INTERNATIONAL STANDARD

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AMENDMENT 1
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Plastics piping systems for the supply of gaseous fuels - Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing —

Part 2: **Pipes**

AMENDMENT 1

Systèmes de canalisations en matières plastiques pour la distribution de combustibles gazeux — Systèmes de canalisations en polyamide non plastifié (PA-U) avec assemblages par soudage et assemblages mécaniques —

Partie 2: Tubes

AMENDEMENT 1

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Foreword

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Amendment 1 to ISO 16486-2:2012 was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 4, *Plastics pipes and fittings for the supply of gaseous fuels*.

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Page 9, A.3.6

Replace the existing third paragraph with the following one:

"Plug in the heater and bring the surface temperatures up to the temperature range (220 °C to 260 °C). Install the heater in the butt fusion machine and bring the pipe ends into full contact with the heater. To ensure that full and proper contact is made between the pipe ends and the heater, the initial contact should be under moderate pressure. After holding the pressure very briefly, it should be released without breaking contact. Continue to hold the components in place, without force, while a bead of molten PA-U develops between the heater and the pipe ends. When the proper bead size is formed against the heater surfaces, the heater should be removed. The bead size is dependent on the pipe size. For $d_n \leq 50$ mm, a bead size of approximately 1,5 mm should be present and for $d_n > 50$ mm, a bead size of 3 mm to 5 mm should be present before removing the heater."

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