

Specification
VSR80

For leak-tight but detachable connections with controlled hardness for easy installation

VSR80

bf bright finished



1. SURFACES QUALITIES

Tubes:	Inner surface	Outer surface
VSR80	Ra values are not defined	Ra_{avg.} ≤ 1.0 μm (40 μin) free of longitudinal and vertical scratches

2. MATERIALS

VSR80	1.4404 / UNS S31603 (316L) 1.4571 / S31635
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Hardness equivalent to:	- max. 70-90 HRB* according to DIN EN ISO 6508-1 * comparable to ASTM E-384 (HV) and ASTM E 18-22 (HRB)
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3. DIMENSIONS

Imperial:	according to ASTM A269 and DIN 11866 Series C	
OD x WT	1/16" (0,0625"x 0,010") to 1" (1,000" x 0,065 ")	1,59 mm x 0,25 mm to 25,40 mm x 1,65 mm
Length	min. 19.36 ft to max. 19.98 ft (6000 mm -100/+90)	

Metric:	according to DIN 11866 Series A	
Dimensions	3,00 mm x 0,50 mm to 28,00 mm x 1,50 mm	Length: 6000 mm -100/+90

Manufacturing process:	Seamless austenitic stainless steel tubes
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4. QUALITY AND TEST PROCEDURES



Verification of basic test certificate



Visual inspection



Endoscopic inspection of bright finished tubes



Verification of dimensions



Roughness measurements

5. TECHNICAL TERMS OF DELIVERY

Tubes according to the following standards:

Tubes

Acc. to ASTM A 632 / A 269 / A 270, DIN EN 10217-7 / 10216-5 with a length of 19.35 ft - 19.98 ft (max. 10% short lengths of 9.8 ft min. possible)

Marking always with

DOCKWEILER / DW-Number / Dimension / Material / Heat number

Tubes are permanently marked in accordance with Dockweiler guideline AA 8.5.2-80.

6. DOCUMENTATION, PACKAGING AND SHIPPING

Documentation

The documentation result by the Dockweiler Inspection Certificate 3.1 according to DIN EN 10204. Optional online documentation WebCert.

Packaging

The batch label on the foil contains the information VSR80.

Shipping

Delivery in tubular container or case for safe transport.