

**Data Sheet**

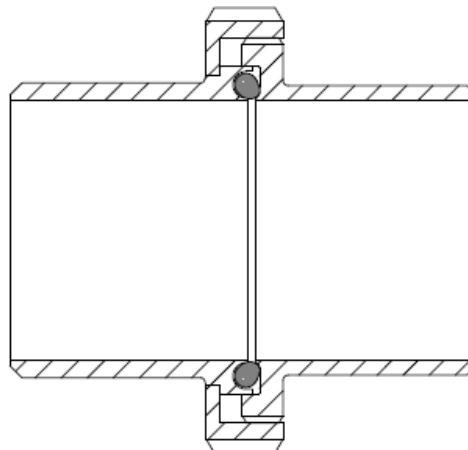
## DIN 11864-1 Aseptic Unions for BS 4825 / ISO 2037 and ASME BPE 2002

### DIN 11864 -1 Aseptic Screwed Union

This range of aseptic fittings has been developed by the German hygienic industry to meet the exacting needs of the food, chemical and pharmaceutical industries.

Three designs of pipe fittings have been tailored to accept 2 different styles of aseptic seals that effect a smooth interface within the pipe work whilst simultaneously achieving a metal to metal seat behind the joint.

The seal sections used are referenced as "Form A" and "Form B" and both have distinctive profiles that are easily recognised. Form A is an O Ring Joint whilst Form B is a 2-part Square seal with a secondary internal diamond section.



This design of fitting is based on the DIN 11851 Hygienic Screwed Union.

This firmly established industry standard the union was used as the basis for the design upgrade where an Aseptic Joint replaced the convention D Section Seal.

The new design was initially referred to as the DIN 11853 Aseptic Screwed Union before finally being included as the first of the 3 new sections of the DIN 11864 standard.

Available with optional lengths to suit Orbital and Manual Welding, these unions have been designed to match tube and pipe specifications in DIN 11850; ISO 2037, ASME BPE 2002 and BS 4825 Part 1 and also ISO 1127 for schedule pipe.

Size range: ½" to 4"

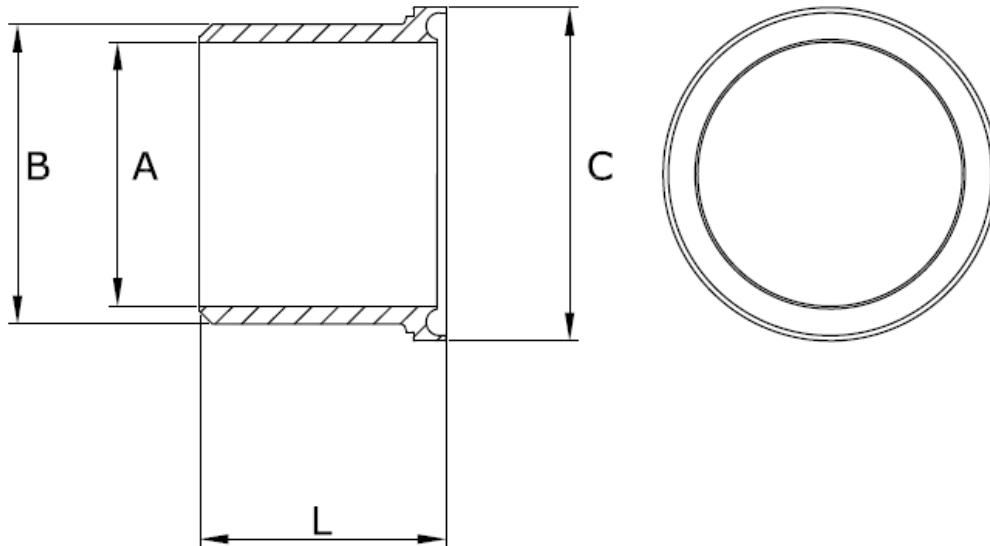
Materials: 316L SS

#### Related standards:

DIN 11864-1 Form A - Aseptic Screwed Union  
DIN 11864-2 Form A - Aseptic Flange Union  
DIN 11864-3 Form A - Aseptic Tri-Clamp Union  
DIN 11866 / 11850  
ISO1127  
ISO 2037 / BS 4825 /ASME BPE 2002  
DIN 11853 (Type 1 only)

