

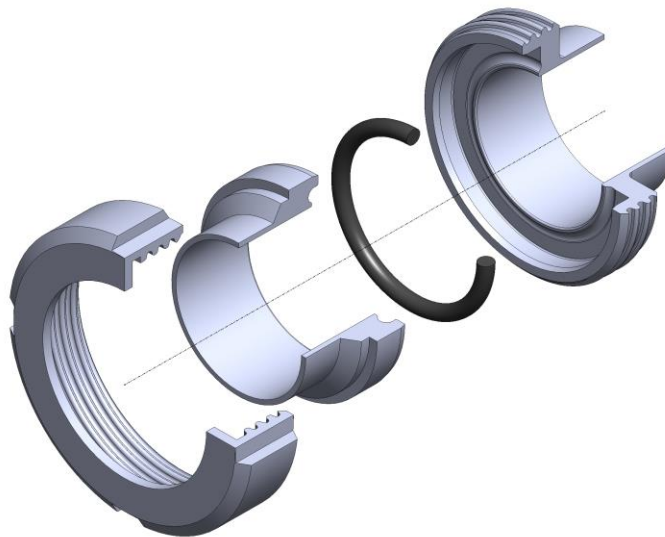
DIN 11864-1/DIN 11853-1 Aseptic Unions for BS 4825/ISO 2037/ASME BPE 2002

DIN 11864-1 / DIN 11853-1 Aseptic Screwed Unions

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:

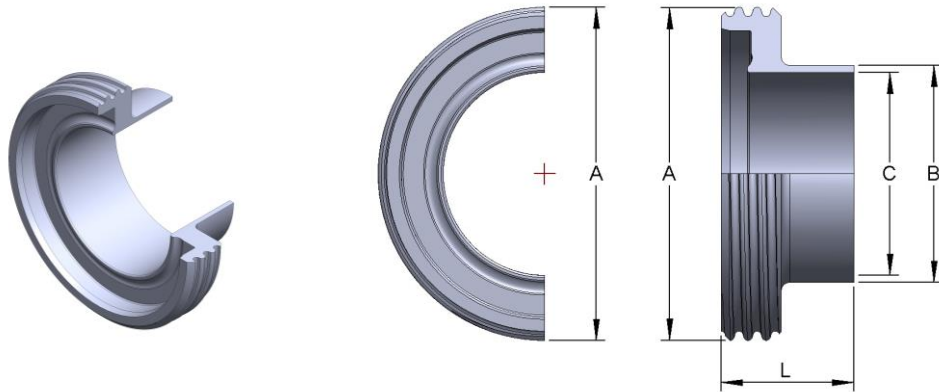
DIN 11864-1 Form A - Aseptic Screwed Union
DIN 11864-2 Form A - Aseptic Flange Union
DIN 11864-3 Form A - Aseptic Tri-Clamp Union
DIN 11866 / 11850 / 11865
ISO 1127
ISO 2037 / BS 4825 /ASME BPE 2014
DIN 11853 (Type 1 only)

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 ASME BPE-BS 4825-ISO 1127 V 1.5](#)

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**DIN 11864-1/11853-1 "Form A" Weld Male - 316L SS
BS4825/ISO 2037/ASME BPE 2002**



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
1/2"	28 x 1/8"	12.7	9.4	41.0	19.0	A061-A013-64	A061-A013-53
3/4"	34 x 1/8"	19.1	15.8	41.0	19.0	A061-A019-64	A061-A019-53
1"	52 x 1/6"	25.4	22.1	43.0	26.0	A061-A026-64	A061-A026-53
1 1/2"	65 x 1/6"	38.1	34.8	48.5	31.0	A061-A038-64	A061-A038-53
2"	78 x 1/6"	50.8	47.5	48.5	31.0	A061-A051-64	A061-A051-53
2 1/2"	95 x 1/6"	63.5	60.2	60.0	36.0	A061-A064-64	A061-A064-53
3"	110 x 1/4"	76.2	72.9	64.0	42.0	A061-A076-64	A061-A076-53
4"	130 x 1/4"	101.6	97.4	64.0	50.0	A061-A102-64	A061-A102-53
5"	160 x 1/4"	127.6	123.4	68.0	-	A061-A127-64	-
6"	190 x 1/4"	152.4	146.9	75.0	-	A061-A152-64	-

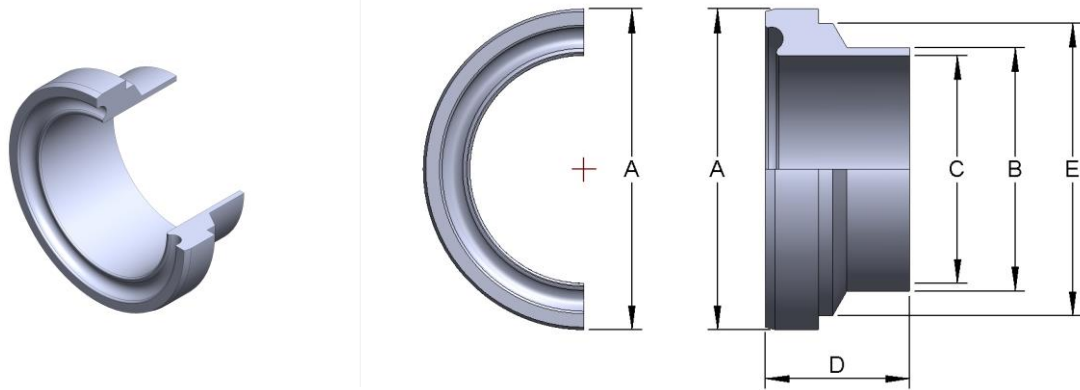
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DS Aseptic Screwed Union DIN 11864-1 ASME BPE-BS 4825-ISO 1127 V 1.5

