



Standard Specification for Kettles, Steam-Jacketed, 32 oz to 20 gal (1 to 75.7 L), Tilting, Table Mounted, Direct Steam, Gas and Electric Heated¹

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

1. Scope

1.1 This specification covers jacketed kettles that use steam as a heat source for cooking food in commercial and institutional food service establishments. This specification does not cover 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 values given in parentheses are for information only.

1.3 *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:²

[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](#)

[A285/A285M Specification for Pressure Vessel Plates, Carbon Steel, Low- and Intermediate-Tensile Strength](#)

[A516/A516M Specification for Pressure Vessel Plates, Carbon Steel, for Moderate- and Lower-Temperature Service](#)

[A580/A580M Specification for Stainless Steel Wire](#)

[B456 Specification for Electrodeposited Coatings of Copper Plus Nickel Plus Chromium and Nickel Plus Chromium](#)

[D3951 Practice for Commercial Packaging](#)

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

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

[F1785 Test Method for Performance of Steam Kettles](#)

2.2 ANSI Standards:³

[ANSI/UL 197 Commercial Electric Cooking Appliances](#)

[ANSI Z83.11 Gas Food Service Equipment—Kettles, Steam Cookers and Steam Generators](#)

[ANSI/NSF Std. 4 Commercial Cooking and Hot Food Storage Equipment](#)

[ANSI Z223.1 National Fuel Gas Code](#)

[ANSI/NFPA 70 National Electrical Code](#)

[ANSI Z1.4 Sampling Procedures and Tables for Inspection by Attributes](#)

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

2.3 ASME Standards:⁴

ASME Boiler and Pressure Vessel Code, Section IV Heating Boilers

ASME Boiler and Pressure Vessel Code, Section VIII—Division 1 Pressure Vessels

2.4 Military Standards:⁵

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

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

~~MIL-STD-462 Measurement of Electromagnetic Interference Characteristics of Subsystems and Equipment~~

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

~~MIL-V-173 Varnish, Moisture and Fungus Resistant~~

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *jacketed kettle*—as used in this specification, a ~~tilting~~, tilting or stationary, deep sided vessel (steam jacketed) of 32 oz to 20 gal (1 to 75.7 L) capacity for cooking food in a liquid.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

⁵ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS; or Acquisition Streamlining and Standardization Information System (ASSIST) which is the official source of all documents listed in the DoD Index of Specifications and Standards. The ASSIST can be located at <http://dsp.dla.mil>.

3.1.1.1 Discussion—

These kettles can be mounted onto the purchaser's table or be specified already mounted on any of the stands or bases described in 4.1.3. The energy in the steam moving through the jacket is transferred to the liquid and to the food by condensation of the steam on the vessel wall.

4. Classification

4.1 Jacketed kettles covered by this specification are classified by size (capacity), grade, style and class.

4.1.1 Size (Capacity):

4.1.1.1 32 oz (1 L) capacity.

4.1.1.2 ~~80~~66 oz (~~2.4~~2 L) capacity.

4.1.1.3 2½ to 3 gal (9.5 to 11.4 L) capacity.

4.1.1.4 5 to 6 gal (~~21~~19 to 22.7 L) capacity.

4.1.1.5 10 to 12 gal (37.9 to 45.5 L) capacity.

4.1.1.6 20 gal (75.7 L) capacity.

4.1.2 Grade:

4.1.2.1 *Grade 1*—Maximum Working Pressure Rating of 15 to 25 psig (~~172.4~~ (103.4 to 172.4 KPa) or less.

4.1.2.2 *Grade 2*—Maximum Working Pressure Rating of 26 to 55 psig (~~379.2~~ (179.3 to 379.2 KPa) or less.

4.1.2.3 *Grade 3*—Maximum Working Pressure Rating of 56 to 90 psig (~~620.5~~ (386.1 to 620.5 KPa) or less.

4.1.3 Style:

4.1.3.1 *Style 1*—For table mounting on a counter.

4.1.3.2 *Style 2*—Table mounted on an open leg equipment stand.

4.1.3.3 *Style 3*—Table mounted on an enclosed cabinet stand.

4.1.3.4 *Style 4*—Table mounted on a 28 to 30-in. (711 to 762-mm) high enclosed cabinet base.

4.1.3.5 *Style 5*—Table mounted on a 28 to 30-in. (711 to 762-mm) high enclosed cabinet base with a Class D steam source.

4.1.4 Class:

4.1.4.1 *Class A*—Directly connected to an external steam source.

4.1.4.2 *Class B*—Self-contained, gas-fired steam generator.

4.1.4.3 *Class C*—Self-contained, electric steam generator.

4.1.4.4 *Class D*—A separate ASME Code, Section IV steam generator/heating boiler as steam source. (Typically used as steam source for multiple table top kettles.)

5. Ordering Information

5.1 An order for a kettle(s) under this specification shall specify:

5.1.1 ASTM specification number and date of issue.

5.1.2 Quantity to be furnished.

5.1.3 Size (capacity).

5.1.4 Grade.

5.1.5 Style.

5.1.6 Class.

5.1.7 Assurance that gas fired unit(s) will be installed in accordance with the installation instructions and the National Fuel Gas Code ANSI Z223.1 that:

5.1.7.1 Gas fired unit(s) will be installed in accordance with the installation instructions and the National Fuel Gas Code ANSI Z223.1.