**Data Sheet**

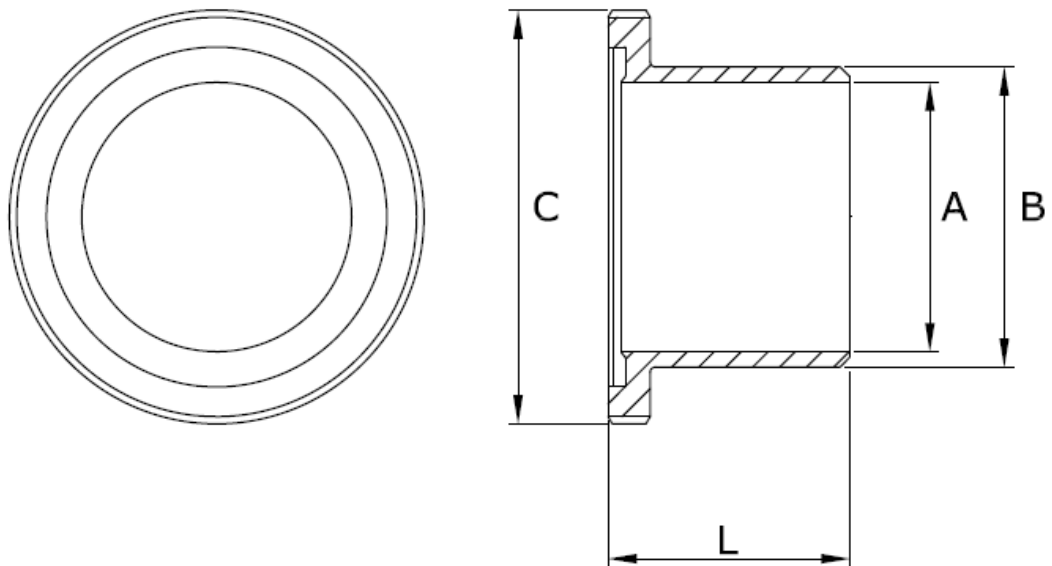
**DIN11864-1 "Form A" Weld Liner, 316L SS  
BS4825 / ISO 2037 / ASME BPE 2002**



Size:	A	B	C	L1 (Orbital Weld)	L2 (Manual Weld)	Detail
1/2"	9.4	12.7	21.9	39.0	21.0	A063-A013
3/4"	15.8	19.1	27.9	39.0	21.0	A063-A019
1"	22.1	25.4	42.9	40.0	22.0	A063-A026
1 1/2"	34.8	38.1	54.9	46.5	26.0	A063-A038
2"	47.5	50.8	66.9	47.5	30.0	A063-A051
2 1/2"	60.2	63.5	84.9	63.0	34.0	A063-A064
3"	72.9	76.2	98.9	61.0	38.0	A063-A076
4"	97.4	101.6	118.9	65.0	46.0	A063-A102

**Data Sheet**

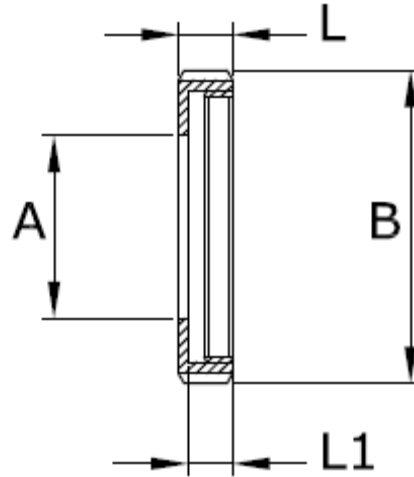
**DIN11864-1 "Form A" Weld Male, 316L SS.  
BS4825 / ISO 2037 / ASME BPE 2002**



Size:	A	B	C	L1 (Orbital Weld)	L2 (Manual Weld)	Detail
1/2"	9.4	12.7	28 x 1/8"	41.0	23.0	A061-A013
3/4"	15.8	19.1	34 x 1/8"	41.0	23.0	A061-A019
1"	22.1	25.4	52 x 1/6"	43.0	26.0	A061-A026
1 1/2"	34.8	38.1	65 x 1/6"	48.5	31.0	A061-A038
2"	47.5	50.8	78 x 1/6"	48.5	31.0	A061-A051
2 1/2"	60.2	63.5	95 x 1/6"	60.0	36.0	A061-A064
3"	72.9	76.2	110 x 1/4"	64.0	42.0	A061-A076
4"	97.4	101.6	130 x 1/4"	64.0	50.0	A061-A102

