



## Standard Specification for Cooker, Steam<sup>1</sup>

This standard is issued under the fixed designation F1217; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

*This standard has been approved for use by agencies of the Department of Defense.*

### 1. Scope

1.1 This specification covers food cookers and food reheaters which use steam as the heat source. These units are also known as steamers, steam ovens, and steam cookers which utilize steam generated by gas, electric heat, or steam coil sources, or a combination thereof, in commercial and institutional food service establishments. This specification can be used for ~~zero-pressure steam cookers, sub-zero-pressure steamers, pressure steamers, and combination pressure/pressureless steamers, boilerless steamers, and connectionless steamers~~, and does not cover steam cooking equipment used by food processors who normally package the food that they cook.

1.2 The values stated in inch-pound units are to be regarded as the standard. The SI values given in parentheses are provided for information only.

1.3 *This standard may involve hazardous materials, operations, and equipment. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

### 2. Referenced Documents

#### 2.1 ASTM Standards:<sup>2</sup>

A36/A36M [Specification for Carbon Structural Steel](#)

A167 [Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip](#)

A176 [Specification for Stainless and Heat-Resisting Chromium Steel Plate, Sheet, and Strip](#)

A240/A240M [Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels and for General Applications](#)

A268/A268M [Specification for Seamless and Welded Ferritic and Martensitic Stainless Steel Tubing for General Service](#)

A269 [Specification for Seamless and Welded Austenitic Stainless Steel Tubing for General Service](#)

A276 [Specification for Stainless Steel Bars and Shapes](#)

~~A366/A366M Specification for Steel, Sheet, Carbon, Cold-Rolled, Commercial Quality~~

A478 [Specification for Chromium-Nickel Stainless Steel Weaving and Knitting Wire](#)

~~A569/A569M Specification for Steel, Carbon (0.15 Maximum Percent), Hot-Rolled Commercial Quality Sheet and Strip<sup>0</sup>~~

~~568/A568M Specification for Steel, Sheet, Carbon, Structural, and High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, General Requirements for~~

~~A635/A635M Specification for Steel, Sheet and Strip, Heavy-Thickness Coils, Hot-Rolled, Alloy, Carbon, Structural, High-Strength Low-Alloy, and High-Strength Low-Alloy with Improved Formability, General Requirements for~~

~~A1011/A1011M Specification for Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, and Ultra-High Strength~~

B108 [Specification for Aluminum-Alloy Permanent Mold Castings](#)

B209 [Specification for Aluminum and Aluminum-Alloy Sheet and Plate](#)

D3951 [Practice for Commercial Packaging](#)

F760 [Specification for Food Service Equipment Manuals](#)

F1166 [Practice for Human Engineering Design for Marine Systems, Equipment, and Facilities](#)

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee F26 on Food Service Equipment and is the direct responsibility of Subcommittee F26.02 on Cooking and Warming Equipment.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

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2.2 *Underwriters Laboratories Standard:*<sup>3</sup>

UL/ANSI 197 Commercial Electric Cooking Appliances

2.3 *ANSI Standards:*<sup>4</sup>

ANSI B1.1 Unified Inch Screw Threads (UN and UNR Thread Form)

ANSI Z1.4 Sampling Procedures and Tables for Inspection by Attributes

ANSI Z21.41 Quick-Disconnect Devices for Use With Gas Fuel Appliances

~~ANSI Z21.45 Flexible Connectors of Other Than All-Metal Construction for Gas Appliances~~ ANSI Z21.69 Connectors for Moveable Gas Appliances

ANSI Z83.11 Gas Food Service Equipment

ANSI/NFPA 54 National Fuel Gas Code

ANSI Z223/NFPA 70 National Electrical Code<sup>5</sup>

2.4 *NSF Standards:*<sup>6</sup>

~~NSF/ANSI Standard No. 4 Commercial Cooking and Hot Food Storage Equipment~~ Commercial Cooking, Rethermalization, and Powered Hot Food Holding and Transportation Equipment

2.5 *ASME Documents:*<sup>7</sup>

~~ASME Boiler and Pressure Vessel Code Section IV—Heating Boilers~~

~~ASME Boiler and Pressure Vessel Code, Section IV—Heating Boilers~~ ASME Boiler and Pressure Vessel Code Section VIII—Division 1

