

## ASEPTIC PROGRAM



### Sleeve for orbital welding similar to DIN 2986

#### Dimensions:

DIN 11866-A (DIN 11850)  
DIN 11866-B (EN ISO 1127)  
DIN 11866-C (ASME BPE)

#### Marking:

dimension, material, heat number

#### Tolerance:

ISO 2768-1

#### Material:

AISI 316L

#### Certificate (on demand):

EN 10204 3.1  
EN 10204 3.1 AD-W2 (for selected items)

#### Standard surface („MB“):

inside: Ra ≤ 0,8 μm  
outside: Ra ≤ 1,6 μm

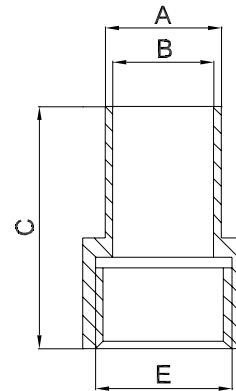
#### Inner surface variants:

electrochemical polished  
Ra ≤ 0,6 μm (STERI-line®)  
Ra ≤ 0,5 μm (STERI-line®)  
Ra ≤ 0,4 μm (HQ-line®)  
Ra ≤ 0,25 μm (HQ-line®)

DIN	pipe	A	B	C	E
DN 10	12,0 x 1,0	12,0	10,0	40,0	1/8"
DN 10	13,0 x 1,5	13,0	10,0	40,0	3/8"
DN 15	19,0 x 1,5	19,0	16,0	40,0	1/4"
DN 15	19,0 x 1,5	19,0	16,0	40,0	1/2"
DN 20	23,0 x 1,5	23,0	20,0	45,0	3/4"
DN 25	29,0 x 1,5	29,0	26,0	50,0	3/4"
DN 25	29,0 x 1,5	29,0	26,0	50,0	1"
DN 32	35,0 x 1,5	35,0	32,0	58,0	1 1/4"
DN 40	41,0 x 1,5	41,0	38,0	55,0	1 1/2"
DN 50	53,0 x 1,5	53,0	50,0	58,0	2"
DN 65	70,0 x 2,0	70,0	66,0	58,0	2 1/2"
DN 80	85,0 x 2,0	85,0	81,0	58,0	3"
DN 100	104,0 x 2,0	104,0	100,0	58,0	4"

ISO	pipe	A	B	C	E
DN 8	13,5 x 1,6	13,5	10,3	40,0	1/4"
DN 10	17,2 x 1,6	17,2	14,0	40,0	3/8"
DN 15	21,3 x 1,6	21,3	18,1	40,0	1/2"
DN 20	26,9 x 1,6	26,9	23,7	45,0	3/4"
DN 25	33,7 x 2,0	33,7	29,7	50,0	1"
DN 32	42,4 x 2,0	42,4	38,4	58,0	1 1/4"
DN 40	48,3 x 2,0	48,3	44,3	55,0	1 1/4"
DN 40	48,3 x 2,0	48,3	44,3	55,0	1 1/2"
DN 50	60,3 x 2,0	60,3	56,3	58,0	2"
DN 65	76,1 x 2,0	76,1	72,1	58,0	2 1/2"
DN 80	88,9 x 2,3	88,9	84,3	58,0	3"
DN 100	114,3 x 2,3	114,3	109,7	58,0	4"

\*) non-standard



ASME BPE	pipe	A	B	C	E
DN 1/2"	12,7 x 1,65	12,7	9,4	40,0	1/4"
DN 3/4"	19,05 x 1,65	19,05	15,75	40,0	1/2"
DN 1"	25,4 x 1,65	25,4	22,1	45,0	3/4"
DN 1 1/2"	38,1 x 1,65	38,1	34,8	55,0	1 1/2"
DN 2"	50,8 x 1,65	50,8	47,5	58,0	2"
DN 2 1/2"	63,5 x 1,65	63,5	60,2	58,0	2 1/2"
DN 3"	76,2 x 1,65	76,2	72,9	58,0	3"
DN 4"	101,6 x 2,11	101,6	97,38	58,0	4"