

## IDF / ISS Hygienic Union – BS 4825 Part 4

This hygienic union has been widely used since its recommendation by the International Dairy Federation in 1960. This hexagonal screwed union is more commonly referred to as an IDF fitting and is suitable for use in fixed pipework where little dismantling is required. The wetted parts are supplied in 316 stainless steel and the nuts in 304 SS. The union has a crevice free construction where a T shaped seal fits flush with the tube's bore.

The fitting is now covered by the standards BS 4825 Part 4 and ISO 2853.

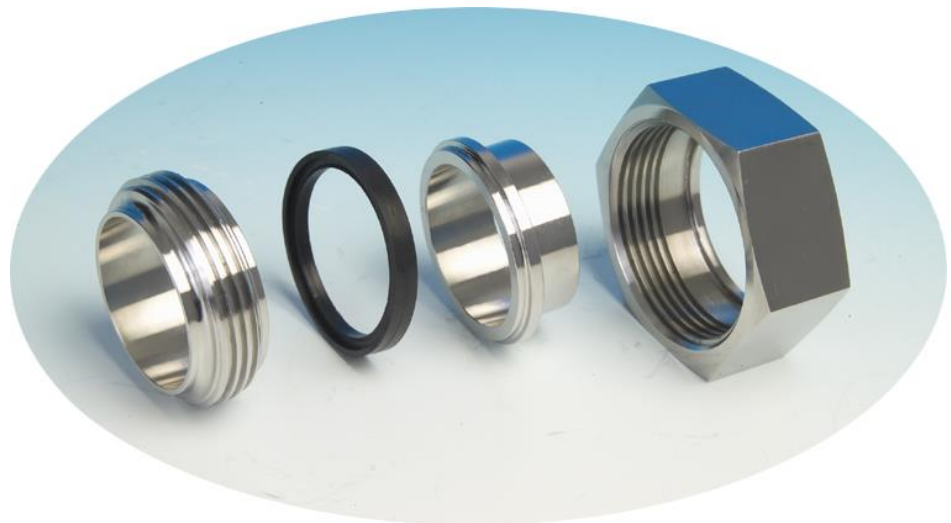
Designed to operate up to a maximum working pressure of 16 Bar (1.6 Mpa) at ambient temperature.

### Size range:

Imperial tube 1" to 4".

### Seal Materials:

Nitrile, EPDM & FKM.



### Accessories:

Conical Strainers

Blank Nuts and Chains

IDF Spanner

Pipe Clips and U Bolts

Fabricated Bends, Tees and Manifolds

Filters, Screens and Sampling Equipment

### Full range of Butterfly Valves, Ball Valves, Pressure Relief and Non-Return.

### Associated Standards:

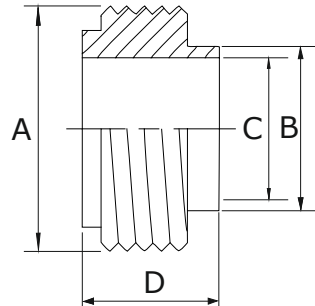
- BS 4825 Part 4 - IDF / ISS Hygienic Stainless Steel Couplings for Food Applications
- ISO 2853 - ISS / IDF Hygienic Stainless Steel Couplings for Food Applications
- BS 4825 Part 1 - Stainless Steel Tube for Food Industry Applications
- BS 4825 Part 2 - Stainless Steel Bends and Tees for the Food Industry
- ASTM A270 - Stainless Steel Tube for Sanitary, Dairy and Food Ind.
- ASTM A269 - Stainless Steel Tubes for General Duties
- DIN 11852 - Hygienic Fittings, Metric
- DIN 11850 - Hygienic Tube, Metric
- DIN 11864 - Aseptic Fittings, Flange, Clamp & Union
- DIN 11866 - Pharmaceutical Tube, Metric
- ASME BPE - Pharmaceutical Tube, Imperial
- ISO 2037 - Stainless Steel Tubes for the Food Industry
- ISO 1127 - Stainless Steel Tubes
- ISO 2851 - Stainless Steel Bends and Tees for the Food Industry
- SMS 3008 - Stainless Steel Tubes
- SMS 3017 - Stainless Steel Tubes

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 IDF V1.4](#)

