmacherfreiem Polyvinylchlorid (PVC-
U) zur Herstellung von Fenstern und Türen -
Klassifizierung, Anforderungen und Prüfverfahren -
Teil 1: Nicht beschichtete PVC-U-Profile

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 249.

If this draft becomes a European Standard, 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.

This draft European Standard was established by CEN 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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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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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

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European foreword

This document (prEN 12608-1:2025) has been prepared by Technical Committee CEN/TC 249 “Plastics”, the secretariat of which is held by SIS.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 12608:2016+A1:2020.

The main changes compared to the previous edition are as follows:

- the restriction of profile colour and the exclusion of fibre reinforced material in Clause 1 have been deleted;
- material definitions in Clause 3 have been deleted and replaced by reference to EN 17508;
- requirements for materials have been summarized in new Annex A;
- the use of RUVM for non-sight visible surface has been permitted;
- the determination of the ash content has been added as an additional test method to Clause 6;
- editorial changes have been made and normative references have been updated.

EN 12608, *Unplasticized poly(vinyl chloride) (PVC-U) profiles for the fabrication of windows and doors — Classification, requirements and test methods* consists of the following parts:

- *Part 1: Non-covered PVC-U profiles*
- *Part 2: PVC-U profiles with laminated foils bonded with adhesives*
- *Part 3: PVC-U profiles covered with paint* (in preparation)
- *Part 4: PVC-U profiles with thermo-laminated foils*
- *Part 5: PVC-U profiles with coextruded coloured top-layer* (in preparation)

1 Scope

This document specifies the classifications, requirements and test methods for non-covered unplasticized poly(vinyl chloride) (PVC-U) profiles intended to be used for the fabrication of windows and doors.

NOTE For editorial reasons in this document the term “window” is used for window/door.

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 477, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the resistance to impact of profiles by falling mass*

EN 478, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the appearance after exposure at 150 °C*

EN 479, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of heat reversion*

EN 513, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the resistance to artificial weathering*

EN 514, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the strength of welded corners and T-joints*

EN 17508, *Plastics — Unplasticized poly(vinyl chloride) (PVC-U) profiles for the fabrication of windows and doors — Terminology of PVC based materials*

EN 20105-A02, *Textiles — Tests for colour fastness — Part A02: Grey scale for assessing change in colour*

EN ISO 105-A01:2010, *Textiles — Tests for colour fastness — Part A01: General principles of testing (ISO 105-A01:2010)*

EN ISO 178, *Plastics — Determination of flexural properties*

EN ISO 179-1, *Plastics — Determination of Charpy impact properties — Part 1: Non-instrumented impact test*

EN ISO 306, *Plastics — Thermoplastic materials - Determination of Vicat softening temperature (VST)*

EN ISO 3451-5:—¹ *Plastics — Determination of ash — Part 5: Poly(vinyl chloride)*

EN ISO 8256, *Plastics — Determination of tensile-impact strength*

EN ISO 21306-2:2019, *Plastics — Unplasticized poly(vinyl chloride) (PVC-U) moulding and extrusion materials — Part 2: Preparation of test specimens and determination of properties (ISO 21306-2:2019)*

EN ISO/CIE 11664-1, *Colorimetry — Part 1: CIE standard colorimetric observers*

EN ISO/CIE 11664-2, *Colorimetry — Part 2: CIE standard illuminants*

¹ Under preparation. Stage at the time of publication: prEN ISO 3451-5:2024.

EN ISO/CIE 11664-4, *Colorimetry — Part 4: CIE 1976 L*a*b* Colour space*

ISO 18314-1, *Analytical colorimetry — Part 1: Practical colour measurement*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 17508 and the following apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp/>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1 profile

product produced by extrusion

3.2 non-covered profile

profile without any surface covering and without coextruded layer(s)

EXAMPLE Profiles without laminated foils or painted surfaces.

3.3 main profile

profile, which defines the structure of the window

Note 1 to entry: See Figure 1.

3.4 auxiliary profile

profile intended to be used for the fabrication of a window which is not a main profile

Note 1 to entry: Main and auxiliary profiles can be different according to the window construction techniques in the individual countries.

Note 2 to entry: See Figure 1.