

# DAIRY GRADE TUBE

DIN EN10357 FORMALLY DIN 11850

## TECHNICAL INFORMATION

**All Tubes are made to Din EN10217-7 Euro Norm standards.**

Dairy tubes are additionally certified to **EN10357** once the longitudinal internal weld bead is flatted or removed to ensure there are no bacterial traps within the tube. It is this process which turns a standard tube into a **'Food Grade'** Tube.

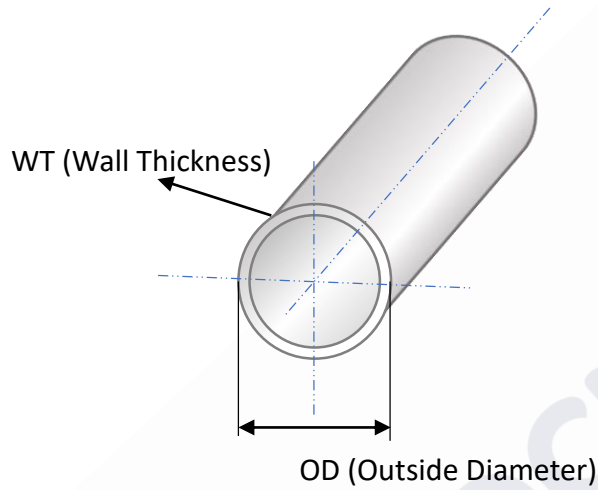
Hence on Material Test Reports you will need **EN10217-7** and also **EN10357** referred to within the report to ensure the tubes are **'Food Grade'**

There are different surface properties available but CC Finish is the most popular within the food industry.

All tubes are pickled allowing an internal **surface finish of <0.8um** , with the internal weld seam area being **<1.6um**.

**The OD of the tube is usually Sateen Polished to a 220 Grit finish and Sleeved for Series D , Imperial Sizes.**

**For Metric Series A and Iso Series C, the norm is a Pickled External Finish without sleeving.**



## TECHNICAL INFORMATION

### TUBE ACC. TO DIN EN10357

### SERIES A

Size WT OD	304/L	316/L	Surface Properties	OD Finish	Weight kg/m
19 x 1.5	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	0.64
23 x 1.5	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	0.81
29 x 1.5	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	1.03
35 x 1.5	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	1.25
41 x 1.5	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	1.48
53 x 1.5	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	1.93
70 x 2.0	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	3.40
85 x 2.0	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	4.15
104 x 2.0	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	5.10
129 x 2.0	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	6.36
154 x 2.0	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	7.61
204 x 2.0	x	x	CC Finish, Pickled & Passivated	Pickled & Unsleeved	10.11

x – Denoted Stock Item.

## SERIES D

Size WT OD	304/L	31x6/L	Surface Properties	OD Finish	Weight kg/m
25.4 x 1.2	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	0.71
25.4 x 1.5	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	0.88
38.1 x 1.2	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	1.11
38.1 x 1.5	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	1.37
50.8 x 1.2	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	1.85
50.8 x 1.5	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	1.50
63.5 x 1.5	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	2.32
76.1 x 1.5	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	2.80
76.1 x 2.0	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	3.714
101.6 x 1.5	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	3.75
101.6 x 2.0	x	x	CC Finish, Pickled & Passivated	220 Grit & Sleeved	4.98

x – Denoted Stock Item.

### INDICATIVE TABLE FOR MAXIMUM PRESSURES AT 20°C FOR STAINLESS STEEL WELDED TUBES ACCORDING TO THE DIN 17457 – 11850 STANDARD

DIMENSIONS WT OD	AISI 304/321 316/316TI Kg./cm <sup>2</sup>	AISI 304/L316/L Kg./cm <sup>2</sup>
19.05 x 1.65	151	125
25.4 x 1.25	86	71
25.4 x 1.65	114	94
38 x 1	46	38
38 x 1.5	59	57
50 x 1.5	52	43
76.1 x 1.65	38	31
101.6 x 1.65	28	23
101.6 x 2	34	28
129 x 2	27	22
154 x 2	23	19
204 x 2	17	14
254 x 2	14	11