BS EN 12608-1:2026

BSI Standards Publication

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



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National foreword

This British Standard is the UK implementation of EN 12608-1:2026. It supersedes BS EN 12608-1:2016+A1:2020, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee PRI/300, GB Co-ordination for International work on plastics standards.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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Profilés 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 : Profilés 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 European Standard was approved by CEN on 5 July 2026.

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European foreword

This document (EN 12608-1:2026) has been prepared by Technical Committee CEN/TC 249 “Plastics”, the secretariat of which is held by SIS.

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of an identical text or by endorsement, at the latest by February 2026, and conflicting national standards shall be withdrawn at the latest by February 2026.

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 12608-1:2016+A1:2020.

This document includes the following significant technical changes with respect to EN 12608-1:2016+A1:2020:

— 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 surfaces has been permitted;

— classification of main profiles according to the resistance to impact by falling mass has been deleted and the test method has been moved to Clause 6 as optional property;

— the determination of the ash content has been added as an additional test method for an optional property 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 covered 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 co-extruded coloured top-layer* (in preparation)

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.

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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 15346, *Plastics — Recycled plastics — Characterization of poly(vinyl chloride) (PVC) recyclates*

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 (ISO 105-A02)*

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 (ISO 178)*

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

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

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

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

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

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)*

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

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

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

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 any co-extruded layer(s) that are not made of PVC-U

EXAMPLE Profiles without laminated foils or painted surfaces.

Note 1 to entry: Profiles covered with a co-extruded layer other than PVC-U will be covered by a separate part of this standard series (in preparation).

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.

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