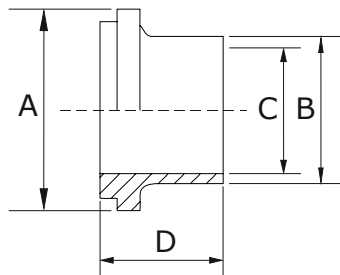
Page No: 1

### IDF Weld Male



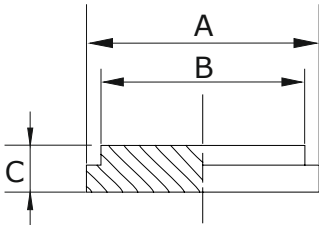
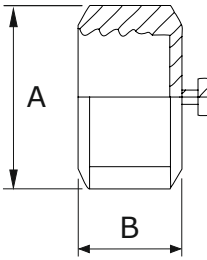
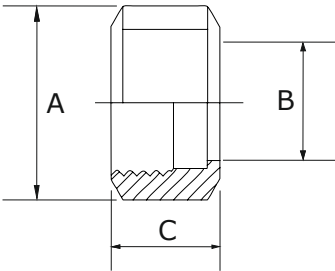
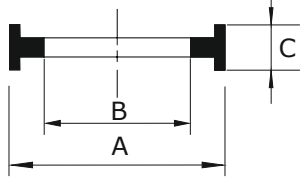
Size	A	B	C	D	Part No 316L	Part No 316
1"	37.0	25.4	22.2	21.5	4061-A026	4061-B026
1.½"	50.5	38.1	34.9	21.5	4061-A038	4061-B038
2"	64.0	50.8	47.6	21.5	4061-A051	4061-B051
2.½"	77.5	63.5	60.3	21.5	4061-A064	4061-B064
3"	91.0	76.2	73.0	21.5	4061-A076	4061-B076
4"	125.7	101.6	97.6	30.0	4061-A102-BS	4061-B102-BS
4" ISO 2853	118.2	101.6	97.6	30.0	4061-A102-ISO	4061-B102-ISO

### IDF Weld Liner Machined



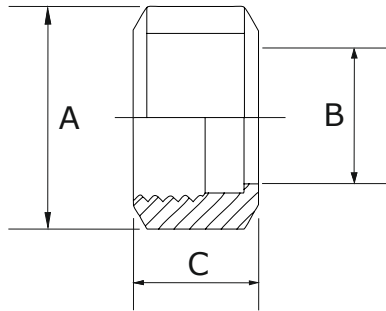
Size	A	B	C	D	Part No 316L	Part No 316
1"	33.8	25.4	22.2	21.5	4063-A026	4063-B026
1.½"	47.0	38.1	34.9	21.5	4063-A038	4063-B038
2"	60.5	50.8	47.6	21.5	4063-A051	4063-B051
2.½"	74.0	63.5	60.3	21.5	4063-A064	4063-B064
3"	87.5	76.2	73.0	21.5	4063-A076	4063-B076
4"	120.6	101.6	97.6	30.0	4063-A102-BS	4063-B102-BS
4" ISO 2853	114.0	101.6	97.6	30.0	4063-A102-ISO	4063-B102-ISO

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.

IDF Liner Blank - 316							
	Size	A	B	C	Part No		
	1"	33.8	29.2	7.0	4066-B026		
	1.½"	47.0	42.7	7.0	4066-B038		
	2"	60.5	56.2	7.0	4066-B051		
	2.½"	74.0	69.9	7.0	4066-B064		
	3"	87.5	82.6	7.0	4066-B076		
	4"	120.6	111.1	7.0	4066-B102*		
*Please note that there are 2 standards for the 4" Liner.							
IDF Blank Nut & Chain - 304							
	Size	A	B	Part No			
	1"	46	30	4069-C026			
	1.½"	60	30	4069-C038			
	2"	75	30	4069-C051			
	2.½"	90	30	4069-C064			
	3"	105	30	4069-C076			
	4"	133	35	4069-C102*			
*Please note that there are 2 standards for the 4" Nuts.							
IDF Nut (Hexagon) - 304							
	Size	A	B	C	Part No		
	1"	46	30.5	30	4065-C026		
	1.½"	60	43.5	30	4065-C038		
	2"	75	57.0	30	4065-C051		
	2.½"	90	70.7	30	4065-C064		
	3"	105	83.3	30	4065-C076		
	4"	133	112.0	35	4065-C102*		
*Please note that there are 2 standards for the 4" Nuts.							
IDF Seals Type A profile							
	Colour			Black	Black	Black	
	Size	A	B	C	Part No (Nitrile)	Part No (FKM)	Part No (EPDM)
	1"	32.5	23.2	7.0	4031-N026	4031-V026	4031-E026
	1.½"	46.0	35.9	7.0	4031-N038	4031-V038	4031-E038
	2"	59.5	48.6	7.0	4031-N051	4031-V051	4031-E051
	2.½"	73.2	61.3	7.0	4031-N064	4031-V064	4031-E064
	3"	86.5	74.0	7.0	4031-N076	4031-V076	4031-E076
	4"	119.0	98.6	9.6	4031-N102*	4031-V102*	4031-E102*
Other material available: 1. 4030-T - PTFE Type B profile (white). *Two sizes are available at 4". Please confirm at time of enquiry.							

