

**Data Sheet**

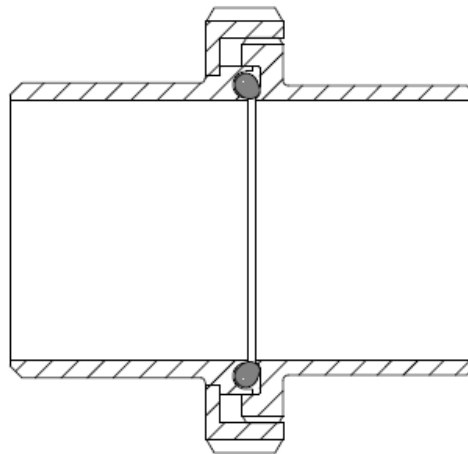
## DIN 11864-1 Aseptic Screwed Union for ISO 1127 Schedule Pipe

### 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: DN8 to DN80

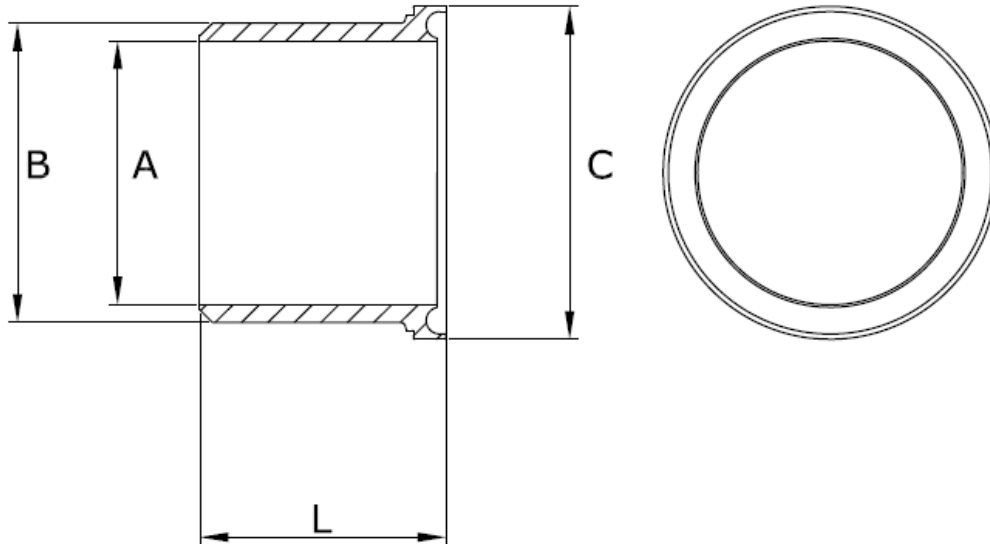
Materials: 316L SS

**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)

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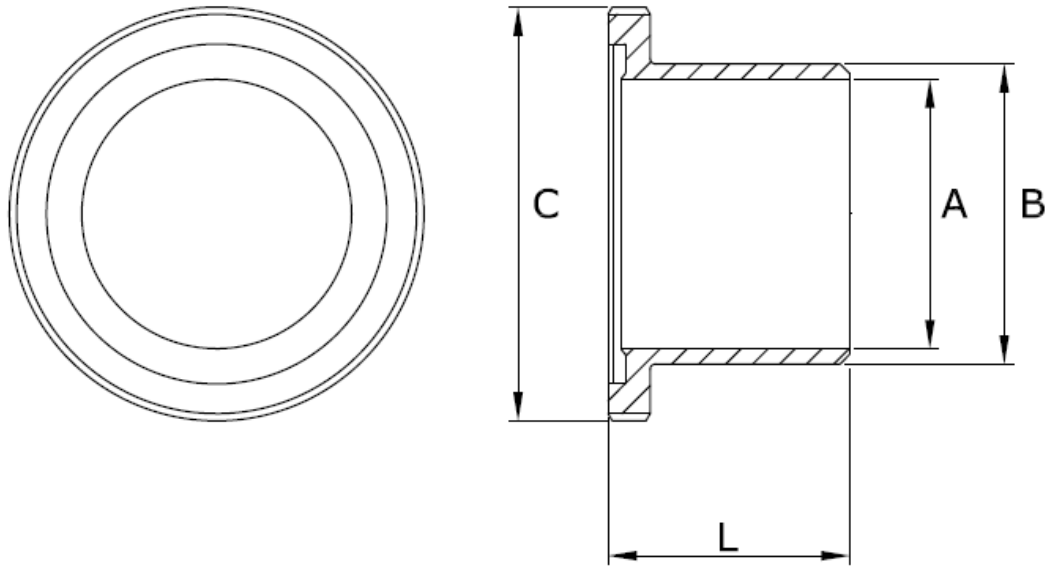
**DIN11864-1 "Form A" Weld Liner, 316L SS,  
ISO 1127**