2.6 *Military Standards:*<sup>8</sup>

MIL-STD-167/1 Mechanical Vibration of Shipboard Equipment (Type 1—Environmental and Type 2—Internally Excited)

MIL-STD-461 Requirements For the Control Of Electromagnetic Interference Characteristics of Subsystems and Equipment

MIL-STD-1399/300 Interface Standard For Shipboard Systems Section 300A Electric Power, Alternating Current

### 3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *boilerless steam cooker*—as used in this specification, is a device with one or more food steaming compartments in which the steam is generated within the food compartment without a separate steam generator.

3.1.2 *capacity*—the capacity of a steam cooker is determined by the number of steam table pans that it is designed to hold during cooking.

3.1.2

3.1.3 *connectionless steam cooker or steamer*—as used in this specification, is a steam cooker without permanent water fill and drain connection and is typically intended for batch cooking. Such a steam cooker may be optionally fitted with a water fill connection or a drain connection, or both.

3.1.4 *pans*—containers used to hold the food product in the oven/steamer cavity. A full size steam table pan is nominally 12¾ by 20¾ by 2½ in. (324 by 527 by 64 mm).

3.1.3 ~~*steam cooker*~~

3.1.5 *pressure/pressureless steamer*—as used in this specification, is a device with one or more food steaming compartments in which the energy in steam is transferred to the food by direct contact. The pressure occurring in the food compartment of these steamers during cooking ranges from 0 to 15 psig-, is a device with one or more food steaming compartments in which the energy in steam is transferred to the food by direct contact. The pressure occurring in the food compartment of these steamers during cooking ranges from 0 to 15 psig (0 to 103.42 KPa).

3.1.6 *steam cooker with steam generator*—as used in this specification, is a separate steam generator that that supplies steam to cooking compartment at a pressure range from 0 to 15 psig (0 to 103.42 KPa) and both the generator and cooking chamber are housed in a single unit.

3.1.7 *sub-zero pressure steamer*—as used in this specification, is a device with one or more food steaming compartments in which the energy in steam is transferred to the food by direct contact. The food compartment of these steamers during cooking is at a vacuum of 1 in. of mercury (minimum) or greater.

<sup>3</sup> Available from Underwriters Laboratories (UL), Corporate Progress, 333 Pfingsten Rd., Northbrook, IL 60062.

<sup>4</sup> Available from Underwriters Laboratories (UL), Corporate Progress, 333 Pfingsten Rd., Northbrook, IL 60062.

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

<sup>5</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

<sup>5</sup> Available from National Fire Protection Association (NFPA), 1 Batterymarch Park, Quincy, MA 02269-9101.

<sup>6</sup> Available from National Fire Protection Association (NFPA), 1 Batterymarch Park, Quincy, MA 02269-9101.

<sup>6</sup> Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140.

<sup>7</sup> Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140.

<sup>7</sup> Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5900.

<sup>8</sup> Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5900.

<sup>8</sup> Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://dodssp.daps.dla.mil>.

#### 4. Classification

~~4.1 Steam cookers covered by this specification are classified by type, grade, class, size, style, and capacity:~~

4.1 Steam cookers covered by this specification are classified by type (more than one type may be specified for the same equipment), grade, class, size, style, and capacity:

4.2 *Type:*

4.2.1 *Type IA*—Table or countertop units with permanent water inlet and drain connection.

4.2.2 *Type IB*—Table or countertop units without permanent water inlet and drain connection (connectionless steamer).

4.2.3 *Type II*—Floor mounted on an open stand.

4.2.4 *Type III*—Floor mounted on a cabinet base.

4.2.5 *Type IV*—Unit with a pressure or pressure-less separate steam generator.

4.2.6 *Type V*—Unit without a separate steam generator (boilerless steamer).

4.3 *Grade:*

4.3.1 *Grade A*—~~0 to 2.9 psig compartment pressure.~~ 0 to 2.9 psig (0 to 19.99 KPa) compartment pressure.