5.1.7.2 Electric heat unit(s) will be installed in accordance with the installation instructions and the National Electrical Code ANSI/NFPA 70.

5.2 The following options should be reviewed and, if any are desired, they should also be included in the order.

5.2.1 When a cover is required.

5.2.2 When required, the maximum allowable width for Style 2 through Style 5 (4.1.3.2-4.1.3.5).

5.2.3 When required, for Style 1 kettles, the desired pouring height to the table top (7.2.2).

5.2.4 When two identical side by side kettles are desired in Style 2, 3, 4 or 5 (4.1.3.2-4.1.3.5).

5.2.5 When a wire basket (7.1.6) is required.

5.2.6 When Federal/Military procurement(s) is involved, refer to the supplement pages.

5.2.7 When Class B and C kettles are to be shipped from the factory without the supply of water in the jacket (7.3.2 and 7.3.3).

5.2.8 If type 430 corrosion-resistant steel is not desired for the enclosed cabinet Styles 3 and 4 (4.1.3).

5.2.9 When a water faucet with a swing spout is required.

5.2.10 When fill level marks are to be etched on kettle interior.

5.2.11 When insulation is required on the outside of the kettle body or steam jacket.

5.2.12 Type of gas, if applicable: natural, propane or other (specify gas composition, heating value in BTU per cubic foot and specific gravity of gas).

5.2.13 Electrical power supply characteristics: voltage, frequency, phase, kW input, or amp load, as applicable.

5.2.14 When other than manufacturer's standard, commercial, domestic packaging is required, specify packaging requirements (14.3).

5.2.15 When special or supplement requirements such as inspections, accessories, mounting patterns, utility connections, etc.

5.2.16 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.

6. Materials

6.1 *General*—Steam jacketed kettles shall conform to the following:

6.2 *Kettle*—The kettle vessel shall be constructed of Type 304, 304L, 316, or 316L corrosion resistant steel conforming to Specifications A167, A176, or A240/A240M.

6.3 *Steam Jacket*—Jacket shall be constructed of Type 304, 304L, 316, or 316L corrosion resistant steel conforming to Specifications A167 or A240/A240M.

6.3.1 *Class B Steam Jackets*—Class B jackets shall be fabricated from material conforming to Specification A285/A285M or A516/A516M material and skirted with Type 302 or 304 corrosion resistant steel conforming to Specifications A167 or A240/A240M.

6.4 *Exterior of Style 3, 4 and 5 Kettle Stands and Bases*—Unless otherwise specified, material shall be Types 302, 304, 316, or 430 corrosion resistant steel conforming to Specification A240/A240M or to Specifications A167 or A176, as applicable, and thickness shall be 20 gauge minimum [0.0375 in. (1 mm) U.S. revised standard gauge].

6.5 *Kettle Mount/Support Base*—All exterior surfaces shall be chrome plated in accordance with Specification B456 or Type 304, 316, or 430 corrosion resistant steel conforming to Specifications A167, A176, or A240/A240M, as applicable.

6.6 *Controls Console of Class B and C Kettles*—All exposed surfaces of the console and kettle base shall be Type 304, 316, or 430 corrosion resistant steel conforming to Specifications A240/A240M, A167, or A176, as applicable.

7. Design and Construction

7.1 *General*—Kettle shall be delivered assembled, ready for connection to steam, water, electricity or gas piping, as applicable. The kettles are to be equipped with a suitable drain and exhaust steam termination, if applicable. The height from the floor to the top rim of the kettle shall not exceed 46 in. (1150 mm).

7.1.1 *Jacketed Steam Chamber*—The steam containing part of the kettle shall be rated for the following allowable working pressure (WP):

7.1.1.1 *Direct Connected Kettles*—Minimum 25 psi (1.76 kg/cm²).

7.1.1.2 *Self-Generating Kettles*—Minimum 30 psi (2.19 kg/cm²).

7.1.1.3 Design and construction of the steam chamber of Class A, Class B and Class C kettles shall be in accordance with the ASME Boiler and Pressure Vessel Code, Section VIII, Division 1 with a National Board Registration number.

7.1.1.4 Design and construction of the steam chamber of Class D steam generator shall be in accordance with the ASME Boiler and Pressure Vessel Code, Section IV for Heating Boilers with CSD controls and National Board Registration.

7.1.2 *Insulation Casing*—When insulation is required, it shall be contained in a cylindrical casing designed to conform to the kettle body and steam jacket. The clearance between the inner and outer liner of the casing shall be sufficiently wide to keep the exterior surface of the kettle from exceeding 140°F (60°C) during operation. The outer liner shall be corrosion-resistant steel conforming to Specification **A167**, **A176**, or **A240/A240M**. The top of the casing shall be attached to the kettle’s canopy with stainless steel fasteners or rivets. The bottom of the casing shall terminate below the steam jacket.