Size:	A	B	C	L1 (Orbital Weld)	L2 (Manual Weld)	Detail
DN 8	10.3	13.5	21.9	39	17	A063-A0135
DN 10	14.0	17.2	27.9	39	17	A063-A0172
DN 15	18.1	21.3	35.9	40	18	A063-A0213
DN 20	23.7	26.9	42.9	41	22	A063-A0269
DN 25	29.7	33.7	48.9	47	25	A063-A0337
DN 32	38.4	42.4	54.9	47	26	A063-A0424
DN 40	44.3	48.3	66.9	48	30	A063-A0483
DN 50	56.3	60.3	84.9	62	34	A063-A0603
DN 65	72.1	76.1	98.9	61	38	A063-A0761
DN 80	84.3	88.9	118.9	68	46	A063-A0889

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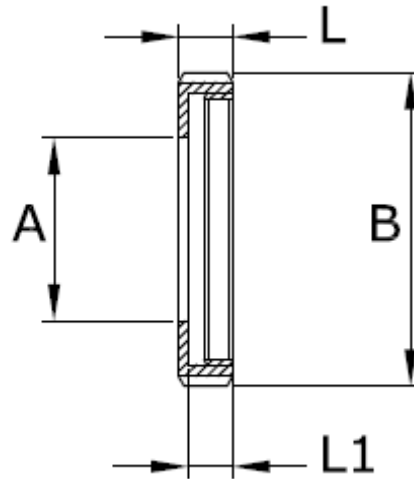
**DIN11864-1 "Form A" Weld Male, 316L SS.  
ISO 1127**



Size:	A	B	C	L1 (Orbital Weld)	L2 (Manual Weld)	Detail
DN 8	10.3	13.5	28 x 1/8"	41	19	A061-A0135
DN 10	14.0	17.2	34 x 1/8"	41	19	A061-A0172
DN 15	18.1	21.3	44 x 1/6"	43	21	A061-A0213
DN 20	23.7	26.9	52 x 1/6"	43	26	A061-A0269
DN 25	29.7	33.7	58 x 1/6"	48	30	A061-A0337
DN 32	38.4	42.4	65 x 1/6"	48	31	A061-A0424
DN 40	44.3	48.3	78 x 1/6"	49	31	A061-A0483
DN 50	56.3	60.3	95 x 1/6"	60	36	A061-A0603
DN 65	72.1	76.1	110 x 1/4"	64	42	A061-A0761
DN 80	84.3	88.9	130 x 1/4"	64	50	A061-A0889

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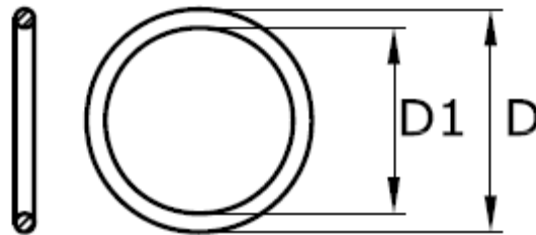
**DIN11864-1 "Form A " Slotted Nut 316L SS,  
ISO 1127**



Size:	A	B	Thread Detail	L	L1	Detail
DN 8	19	38	28 x 1/8"	18	15	A064-A010
DN 10	25	44	34 x 1/8"	18	15	A064-A015
DN 15	31	54	44 x 1/6"	20	17	A064-A020
DN 20	36	63	52 x 1/6"	21	18	A064-A025
DN 25	42	70	58 x 1/6"	21	18	A064-A032
DN 32	49	78	65 x 1/6"	21	18	A064-A040
DN 40	62	92	78 x 1/6"	22	19	A064-A050
DN 50	60	112	95 x 1/6"	25	21	A064-A065
DN 65	94	127	110 x 1/4"	29	25	A064-A080
DN 80	115	148	130 x 1/4"	31	26	A064-A100