4.3.2 *Grade B*—~~3.0 to 9.9 psig compartment pressure.~~ 3.0 to 9.9 psig (20 to 68.90 KPa) compartment pressure.

4.3.3 *Grade C*—~~10.0 to 15 psig compartment pressure.~~ 10.0 to 15 psig (68.95 to 103.42 KPa) compartment pressure.

4.3.4 *Grade D*—Vacuum of 1 to 29.8 in. (25.4 to 755 mm) of mercury.

NOTE 1—These pressure values refer to the continuous pressure or the maximum pressure reached during a cooking cycle.

4.4 *Class:*

4.4.1 *Class 1*—208 V, 60 Hz, 1 phase.

4.4.2 *Class 2*—208 V, 60 Hz, 3 phase.

4.4.3 *Class 3*—240 V, 60 Hz, 1 phase.

4.4.4 *Class 4*—240 V, 60 Hz, 3 phase.

4.4.5 *Class 5*—480 V, 60 Hz, 1 phase.

4.4.6 *Class 6*—480 V, 60 Hz, 3 phase.

4.4.7 *Class 7*—120 V, 60 Hz, 1 phase.

4.4.8 *Class 8*—220 V, 60 Hz, 3 phase.

4.4.9 *Class 9*—230 ( $\pm 5\%$ ) V, 50 Hz, 1 phase.

4.4.10 *Class 10*—400 ( $\pm 5\%$ ) V, 50 Hz, 3 phase.

4.4.11 *Class 11*—440 V, 60 Hz, 3 phase (shipboard use).

4.5 *Size:*

4.5.1 *Size a*—One-compartment steamer.

4.5.2 *Size b*—Two-compartment steamer.

4.5.3 *Size c*—Three-compartment steamer.

4.6 *Style:* [standards.iteh.ai/catalog/standards/sist/00382db2-2f65-483b-8865-07e6200a6e93/astm-f1217-10](https://standards.iteh.ai/catalog/standards/sist/00382db2-2f65-483b-8865-07e6200a6e93/astm-f1217-10)

4.6.1 The steam used in the food compartments must be made from potable water and can be supplied from a self-contained electric, gas-fired, or steam coil steam generator, or from an external potable steam source.

4.6.2 *Style i*—Directly connected to an external steam source.

4.6.3 *Style ii*—Self-contained steam coil steam generator.

4.6.4 *Style iii*—Self-contained gas-fired steam generator.

4.6.5 *Style iv*—Self-contained electric steam generator.