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**DIN 11864-1/11853-1 "Form A" Weld Liner - 316L SS
BS 4825/ISO 2037/ASME BPE 2002**



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
1/2"	21.0	12.7	9.4	39.0	17.0	A063-A013-64	A063-A013-53
3/4"	27.9	19.1	15.8	39.0	17.0	A063-A019-64	A063-A019-53
1"	42.9	25.4	22.1	40.0	22.0	A063-A026-64	A063-A026-53
1 1/2"	54.9	38.1	34.8	46.5	26.0	A063-A038-64	A063-A038-53
2"	66.9	50.8	47.5	47.5	30.0	A063-A051-64	A063-A051-53
2 1/2"	84.9	63.5	60.2	63.0	34.0	A063-A064-64	A063-A064-53
3"	98.9	76.2	72.9	61.0	38.0	A063-A076-64	A063-A076-53
4"	118.9	101.6	97.4	65.0	46.0	A063-A102-64	A063-A102-53
5"		127.6	123.4	63.0	-	A063-A127-64	-
6"		152.4	146.9	67.0	-	A063-A152-64	-

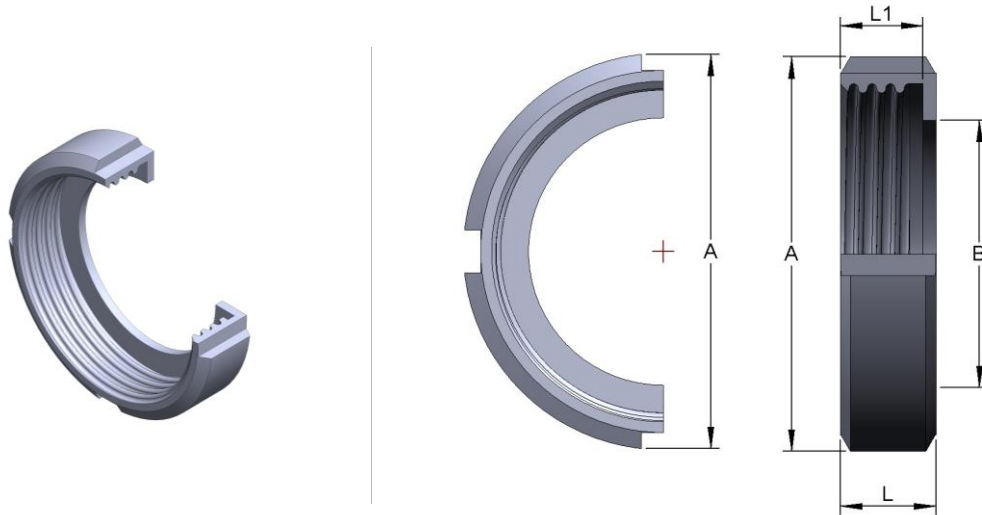
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[DS Aseptic Screwed Union DIN 11864-1 ASME BPE-BS 4825-ISO 1127 V 1.5](#)

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



Size	A	B	Thread Detail	L	L1	Part No
1/2"	38	19	28 x 1/8"	18	15	A064-C013
3/4"	44	25	34 x 1/8"	18	15	A064-C019
1"	63	36	52 x 1/6"	21	18	A064-C026
1 1/2"	78	49	65 x 1/6"	21	18	A064-C038
2"	92	62	78 x 1/6"	22	19	A064-C051
2 1/2"	112	80	95 x 1/6"	25	21	A064-C064
3"	127	94	110 x 1/4"	29	25	A064-C076
4"	148	115	130 x 1/4"	31	26	A064-C102
5"	178	138	160 x 1/4"	35	30	A064-C127
6"	210	164	190 x 1/4"	40	34	A064-C152

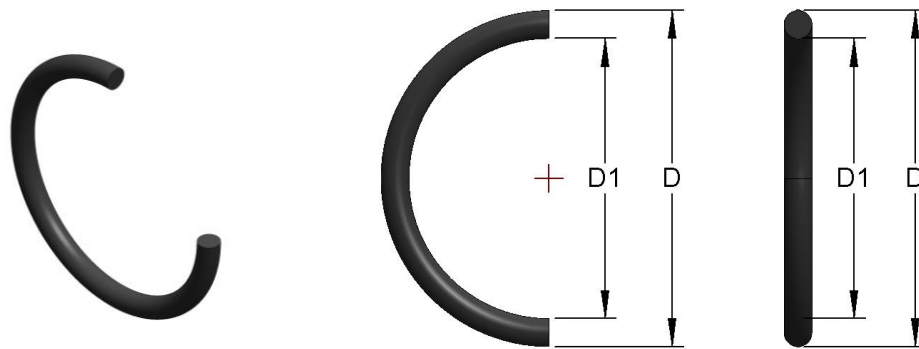
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DS Aseptic Screwed Union DIN 11864-1 ASME BPE-BS 4825-ISO 1127 V 1.5

