

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 2037

PIPES AND FITTINGS

STAINLESS STEEL TUBES

FOR THE FOOD INDUSTRY

1st EDITION

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BRIEF HISTORY

The ISO Recommendation R 2037, *Pipes and fittings – Stainless steel tubes for the food industry*, was drawn up by Technical Committee ISO/TC 5, *Metal pipes and fittings*, the Secretariat of which is held by the Association Suisse de Normalisation (SNV).

Work on this question led to the adoption of Draft ISO Recommendation No. 2037, which was circulated to all the ISO Member Bodies for enquiry in July 1970. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	Hungary	South Africa, Rep. of
Austria	India	Sweden
Belgium	Israel	Switzerland
Canada	Italy	Thailand
Czechoslovakia	Korea, Rep. of	U.A.R.
Denmark	Netherlands	United Kingdom
France	Norway	U.S.S.R.
Germany	Poland	
Greece	Romania	

No Member Body opposed the approval of the Draft.

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided to accept it as an ISO RECOMMENDATION.

PIPES AND FITTINGS

STAINLESS STEEL TUBES FOR THE FOOD INDUSTRY

1. SCOPE

This ISO Recommendation specifies the dimensions, tolerances, surface roughness, materials and hygienic requirements for seamless or welded stainless steel tubes in straight lengths for the food industry.

2. BASIS OF SPECIFICATIONS

The dimensions of the tubes and the tolerances D_3 , D_4 and T_3 are selected from ISO Recommendation R 1127, *Stainless steel tubes – Dimensions, tolerances and masses per unit length*, with the exception of the dimension 51 × 1, the surface roughness from ISO Recommendation R 468, *Surface roughness*, and the materials from ISO Recommendation R . . . * for stainless steels.

3. DIMENSIONS

The dimensions should be selected from the following table :

Outside tube diameter				Wall thickness			
preferred series		complementary dimensions**		for welding and general purpose		preferably for expanding purpose	
mm	in	mm	in	mm	in	mm	in
12				1	0.040		
18				1	0.040		
22				1	0.040		
25		25.4	1.000	1.2	0.048	1	0.040
28				1.2	0.048	1	0.040
33.7		35	1.378	1.2	0.048	1	0.040
38	1.500			1.2	0.048	1	0.040
40				1.2	0.048	1	0.040
51	2.000			1.2	0.048	1	0.040
63.5	2.500			1.6	0.064		
70	2.750			1.6	0.064		
76.1	3.000			1.6	0.064		
88.9	3.500			2	0.080		
101.6	4.000			2	0.080		
114.3	4.500			2	0.080		
139.7	5.500			2	0.080		
168.3	6.625			2.6	0.104		
219.1	8.625			2.6	0.104		
273	10.750			2.6	0.104		
323.9	12.750			2.6	0.104		
355.6	14.000			2.6	0.104		
406.4	16.000			3.2	0.128		

* At present at the stage of draft proposal.

** Complementary dimensions are intended to facilitate the maintenance of existing plants and are not recommended for use in the future.