**Data Sheet**

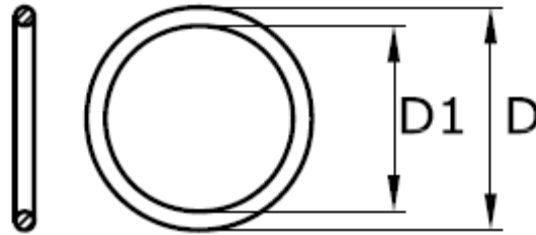
**DIN11864-1 "Form A" Slotted Nut 316L SS**



Size:	A	B	Thread Detail	L	L1	Detail
1/2"	19	38	28 x 1/8"	18	15	A064-A010
3/4"	25	44	34 x 1/8"	18	15	A064-A015
1"	36	63	52 x 1/6"	21	18	A064-A025
1 1/2"	49	78	65 x 1/6"	21	18	A064-A040
2"	62	92	78 x 1/6"	22	19	A064-A050
2 1/2"	60	112	95 x 1/6"	25	21	A064-A065
3"	94	127	110 x 1/4"	29	25	A064-A080
4"	115	148	130 x 1/4"	31	26	A064-A100

**Data Sheet**

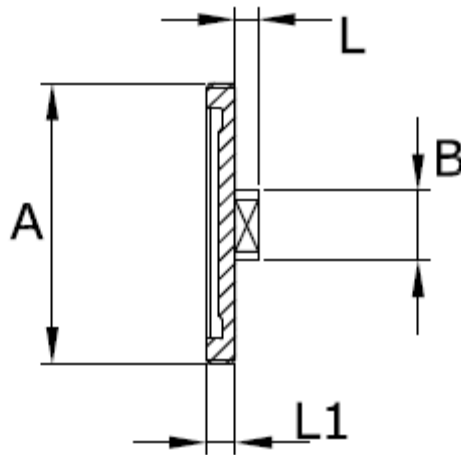
**DIN11864-1 "Form A " O Ring Union Seal,  
BS 4825 / ISO 2037 & ASME BPE 2002**



Size:	D1	D	Section	Part No: EPDM	Part No: Viton	Part No: PTFE
1/2"	12	19	3.5	A030-E013	A030-V013	A030-T013
3/4"	18	25	3.5	A030-E019	A030-V019	A030-T019
1"	24	31	3.5	A030-E026	A030-V026	A030-T026
1 1/2"	37	47	5	A030-E038	A030-V038	A030-T038
2"	50	60	5	A030-E051	A030-V051	A030-T051
2 1/2"	62	72	5	A030-E064	A030-V064	A030-T064
3"	75	85	5	A030-E076	A030-V076	A030-T076
4"	100	110	5	A030-E102	A030-V102	A030-T102

**Data Sheet**

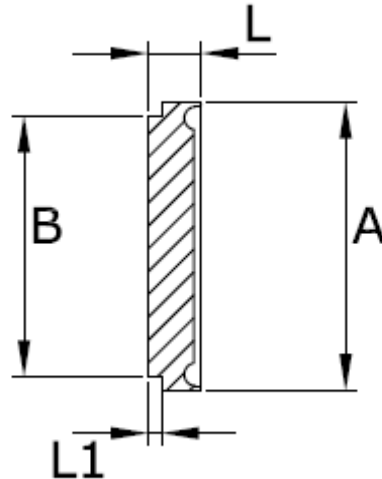
**DIN11864-1 "Form A " Male Blank, 316L SS**



Size:	A	B	L1	L	Part No:	Detail
1/2"	28 x 1/8"	22	12	10	A06D-A013	
3/4"	34 x 1/8"	25	12	10	A06D-A019	
1"	52 x 1/6"	34	14	10	A06D-A026	
1 1/2"	65 x 1/6"	34	14	10	A06D-A038	
2"	78 x 1/6"	34	14	10	A06D-A051	
2 1/2"	95 x 1/6"	34	16	10	A06D-A064	
3"	110 x 1/4"	34	20	10	A06D-A076	
4"	130 x 1/4"	34	20	10	A06D-A102	

**Data Sheet**

**DIN11864-1 "Form A" Blank Liner, 316L SS**



Size:	A	B	L	L1	Part No:	Detail
1/2"	21.9	18	9	3	A06C-A013	
3/4"	27.9	24	9	3	A06C-A019	
1"	42.9	35	12	3	A06C-A026	
1 1/2"	54.9	48	13	3	A06C-A038	
2"	66.9	61	14	3	A06C-A051	
2 1/2"	84.9	79	16	4	A06C-A064	
3"	98.9	93	16	4	A06C-A076	
4"	118.9	114	20	5	A06C-A102	