7.1.3 *Covers*—When specified, kettle shall be provided with a one piece lift-off cover. Cover design shall be such that there is no permanent distortion as a result of normal use, or accumulation of liquid or debris on the cover which could contaminate the food zone during opening or closing of the cover.

7.1.3.1 *Operating Handles*—Kettle rim shall have a lug(s) for a handle to tilt the kettle, if applicable.

7.1.4 *Safety Relief Valve:*

7.1.4.1 Class ~~B-A~~, **Class B**, and Class C kettles shall be provided with a safety valve on the steam jacket or on the steam inlet pipe to the jacket. Valve shall be constructed in accordance with the applicable requirements of the ASME Boiler and Pressure Vessel Code Section VIII, Division ~~1~~ of ~~Pressure Vessels-1~~.

7.1.4.2 Class D steam generators shall be provided with a safety valve on the steam jacket or on the steam outlet pipe. Valve shall be constructed in accordance with the applicable requirements of the ASME Boiler and Pressure Vessel Code Section IV.

7.1.4.3 Valve shall be positioned so that its discharge port will vent steam downward.

7.1.4.4 The relief pressure of the valve shall be equal to or less than the maximum working pressure of the kettle.

7.1.5 *Swing Spout Water Supply*—Each kettle shall be provided with a swing spout with a companion on/off valve when specified. The swing spout assembly should be made of stainless steel, conforming to Specification **A167**, or chromium plated, in accordance with Specification **B456**. The bracket and swing spout shall be positioned so that the outlet end of the spout is a minimum of ½ in. (13 mm) above the top rim of the kettle. The swing spout supplied with tilting kettles shall be mounted independent of the kettle body.

7.1.6 *Basket Insert*—When specified, each kettle shall be provided with a basket insert. The length and diameter of the basket shall fit inside the insides of the kettle body and shall be fitted with handles. The basket shall be fabricated of Type 304 or 316 corrosion resistant steel perforated sheet metal conforming to Specifications **A167**, **A176**, **A240/A240M**, or Type 304 or 316 wire in accordance with Specification **A580/A580M**, as applicable. For wire baskets, the space between wires shall not be greater than 3/8 in. (9.5 mm). For perforated baskets, holes shall be ¼ in. (6.4 mm) or ⅜ in. (9.5 mm) diameter unless otherwise specified. A contour-fitted nylon bag with a stainless steel spreader ring shall be furnished with each basket.

7.1.7 *Tilt Mechanism:*

7.1.7.1 *Hand Tilt Mechanism*—The tilt mechanism, through its operating handle, shall provide the user a smooth pull against resistance to tilt a kettle that is filled to capacity. When the pull on the operating handle is relaxed the kettle shall return to its upright position. Kettle shall be tiltable to past 90° from normal operating position.

(1) When specified, a locking system shall be provided to prevent accidental tilting. This lock shall have an easy release mechanism to tilt the kettle.

7.1.7.2 *Crank Tilt Mechanism*—Shall be provided when specified. The tilt mechanism shall provide the smooth, quick-acting, self-locking, easy tilting operation of a liquid-filled kettle, of greater than 90° from normal operating position, and it shall hold the kettle at any position as it is being raised or lowered. Tilting shall be controlled by either a power mechanism or a crank handle, or a handwheel attached to the gear box.

7.1.8 ~~All exterior surfaces shall be chrome plated per Specification **B456** or Type 304 or 316 corrosion resistant steel.~~

7.1.8 *Kettle Mount/Support Base*—Design of the base shall be such that the kettle can be mounted on a counter top or equipment stand or an enclosed cabinet base.

7.1.9 *Control Box*—Controls for operation of the fuel supply shall be located in a protective housing designed to prevent the entry of spillage from the kettle. This housing shall be corrosion-resistant steel conforming to Specification **A167**, **A176**, or **A240/A240M**, and it shall be located on the outside of the kettle and permit easy access to the controls.

7.1.10 *Safety Cut-Off*—Class B and Class C kettles shall be equipped with a device to de-energize the heat source (electric power to the elements or gas to the burners) when the kettle is tilted.

7.1.11 *Thermostat*—Class B and C kettles shall have a control that will maintain a desired temperature in the liquid being heated in the kettle. It shall be marked with an “off” or “0” position, or it may have a separate “on/off” switch. An indicating light shall show when the heating system is energized.

7.1.12 *Standards*—Jacketed kettles shall conform to ANSI/UL 197, ANSI/NSF Std. 4, and ANSI/NFPA 70 for electric heated kettles and ANSI Z83.11, ANSI/NSF Std. 4, ANSI Z223.1, and ANSI/NFPA 70 for gas heated kettles.

7.1.12.1 *Proof of Compliance*—Evidence of compliance with ANSI/UL 197, ANSI Z83.11, ASME Boiler and Pressure Vessel Code, Section IV or VIII, or both, and ANSI/NSF Std. 4 shall be a listing in a third-party certification agency listing book, or a certified test report from a nationally recognized testing laboratory acceptable to the purchaser.

7.2 *General by Style:*