

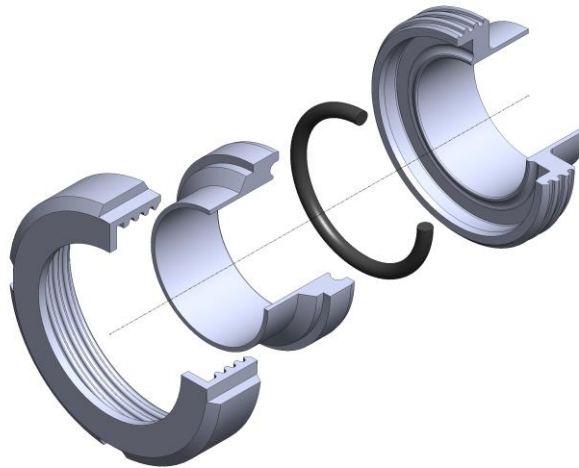
## DIN 11864-1/DIN 11853-1 Aseptic Screwed Union for ISO 1127 Schedule Pipe

### DIN 11864-1/DIN 11853-1 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: NS8 to NS80

Materials: 316L SS

#### Related standards:

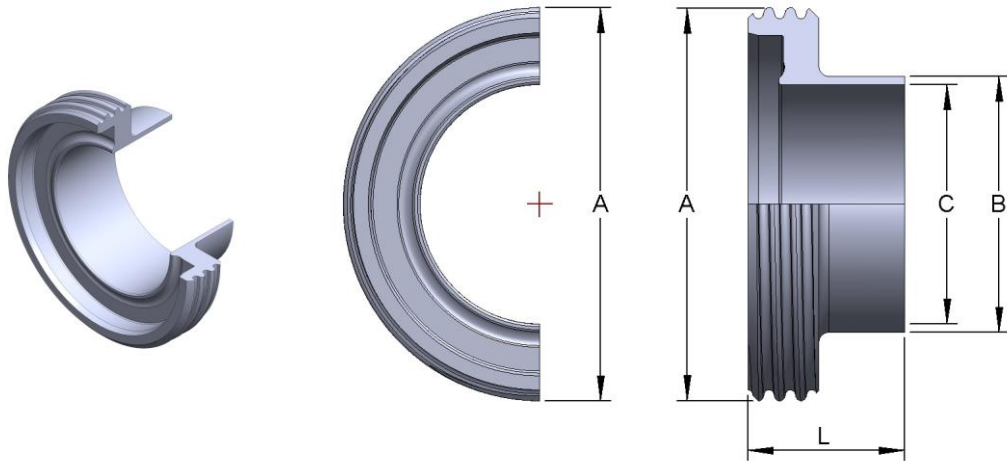
DIN 11864-1 Form A - Aseptic Screwed Union  
DIN 11864-2 Form A - Aseptic Flange Union  
DIN 11864-3 Form A - Aseptic Tri-Clamp Union  
DIN 11866 / 11850 / 11865  
ISO 1127  
ISO 2037 / BS 4825 / ASME BPE 2014  
DIN 11853 (Type 1 only)

Dimensions are provided in good faith but may be subject to change, if dimensions are critical please call the office to confirm all sizes before placing an order.

[DS Aseptic Screwed Union DIN 11864-1 ISO 1127 V 1.1](#)