4.7 *Capacity:*

4.7.1 Maximum three full size pans.

4.7.2 Maximum five full size pans.

~~4.7.3 Maximum six full size pans.~~

4.7.3 Maximum six full size pans.

4.7.4 Maximum ten full size pans.

4.7.5 Maximum 12 full size pans.

4.7.6 Maximum 16 full size pans.

4.7.7 Maximum 18 full size pans.

~~4.7.8 Maximum 24 full size pans.~~

4.7.8 Maximum 20 full size pans.

4.7.9 Maximum 24 full size pans.

#### 5. Ordering Information

5.1 An order for a steam cooker under this specification shall include the following information:

5.1.1 ASTM specification number and year of issue,

5.1.2 Quantity to be furnished,

5.1.3 Type,

- 5.1.3 Type (include more than one type as applicable).
- 5.1.4 Grade,
- 5.1.5 Class,
- 5.1.6 Size,
- 5.1.7 Style, and
- ~~5.1.8 Capacity.~~
- 5.1.8 Capacity (for capacity 4.7.3 through 4.7.9, specify size a, b, or c).
- 5.2 The following options should be reviewed and if any are desired they should be included in the order.
  - 5.2.1 When Federal/Military procurement(s) is involved, refer to the supplement pages.
  - ~~5.2.2 Type of gas, if applicable: natural, propane, other (specify dry gas energy content in Btu per cubic feet and specific gravity).~~
  - 5.2.2 Type of gas, if applicable: natural, propane, other (specify high heating value of gas in Btu per cubic feet, specific gravity, and composition of gas for other gases).
  - 5.2.3 Electrical power supply connection if applicable; power cord with plug or conduit connection and size.
  - 5.2.4 If required, the ability to cook frozen food without thawing it first.
  - 5.2.5 When other than manufacturer's standard, commercial, domestic packaging is required, specify packaging requirements.
  - ~~5.2.6 Specify special requirements, such as inspections, accessories, additional nameplate data, anchorable feet, etc.~~
  - 5.2.6 Specify special requirements, such as inspections, accessories, additional nameplate data, anchorable feet, stacking of different capacities for size b or size c, etc.
  - 5.2.7 If required, specify an automatic cold water steam condenser on the steam cooker's drain line.
  - 5.2.8 When specified, a certification to ensure that samples representing each lot have been either tested or inspected as directed and the requirements have been met. When specified, a copy of the certification or test results, or both, shall be furnished to the purchaser.
  - 5.2.9 If Type 430 corrosion-resistant steel is not desired in 6.4.
  - 5.2.10 *Type of Controls*—Electro-mechanical, solid state, or programmable/computer controlled.
  - 5.2.11 When specified, a fan and baffle shall be provided in a steam cooking compartment:
    - 5.2.11.1 Fan shall be operated by a single speed or two-speed motor.
    - 5.2.11.2 Air baffle or fan guard may be provided to maintain uniformity of temperature within the cooking cavity.
    - 5.2.11.3 When provided, the baffle or fan guard shall be removable for cleaning of fan or blower.
  - 5.2.12 *Water Resistance:*
    - 5.2.12.1 When specified, control components and electrical wiring shall be resistant to moisture and condensation due to steam from "blow-down" of boiler or accidental leakage.
    - 5.2.12.2 When specified, all control components and exposed electrical wiring shall be resistant to cleaning by a water spray hose connected to domestic city water supply.
  - 5.2.13 When specified, the steam cooker shall be provided with "Hold" or "Cook and Hold" feature.
  - ~~5.2.14 When specified, with a quick-disconnect gas supply, an approved quick disconnect (socket and plug) conforming to ANSI Z21.41, and a flexible metal connector conforming to ANSI Z21.45 and consisting of a male pipe thread fitting on one end and a union with female thread on the opposite end shall be provided with the steam cooker.~~
  - ~~5.2.15 When specified, additional accessories such as: wire shelves, casters, oven stand, legs, wash-down hose assembly, and faucets shall be provided.~~
  - 5.2.14 When specified, a quick-disconnect gas supply, an approved quick disconnect (socket and plug) conforming to ANSI Z21.41, and a flexible metal connector conforming to ANSI Z21.69 shall be provided with the steam cooker.
  - 5.2.15 When specified, additional accessories such as: wire shelves, casters, steamer stand, legs, spray hose assembly, and faucets shall be provided.

## 6. Materials

- 6.1 *General:*
  - 6.1.1 Steam cookers shall conform to the documents listed in 2.1 and 2.3.
  - 6.1.2 Materials used shall be free from defects, which would affect the performance or maintainability of individual components, or of the overall assembly.
  - 6.1.3 Materials not specified herein shall be of the same quality used for the intended purpose in commercial practice.
  - 6.1.4 Use of used or rebuilt products is not allowed under this specification.
- 6.2 *Door*—The door shall be constructed of Types 302 or 304 corrosion-resistant steel conforming to Specifications A167, or A240/A240M. Aluminum alloy Types 356 or 319 conforming to Specification B108 or Type 6061 aluminum alloy conforming to Specification B209 may also be used alone or in combination with the corrosion-resisting steels described.
- 6.3 *Food Cooking Compartment*—Compartment shall be constructed of Types 302, 304, 304L, 316, or 316L corrosion-resistant steel conforming to Specifications A167 or A240/A240M, or aluminum alloy Type 3003-0 conforming to Specification B209. Pan racks shall be fabricated from Types 302, 304, or 316 corrosion-resistant steel conforming to Specifications A276 or A478.
- 6.4 *Exterior*—Unless otherwise specified, material shall be Types 201, 302, 304, 304L, 316, 316L, or 430 corrosion-resistant stainless steel conforming to Specification A240/A240M or to Specifications A167 or A176 ~~as applicable, and thickness shall be~~