

## საქართველოს სტანდარტი

---

სტრუქტურული ადჰეზივები - ანაერობული ადჰეზივების მახასიათებლები  
ღერძული მეტალის შეკრებაზე სამშენებლო და საზოგადოებრივ ნაგებობებში

საინფორმაციო ნაწილი. სრული ტექსტის სანახავად შეიძინეთ სტანდარტი.

საქართველოს სტანდარტებისა და მეტროლოგიის  
ეროვნული სააგენტო  
თბილისი

# სსტ ენ 15275:2015/2018

## საინფორმაციო მონაცემები

1 შემუშავებულია საქართველოს სტანდარტების და მეტროლოგიის ეროვნული სააგენტოს სტანდარტების დეპარტამენტის მიერ

2 დამტკიცებულია და შემოღებულია სამოქმედოდ საქართველოს სტანდარტების და მეტროლოგიის ეროვნული სააგენტოს 2018 წლის 17 აგვისტოს № 85 განკარგულებით

3 მიღებულია გარეკანის თარგმნის მეთოდით სტანდარტიზაციის ევროპული კომიტეტის სტანდარტი ენ 15275:2015:2011 „სტრუქტურული ადჰეზივები - ანაერობული ადჰეზივების მახასიათებლები ღერძული მეტალის შეკრებაზე სამშენებლო და საზოგადოებრივ ნაგებობებში“

### 4 პირველად

5 რეგისტრირებულია საქართველოს სტანდარტების და მეტროლოგიის ეროვნული სააგენტოს რეესტრში: 2018 წლის 17 აგვისტო №268-1.3-013967

აკრძალულია ამ სტანდარტის გადაცემა მესამე პირებისათვის ან/და მისი სხვა ფორმით გავრცელება

English Version

## Structural adhesives - Characterisation of anaerobic adhesives for co-axial metallic assembly in building and civil engineering structures

Adhésifs structuraux - Caractérisation des adhésifs  
anaérobies pour assemblages métalliques coaxiaux dans  
les bâtiments et ouvrages de génie civil

Strukturklebstoffe - Charakterisierung anaerober Klebstoffe  
für koaxiale Metallverbindungen im Bauwesen

This European Standard was approved by CEN on 25 January 2015.

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.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

**Contents**

Page

Foreword.....4

Introduction .....5

1 Scope .....6

2 Normative references .....6

3 Terms and definitions .....6

4 Performance characteristics for intended uses .....6

5 Test methods.....8

5.1 Retaining co-axial assemblies.....8

5.1.1 Static shear strength .....8

5.1.2 Durability .....8

5.1.3 Heat resistance .....9

5.2 Threaded fasteners.....9

5.2.1 Torque strength; breakloose torque; breakaway torque.....9

5.2.2 Durability .....9

5.2.3 Heat resistance .....9

5.3 Threaded joints in contact with 1st, 2nd and 3rd family gases and hot water.....9

5.3.1 General.....9

5.3.2 Sealing ability.....9

5.4 Release of dangerous substances.....9

6 Assessment and verification of constancy of performance (AVCP)..... 10

6.1 General..... 10

6.2 Type testing..... 10

6.2.1 General..... 10

6.2.2 Test samples, testing and compliance criteria..... 11

6.2.3 Test reports ..... 11

6.2.4 Shared other party results ..... 11

6.2.5 Cascading determination of the product type results ..... 12

6.3 Factory production control (FPC) ..... 13

6.3.1 General..... 13

6.3.2 Requirements ..... 13

6.3.3 Product specific requirements ..... 15

6.3.4 Initial inspection of factory and of FPC ..... 16

6.3.5 Continuous surveillance of FPC ..... 17

6.3.6 Procedure for modifications..... 17

6.3.7 One-off products, pre-production products (e.g. prototypes) and products produced in very low quantity..... 17

Annex A (informative) Indicative values for performance characteristics ..... 19

Annex ZA (informative) Clauses of this European Standard addressing the provisions of the EU Construction Products Regulation ..... 20

ZA.1 Scope and relevant characteristics ..... 20

ZA.2 Procedure for AVCP of anaerobic adhesives ..... 21

ZA.2.1 System of AVCP..... 21

ZA.2.2 Declaration of performance (DoP) ..... 22

ZA.2.2.1 General ..... 22

საინფორმაციო ნაწილი. სრული ტექსტის სახსრავად შეიძინეთ სტანდარტი.

<b>ZA.2.2.2</b>	<b>Content.....</b>	<b>22</b>
<b>ZA.2.2.3</b>	<b>Example of DoP.....</b>	<b>23</b>
<b>ZA.3</b>	<b>CE marking and labelling.....</b>	<b>25</b>
<b>Bibliography.....</b>		<b>28</b>

## Foreword

This document (EN 15275:2015) has been prepared by Technical Committee CEN/TC 193 “Adhesives”, the secretariat of which is held by AENOR.

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 October 2015, and conflicting national standards shall be withdrawn at the latest by January 2017.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 15275:2007.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association.

For relationship with EU Regulation see informative Annex ZA, which is an integral part of this document.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

## Introduction

Anaerobic adhesives are single component adhesives that cure in absence of oxygen, curing being inhibited by the presence of oxygen and catalysed by metal ions. Polymerisation takes normally place at room temperature. Due to their curing properties these adhesives are well suited for easy assembling threaded and otherwise, pipes and tubes in building and civil engineering structures. By the curing reaction a polymeric material is formed, which fills narrow gaps or micro-imperfections of threads thus sealing and bonding the joint. In addition, anaerobic adhesives may be used to joint load-bearing parts of the structures when used in tubular lap joints or pin-into-bore type joints.

The primary aim of the test methods presented herein is for ranking and quality control of anaerobic adhesives and reliance should not be placed on any test results for design purposes. Design data should preferably be obtained from tests using the construction materials and configurations used in the actual design. The requirements to the assemblies are strongly depending on the intended use. Apart from the sealing ability, strength requirements may conflict with the intention to regular or occasional dismantling the joint for maintenance purposes. The values defined in this standard are considered to indicate a general or typical suitability for use of an anaerobic adhesive in a particular application in building and civil engineering structures.