Page No: 1

**DIN 11864-1/11853-1 "Form A" Weld Male  
316L SS - ISO 1127**



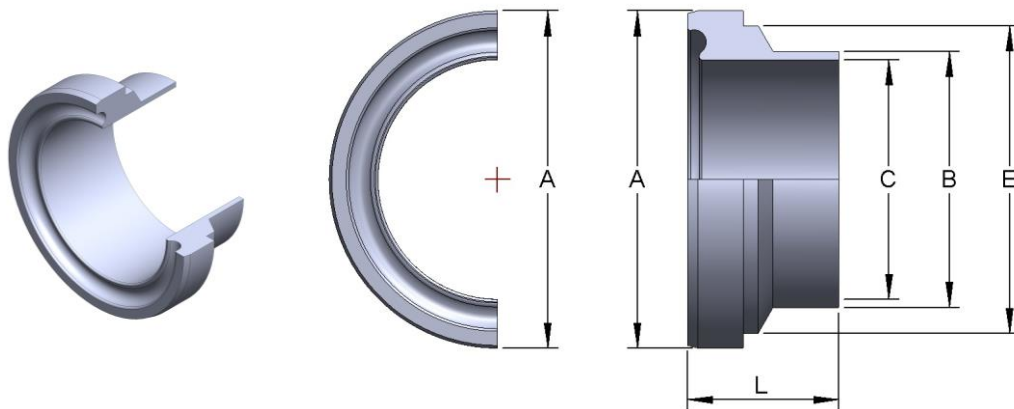
Size	A	B	C	L1 (Orbital Weld) DIN 11864-1	L2 (Manual Weld) DIN 11853-1	Part No DIN 11864-1	Part No DIN 11853-1
NS 8	28 x 1/8"	13.5	10.3	41	19	A061-A0135-64	A061-A0135-53
NS 10	34 x 1/8"	17.2	14	41	19	A061-A0172-64	A061-A0172-53
NS 15	44 x 1/6"	21.3	18.1	43	21	A061-A0213-64	A061-A0213-53
NS 20	52 x 1/6"	26.9	23.7	43	26	A061-A0269-64	A061-A0269-53
NS 25	58 x 1/6"	33.7	29.7	48	30	A061-A0337-64	A061-A0337-53
NS 32	65 x 1/6"	42.4	38.4	48	31	A061-A0424-64	A061-A0424-53
NS 40	78 x 1/6"	48.3	44.3	49	31	A061-A0483-64	A061-A0483-53
NS 50	95 x 1/6"	60.3	56.3	60	36	A061-A0603-64	A061-A0603-53
NS 65	110 x 1/4"	76.1	72.1	64	42	A061-A0761-64	A061-A0761-53
NS 80	130 x 1/4"	88.9	84.3	64	50	A061-A0889-64	A061-A0889-53

Dimensions are provided in good faith but may be subject to change, if dimensions are critical please call the office to confirm all sizes before placing an order.

[DS Aseptic Screwed Union DIN 11864-1 ISO 1127 V 1.1](#)

Page No: 2

**DIN 11864-1/11853-1 "Form A" Weld Liner  
316L SS - ISO 1127**



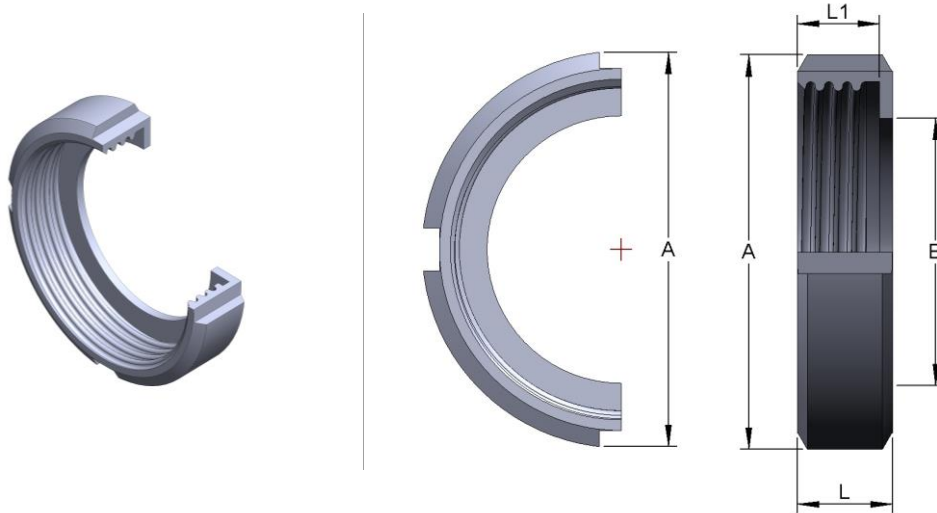
Size	A	B	C	L1 (Orbital Weld) DIN 11864-1	L2 (Manual Weld) DIN 11853-1	Part No DIN 11864-1	Part No DIN 11853-1
NS 8	21.9	13.5	10.3	39	17	A063-A0135-64	A063-A0135-53
NS 10	27.9	17.2	14	39	17	A063-A0172-64	A063-A0172-53
NS 15	35.9	21.3	18.1	40	18	A063-A0213-64	A063-A0213-53
NS 20	42.9	26.9	23.7	41	22	A063-A0269-64	A063-A0269-53
NS 25	48.9	33.7	29.7	47	25	A063-A0337-64	A063-A0337-53
NS 32	54.9	42.4	38.4	47	26	A063-A0424-64	A063-A0424-53
NS 40	66.9	48.3	44.3	48	30	A063-A0483-64	A063-A0483-53
NS 50	84.9	60.3	56.3	62	34	A063-A0603-64	A063-A0603-53
NS 65	98.9	76.1	72.1	61	38	A063-A0761-64	A063-A0761-53
NS 80	118.9	88.9	84.3	68	46	A063-A0889-64	A063-A0889-53

Dimensions are provided in good faith but may be subject to change, if dimensions are critical please call the office to confirm all sizes before placing an order.