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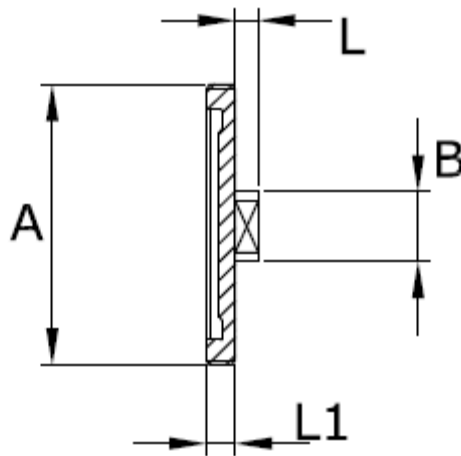
**DIN11864-1 "Form A " O Ring Union Seal,  
ISO 1127**



Size:	D1	D	Section	Part No: EPDM	Part No: Viton	Detail
DN 8	12.0	19.0	3.5	A030-E0135	A030-V0135	
DN 10	16.0	23.0	3.5	A030-E0172	A030-V0172	
DN 15	20.0	27.0	3.5	A030-E0213	A030-V0213	
DN 20	26.0	33.0	3.5	A030-E0269	A030-V0269	
DN 25	32.0	42.0	5	A030-E0337	A030-V0337	
DN 32	40.5	50.5	5	A030-E0424	A030-V0424	
DN 40	46.5	56.5	5	A030-E0463	A030-V0463	
DN 50	58.5	68.5	5	A030-E0603	A030-V0603	
DN 65	73.5	83.5	5	A030-E0761	A030-V0761	
DN 80	88.5	96.5	5	A030-E0889	A030-V0889	
DN 100	111.0	121.0	5	A030-E1143	A030-V1143	

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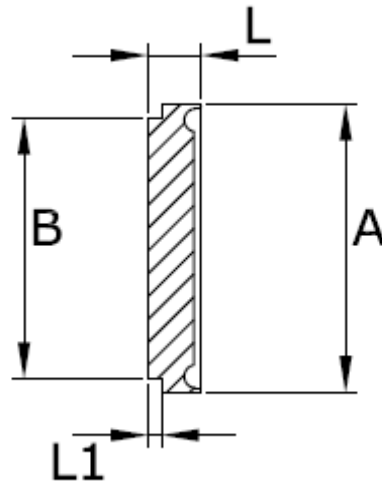
**DIN11864-1 "Form A " Male Blank, 316L SS  
ISO 1127**



Size:	A	B	L1	L	Part No:	Detail
DN 8	28 x 1/8"	25	12	10	A06D-A0135	
DN 10	34 x 1/8"	25	12	10	A06D-A0172	
DN 15	44 x 1/6"	25	14	10	A06D-A0213	
DN 20	52 x 1/6"	34	14	10	A06D-A0269	
DN 25	58 x 1/6"	34	14	10	A06D-A0337	
DN 32	65 x 1/6"	34	14	10	A06D-A0424	
DN 40	78 x 1/6"	34	14	10	A06D-A0483	
DN 50	95 x 1/6"	34	16	10	A06D-A0603	
DN 65	110 x 1/4"	34	20	10	A06D-A0761	
DN 80	130 x 1/4"	34	20	10	A06D-A0889	

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**DIN11864-1 "Form A " Weld Liner, 316L SS,  
ISO 1127**



Size:	A	B	L	L1	Part No:	Detail
DN 8	21.9	18	10	3	A06C-A0135	
DN 10	27.9	24	10	3	A06C-A0172	
DN 15	35.9	30	10	3	A06C-A0213	
DN 20	42.9	35	12	3	A06C-A0269	
DN 25	48.9	41	13	3	A06C-A0337	
DN 32	54.9	48	13	3	A06C-A0424	
DN 40	66.9	61	14	3	A06C-A0463	
DN 50	84.9	79	16	4	A06C-A0603	
DN 65	98.9	93	16	4	A06C-A0761	
DN 80	118.9	114	20	5	A06C-A0889	