



**BSI Standards Publication**

# **Unplasticized poly(vinyl chloride) (PVC-U) profiles for the fabrication of windows and doors — Classification, requirements and test methods**

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Part 2: PVC-U profiles covered with foils bonded with adhesives

This is a preview of BS EN 12608-2:2023. [Click here to purchase the full version from the ANSI store.](#)

## National foreword

This British Standard is the UK implementation of EN 12608-2:2023. It supersedes BS 7722:2010 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee PRI/21, Testing of plastics.

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

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Date	Text affected
31 January 2024	Correction to supersession details in national foreword
31 July 2025	Implementation of CEN correction notice 1 November 2023: update of the German title and correction of unit for flexural modulus of elasticity $E_f$ in Table A.1 from $N/m^2$ to $N/mm^2$
30 September 2025	Correction to national foreword

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## EUROPÄISCHE NORM

October 2023

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English Version

## Unplasticized poly(vinyl chloride) (PVC-U) profiles for the fabrication of windows and doors - Classification, requirements and test methods - Part 2: PVC-U profiles covered with foils bonded with adhesives

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 2 : Profils en PVC-U plaxés avec des films collés

Profile aus weichmacherfreiem Polyvinylchlorid (PVC-U) zur Herstellung von Fenstern und Türen - Klassifizierung, Anforderungen und Prüfverfahren - Teil 2: PVC-U-Profile mit durch Klebstoff kaschierte Folien

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This European Standard was corrected and reissued by the CEN-CENELEC Management Centre on 01 November 2023.

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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 (EN 12608-2:2023) 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 April 2024, and conflicting national standards shall be withdrawn at the latest by April 2024.

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.

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

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

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

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## 1 Scope

This document specifies the classifications, requirements and test methods for unplasticized poly(vinyl chloride) (PVC-U) profiles covered with foils designed for external uses bonded with adhesives which are intended to be used for the fabrication of windows and doors.

NOTE 1 For editorial reasons, in this document, the term “window” is used for window/door.

NOTE 2 For the purpose of production control, test methods other than those specified in this document can be used.

## 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 410, *Glass in building — Determination of luminous and solar characteristics of glazing*

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(vinylchloride) (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 12608-1:2016+A1:2020, *Unplasticized poly(vinyl chloride) (PVC-U) profiles for the fabrication of windows and doors — Classification, requirements and test methods — Part 1: Non-coated PVC-U profiles with light coloured surfaces*

EN 17271, *Plastics — Poly(vinyl chloride) (PVC) based profiles — Determination of the peel strength of profiles laminated with foils*

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 2409, *Paints and varnishes — Cross-cut test (ISO 2409)*