[DS Aseptic Screwed Union DIN 11864-1 ISO 1127 V 1.1](#)

Page No: 3

**DIN 11864-1/11853-1 "Form A" Slotted Nut  
304 SS - ISO 1127**



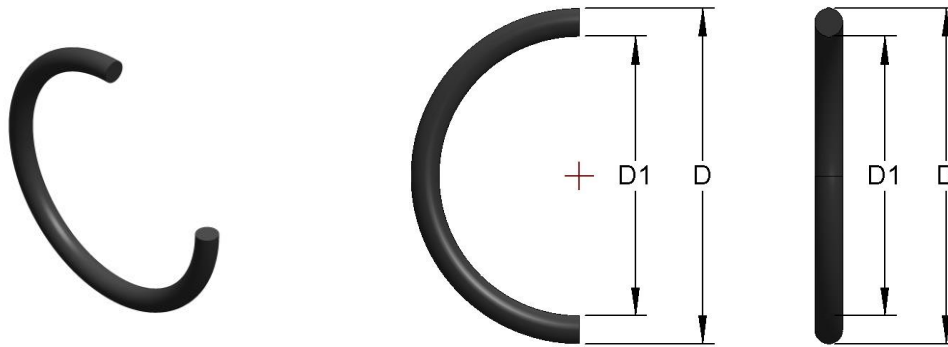
Size	A	B	Thread Detail	L	L1	Part No
NS 8	38	19	28 x 1/8"	18	15	<a href="#">A064-C0135</a>
NS 10	44	25	34 x 1/8"	18	15	<a href="#">A064-C0172</a>
NS 15	54	31	44 x 1/6"	20	17	<a href="#">A064-C0213</a>
NS 20	63	36	52 x 1/6"	21	18	<a href="#">A064-C0269</a>
NS 25	70	42	58 x 1/6"	21	18	<a href="#">A064-C0337</a>
NS 32	78	49	65 x 1/6"	21	18	<a href="#">A064-C0424</a>
NS 40	92	62	78 x 1/6"	22	19	<a href="#">A064-C0483</a>
NS 50	112	80	95 x 1/6"	25	21	<a href="#">A064-C0603</a>
NS 65	127	94	110 x 1/4"	29	25	<a href="#">A064-C0761</a>
NS 80	148	115	130 x 1/4"	31	26	<a href="#">A064-C0889</a>

Dimensions are provided in good faith but may be subject to change, if dimensions are critical please call the office to confirm all sizes before placing an order.

[DS Aseptic Screwed Union DIN 11864-1 ISO 1127 V 1.1](#)

