



## SPECIFICATION FOR STANDARD SIZES

### SANS 657-3:2005 - CONVEYOR ROLLER TUBES.

Nominal outside diameter (MM)	Actual outside diameter (MM)	Outside diameter(MM)		Inside diameter(MM)		Ovality Max	Wall Thickness	Weight of Tube	
		Max	Min	Max	Min			MM	Kg/Mtr
101	101.6	101.8	101.4	95.80	95.40	0.4	3	7.29	4.90
127	127	127.2	126.8	119.60	119.20	0.4	3.8	11.55	7.76
152	152.4	152.6	152.2	144.60	144.20	0.4	4	14.64	9.84
165	165.1	165.3	164.8	156.30	155.80	0.5	4.5	17.82	11.98

**1) TOLERANCE**

- a) :On Specified OD & ID  $\pm 0.2$  mm (Ovality 0.4 mm)
- b) On wall Thickness -  $\pm 0.2$  mm
- c) Straightness- Shall not exceed 1 in 1000 (measured at the midpoint of the tube)
- d) Scarfing- Outer side= $0.1$  mm Max.,inner scarfing= $(-0.35$  to  $-0.10)$ mm

**2) END**

: Cut cleanly and nominally square with the axis of the tube and free from excessive burrs.

**3) PROPERTIES**

- a) Chemical: : % Max.C - 0.25%, S - 0.06%, P - 0.060%,
- b) Mechanical:(Min.) UTS - 320 N/mm<sup>2</sup>, YS - 230 N/mm<sup>2</sup> & %Elongation - 10%.

**4) FLATTENING TEST**

- a) Weld Position 90°-Flatten until the distance between the two plates is 60% of the actual tube OD
- b) Weld Position 0°-Flatten until the distance between the two plates is 15% of the actual tube OD.

**5) FLARE TEST**

Applying a steadily increasing force until the end of the test piece flares to a diameter  $10\% \pm 1\%$  Larger than the outside diameter of the pipe.



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| <b>6) MARKING</b>               | : We can emboss mill sign and Standard " UTP -SANS657-3" online at every one meter interval over the length of pipe. |
| <b>7) PACKING</b>               | : Hexagonal  |
| <b>8) MILL TEST CERTIFICATE</b> | : We can issue a MTC, Certifying that the tube supplied comply with this standard.                                   |