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**DIN 11864-1/11853-1 "Form A" O Ring Union Seal
BS 4825/ISO 2037/ASME BPE 2002**



Size	D1	D	Section	Part No EPDM	Part No FKM	Part No PTFE
½"	12	19	3.5	A030-E013	A030-V013	A030-T013
¾"	18	25	3.5	A030-E019	A030-V019	A030-T019
1"	24	31	3.5	A030-E026	A030-V026	A030-T026
1½"	37	47	5	A030-E038	A030-V038	A030-T038
2"	50	60	5	A030-E051	A030-V051	A030-T051
2½"	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
5"	-	-	5	A030-E127	A030-V127	A030-T127
6"	-	-	5	A030-E152	A030-V152	A030-T152

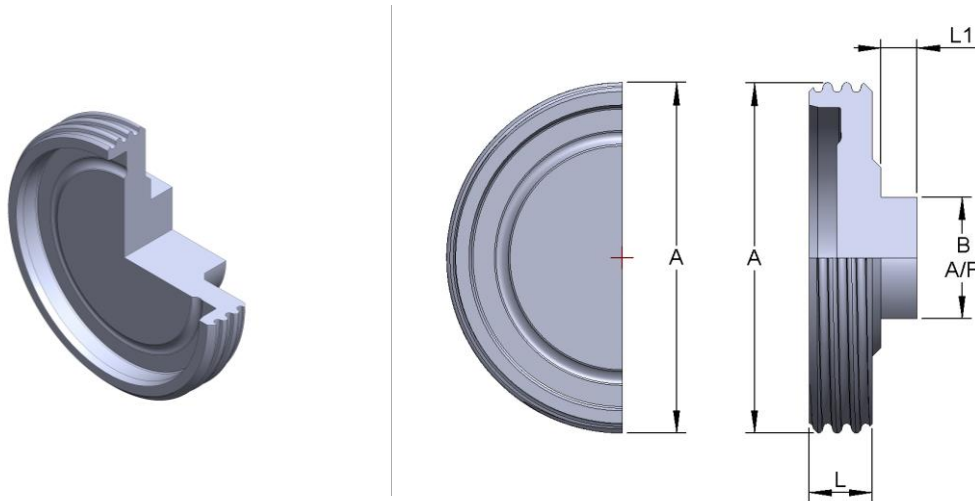
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DS Aseptic Screwed Union DIN 11864-1 ASME BPE-BS 4825-ISO 1127 V 1.5

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



Size	A	B	L	L1	Part No
1/2"	28 x 1/8"	34	12	10	A06D-A013
3/4"	34 x 1/8"	34	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
5"	160 x 1/4"	-	-	-	A06D-A127
6"	190 x 1/4"	-	-	-	A06D-A152

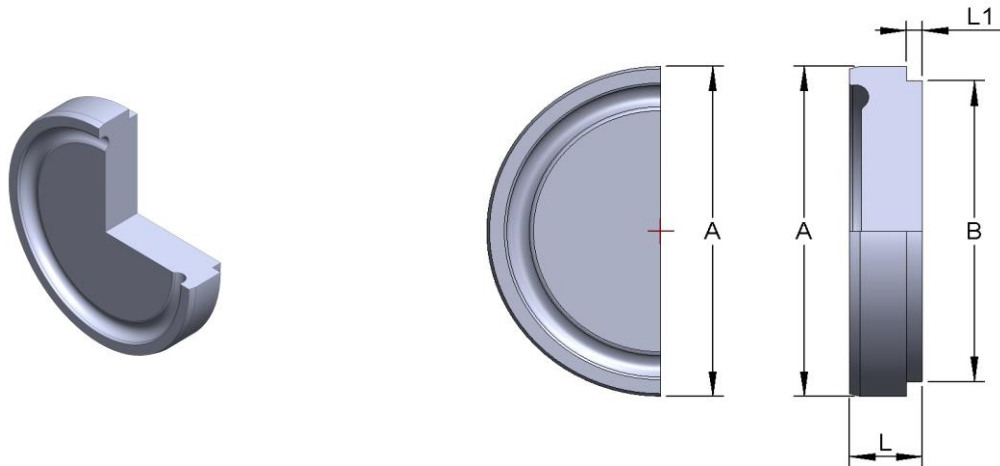
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DIN 11864-1/11853-1 "Form A" Blank Liner - 316L SS



Size	A	B	L	L1	Part No
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
5"	-	-	-	-	A06C-A127
6"	-	-	-	-	A06C-A152

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