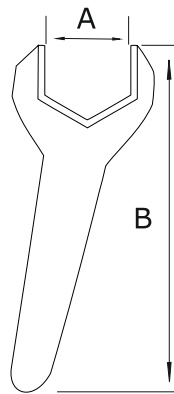
Dimensions are provided in good faith but may be subject to change; if dimensions are critical please call the office to confirm all sizes before placing an order.

### IDF Round Slotted Nut - 304



Size	A	B	C	Part No
1"	44.5	30.5	30.0	<a href="#">4064-C026</a>
1.½"	57.2	43.5	30.0	<a href="#">4064-C038</a>
2"	70.0	57.0	30.0	<a href="#">4064-C051</a>
2.½"	86.0	70.7	30.0	<a href="#">4064-C064</a>
3"	102.0	83.3	30.0	<a href="#">4064-C076</a>

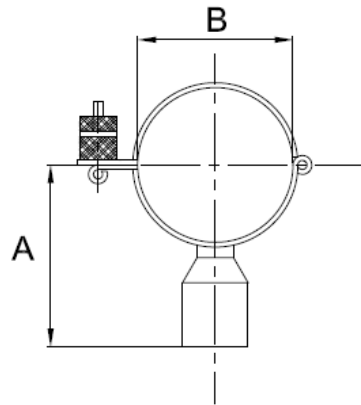
### IDF Spanner Aluminium



Size	A	B (A/F)	C	Part No
1"	46	280		<a href="#">410P-1026</a>
1.½"	60	280		<a href="#">410P-1038</a>
2"	75	300		<a href="#">410P-1051</a>
2.½"	90	350		<a href="#">410P-1064</a>
3"	105	430		<a href="#">410P-1076</a>
4"	133	440		<a href="#">410P-1102</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.

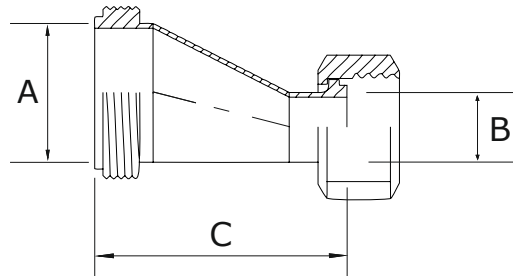
### IDF Hinged Pipe Clip - 1/2" BSP Boss



Size	A	B	C	Part No
1/2"	35	13		010Q-C013
3/4"	38	20		010Q-C019
1"	41	26		010Q-C026
1.1/2"	47	38		010Q-C038
2"	54	51		010Q-C051
2.1/2"	60	64		010Q-C064
3"	66	76		010Q-C076
4"	79	102		010Q-C102

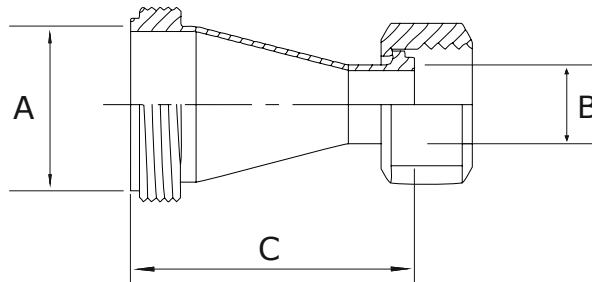
Dimensions are provided in good faith but may be subject to change; if dimensions are critical please call the office to confirm all sizes before placing an order.

### IDF Eccentric Reducer M/F - 316



Size	A	B	C	Part No
1.½"-1"	38.1	25.4		4054-B038-026
2"-1"	50.8	25.4		4054-B051-026
2"-1.½"	50.8	38.1		4054-B051-038
2.½"-1.½"	63.5	38.1		4054-B064-038
2.½"-2"	63.5	50.8		4054-B064-051
3"-1.½"	76.2	38.1		4054-B076-038
3"-2"	76.2	50.8		4054-B076-051
3"-2.½"	76.2	63.5		4054-B076-064

