



SLOVENSKI STANDARD

SIST EN 13957:2004

01-junij-2004

Aluminium and aluminium alloys - Extruded round, coiled tube for general applications - Specification

Aluminium and aluminium alloys - Extruded round, coiled tube for general applications - Specification

Aluminium und Aluminiumlegierungen - Stranggepresste Rundrohre in Ringen für allgemeine Anwendungen - Spezifikation

Aluminium et alliages d'aluminium - Tubes ronds filés, fournis en couronnes pour applications générales - Spécification

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77.150.10 Alumijski izdelki Aluminium products

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 13957

August 2003

ICS 77.150.10

English version

Aluminium and aluminium alloys - Extruded round, coiled tube for general applications - Specification

Aluminium et alliages d'aluminium - Tubes ronds filés,
fournis en couronnes, pour applications générales -
Spécifications

Aluminium und Aluminiumlegierungen - Stranggepresste
Rundrohre in Ringen für allgemeine Anwendungen -
Spezifikation

This European Standard was approved by CEN on 2 July 2003.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: rue de Stassart, 36 B-1050 Brussels

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Foreword

This document (EN 13957:2003) has been prepared by Technical Committee CEN/TC 132, "Aluminium and aluminium alloys", the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by February 2004, and conflicting national standards shall be withdrawn at the latest by February 2004.

Within its programme of work, Technical Committee CEN/TC 132 entrusted CEN/TC 132/WG 5 "Extruded and drawn products" to prepare the following standard:

- EN 13957 , *Aluminium and aluminium alloys – Extruded round coiled tube for general applications – Specification.*

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and the United Kingdom.

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EN 13957:2003 (E)**1 Scope**

This standard specifies the technical conditions for inspection and delivery, mechanical properties and tolerances on dimensions and form for aluminium and aluminium alloy extruded round, coiled tubes for general applications with outside or inside diameters in the range from 5 mm up to and including 30 mm.

Depending on the final application of the product, additional or stricter requirements can apply, after agreement between supplier and purchaser.

NOTE Some of the products listed in the present standard can be subject to patent or patent applications, and their listing herein is not to be construed in any way as the granting of a licence under such patent right.

CEN/TC 132 affirms it is its policy that in the case when a patentee refuses to grant licences on standardised standard products under reasonable and not discriminatory conditions then this product shall be removed from the corresponding standard.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 755-1:1997, *Aluminium and aluminium alloys – Extruded rod/bar, tube and profiles – Part 1 : Technical conditions for inspection and delivery.*

EN 755-2, *Aluminium and aluminium alloys – Extruded rod/bar, tube and profiles – Part 2 : Mechanical properties.*

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3 Technical conditions for inspection and delivery**3.1 General**

If not otherwise stated in this standard then the provisions of EN 755-1:1997 shall apply.

3.2 Production and manufacturing process

Only the porthole die method shall be used.

3.3 Coil size and weight

The inner coil diameters shall be subject to agreement between purchaser and manufacturer and stated on the order.

Coil weight and tube length shall be subject to agreement between purchaser and manufacturer and stated on the order.

4 Alloys and sizes

4.1 Alloys

Coiled tube is currently available only in the most commonly used general engineering alloys as listed below.

- EN AW-1050A, EN AW-1070A, EN AW-1200, EN AW-1350
- EN AW-3003, EN AW-3103
- EN AW-5005, EN AW-5005A, EN AW-5051A, EN AW-5251
- EN AW-6101A, EN AW-6101B, EN AW-6005, EN AW-6005A, EN AW-6106, EN AW-6012, EN AW-6018, EN AW-6351, EN AW-6060, EN AW-6061, EN AW-6261, EN AW-6262, EN AW-6063, EN AW-6063A, EN AW-6463, EN AW-6081, EN AW-6082

Availability of other alloys is subject to agreement between purchaser and supplier.

4.2 Sizes

Coiled tube is currently available only with an outside diameter up to and including 30 mm, a wall thickness up to and including 2,5 mm, and an outer diameter: wall thickness ratio up to 20 max.

5 Mechanical properties

The mechanical properties shall conform to those specified in EN 755-2.

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6 Tolerances on dimensions and form

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6.1 Diameter

The tolerances on diameter shall be as specified in Table 1. Measurement shall be made on the coiled tube (i.e. without straightening) after having discarded a length corresponding to two coiled laps.

Table 1 — Tolerances on diameter

Dimensions in millimetres

Diameter (outside or inside)		Tolerances on diameter (outside or inside)	
Over	Up to and including	Maximum allowable deviation of mean diameter from specified diameter	Maximum allowable deviation of diameter at any point from specified diameter (including ovality)
≥ 5	10	± 0,25	± 0,60
10	18	± 0,25	± 0,70
18	30	± 0,30	± 0,90

The mean diameter shall be determined as the average of two diameter measurements taken at right angles to each other at any point along the coil length.

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6.2 Wall thickness

The mean wall thickness shall be determined as the average of two wall thickness measurements taken at right angles to each other at any point along the coil length.

The tolerances on wall thickness are specified in Table 2.

Table 2 — Tolerances on wall thickness

Wall thickness mm		Maximum allowable deviation of mean wall thickness from specified wall thickness mm	Maximum allowable eccentricity of specificied of wall thickness %
Over	Up to and including		
-	0,8	$\pm 0,10$	± 8
1,0	1,5	$\pm 0,10$	± 8
1,5	2,5	$\pm 0,15$	± 8

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