

Methods of testing plastics —

Part 11: Thermoplastics pipes, fittings and valves —

Method 1150B: Plastics pipes and fittings — Preparation of polyethylene (PE) pipe/pipe or pipe/fitting test piece assemblies by butt fusion

ICS 23.040.20; 23.040.45

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National foreword

This British Standard reproduces verbatim ISO 11414:1996 and implements it as the UK national standard.

This international standard is incorporated into BS 2782 *Methods of testing plastics*: Part 11 *Thermoplastics pipes, fittings and valves*, as Method 1150B:1998, for association with related test methods for plastics materials and plastics piping components.

The UK participation in its preparation was entrusted by Technical Committee PRI/61, Plastics piping systems and components, to Subcommittee PRI/61/4, Methods of test for thermoplastics piping systems and components, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible international/European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

A list of organizations represented on this subcommittee can be obtained on request to its secretary.

The responsible UK technical committee considers that certain aspects of the text as published are misleading and require clarification or further attention as follows.

a) In clause 6, the opening paragraph requires use of pipes and fittings conforming to ISO 4427, ISO 4437 and ISO 8085-2 as applicable. The method may be applicable where one or more of the components conforms to some other standard, in which case reference to this method should be modified accordingly.

b) The purpose of this document is to establish performance with a test piece incorporating a misalignment. It is applicable for type testing to show that a joint could tolerate the sorts of level of butt misalignment likely to occur in practice.

In clause 6 a), the words “at the most” before the limiting values for misalignment are in each case therefore considered to be misleading, because they require the preparation of joints with less misalignment and permit the use of joints with no misalignment for the conduct of this test, which was not the intention. For the purposes of testing components and joints for adequate tolerance of misalignment, the UK technical committee considers that the words “at the most” should be read as “at least”.

For field installation however, for which deliberate misalignment is inappropriate, the UK committee’s advice to supplement the third paragraph of the scope is that any misalignment during field assembly should not exceed the applicable value given in clause 6 a).

c) In clause 6 b), for the English text, the words “over a maximum of one-third of the circumference” are incorrectly located. As printed, the text appears to require that not more than one third of each butt fusion face is prepared and planed, leaving the rest “as received”. Furthermore, this would be difficult and deleterious if the faces are initially truly plane and square to their axes.

In the view of the UK technical committee, the words in question should for the English text have been located following “clearance D_w ”, to achieve the following meaning: Prepare and plane the whole of each butt fusion face so that:

- 1) any subsequent clearance D_w between the faces does not extend over more than one third of the circumference;
- 2) any such clearance does not exceed 0,3 mm when $d_n < 200$ or 0,5 mm when $d_n \geq 200$.

In Table A.1, the heater plate temperatures given are not unsuitable, but as indicated in the third paragraph of the scope, they do not necessarily align with or supersede those used in the field. For field installation in the UK, heater plate temperatures of $\left(230 \frac{+10}{-5}\right) ^\circ\text{C}$ are generally used for all pipe sizes.

Cross-references

The British Standards which implement international or European publications referred to in this document may be found in the BSI Standards Catalogue under the section entitled “International Standards Correspondence Index”, or by using the “Find” facility of the BSI Standards Electronic Catalogue.

References are made to ISO 4427, ISO 4437 and ISO 8085-2, for which there are no identical British Standards, because the corresponding British Standards are expected to be replaced by implementation of the relevant Parts of EN 1555.

WARNING NOTE. This British Standard, which is identical with ISO 11414:1996, does not necessarily detail all the precautions necessary to meet the requirements of the Health and Safety at Work etc. Act 1974. Attention should be paid to any appropriate safety precautions and the method should be operated only by trained personnel.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i to iv, the ISO title page, pages ii to iv, pages 1 to 4 and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.