Page No: 4

**DIN 11864/11853 "Form A" O Ring Union Seal -  
ISO 1127**



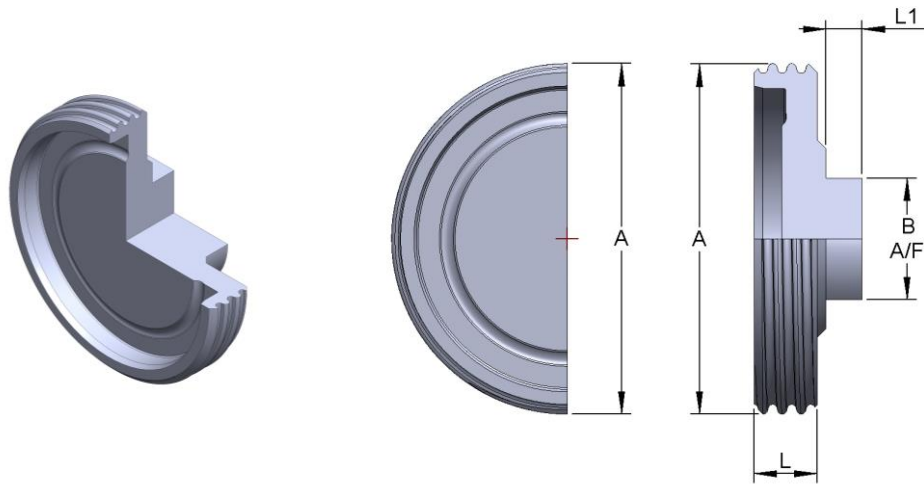
Size	D1	D	Section	Part No EPDM	Part No FKM
NS 8	12.0	19.0	3.5	A030-E0135	A030-V0135
NS 10	16.0	23.0	3.5	A030-E0172	A030-V0172
NS 15	20.0	27.0	3.5	A030-E0213	A030-V0213
NS 20	26.0	33.0	3.5	A030-E0269	A030-V0269
NS 25	32.0	42.0	5	A030-E0337	A030-V0337
NS 32	40.5	50.5	5	A030-E0424	A030-V0424
NS 40	46.5	56.5	5	A030-E0483	A030-V0483
NS 50	58.5	68.5	5	A030-E0603	A030-V0603
NS 65	73.5	83.5	5	A030-E0761	A030-V0761
NS 80	85.0	96.5	5	A030-E0889	A030-V0889
NS 100	111.0	121.0	5	A030-E1143	A030-V1143

Dimensions are provided in good faith but may be subject to change, if dimensions are critical please call the office to confirm all sizes before placing an order.

[DS Aseptic Screwed Union DIN 11864-1 ISO 1127 V 1.1](#)

Page No: 5

**DIN 11864-1/11853-1 "Form A" Male Blank  
316L SS - ISO 1127**



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

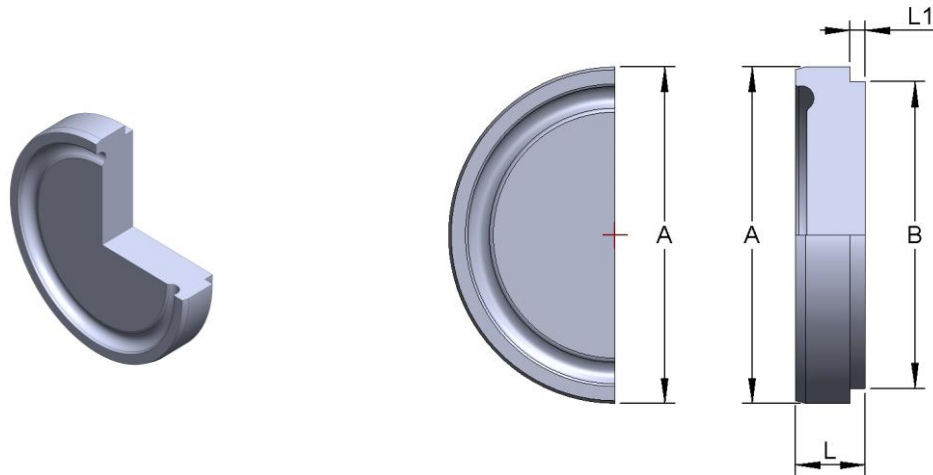
Dimensions are provided in good faith but may be subject to change, if dimensions are critical please call the office to confirm all sizes before placing an order.

[DS Aseptic Screwed Union DIN 11864-1 ISO 1127 V 1.1](#)

Page No: 6



**DIN 11864-1/11853-1 "Form A" Blank Liner  
316L SS - ISO 1127**



Size	A	B	L	L1	Part No
NS 8	21.9	18	10	3	A06C-A0135
NS 10	27.9	24	10	3	A06C-A0172
NS 15	35.9	30	10	3	A06C-A0213
NS 20	42.9	35	12	3	A06C-A0269
NS 25	48.9	41	13	3	A06C-A0337
NS 32	54.9	48	13	3	A06C-A0424
NS 40	66.9	61	14	3	A06C-A0483
NS 50	84.9	79	16	4	A06C-A0603
NS 65	98.9	93	16	4	A06C-A0761
NS 80	118.9	114	20	5	A06C-A0889

Dimensions are provided in good faith but may be subject to change, if dimensions are critical please call the office to confirm all sizes before placing an order.

[DS Aseptic Screwed Union DIN 11864-1 ISO 1127 V 1.1](#)

Page No: 7