### IDF Concentric Reducer M/F - 316

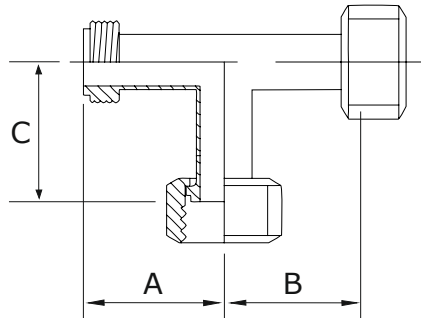


Size	A	B	C	Part No
1.½"-1"	38.1	25.4		4051-B038-026
2"-1"	50.8	25.4		4051-B051-026
2"-1.½"	50.8	38.1		4051-B051-038
2.½"-1.½"	63.5	38.1		4051-B064-038
2.½"-2"	63.5	50.8		4051-B064-051
3"-1.½"	76.2	38.1		4051-B076-038
3"-2"	76.2	50.8		4051-B076-051
3"-2.½"	76.2	63.5		4051-B076-064

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.



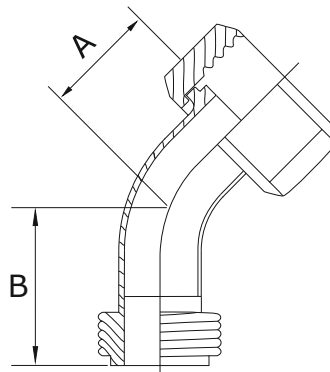
### IDF Equal Tee – MFF branch – 316L



Size	A	B	C	Part No
1"	65	65	65	404P-B026-MFF
1.½"	85	85	85	404P-B038-MFF
2"	110	110	110	404P-B051-MFF
2.½"	135	135	135	404P-B064-MFF
3"	155	155	155	404P-B076-MFF
4"	195	195	195	404P-B102-MFF

**\*Note: Available in Variations, Please state which IDF End connectors you require either Male or Female.**

### IDF 45° Bend - M/F - 316

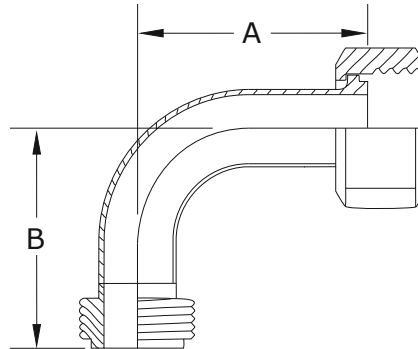


Size	A	B	Part No
1"	51	51	4046-B026
1.½"	58	58	4046-B038
2"	67	67	4046-B051
2.½"	73	73	4046-B064
3"	83	83	4046-B076
4"	135	135	4046-B102

**\*Note: Available in Variations, Please state which IDF End connectors you require either Male or Female.**

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.

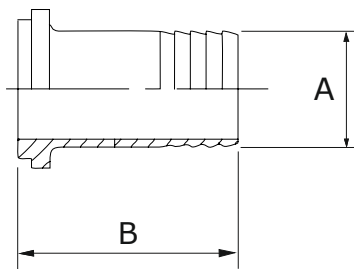
### IDF 90° Bend - M/F - 316



Size	A	B	Part No
1"	65	65	4040-B026
1.½"	85	85	4040-B038
2"	110	110	4040-B051
2.½"	135	135	4040-B064
3"	155	155	4040-B076
4"	204	204	4040-B102

\*Note: Available in Variations, Please state which IDF End connectors you require either Male or Female.

### IDF Female Hoseliner - 316



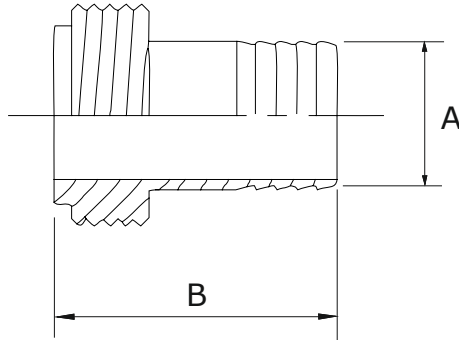
Size	A	B	Part No
1"	25.4	101.5	406K-B026
1.½"	38.1	106.5	406K-B038
2"	50.8	106.5	406K-B051
2.½"	63.5	116.5	406K-B064
3"	76.2	121.5	406K-B076
4"	101.6	150.0	406K-B102

\*Note: This is a Non stock item and would usually be made to order. Please double check the length if this is a critical dimension.

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.



### IDF Male Hosetail - 316



Size	A	B	Part No
1"	25.4	101.5	406L-B026
1.½"	38.1	106.5	406L-B038
2"	50.8	106.5	406L-B051
2.½"	63.5	116.5	406L-B064
3"	76.2	121.5	406L-B076
4"	101.6	150.0	406L-B102

**\*Note: This is a Non stock item and would usually be made to order. Please double check the length if this is a critical dimension.**

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.