

**Alumiinium ja alumiiniumisulamid. Külmtõmmatud vardad või latid ja torud. Osa 8: Ambrasuuritorud, mõõtmeterantsid ja kuju lubatud piirhälbed**

Aluminium and aluminium alloys - Cold drawn rod/bar and tube - Part 8: Porthole tubes, tolerances on dimensions and form

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 754-8:2008 sisaldab Euroopa standardi EN 754-8:2008 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 19.05.2008 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 19.03.2008.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN 754-8:2008 consists of the English text of the European standard EN 754-8:2008.

This standard is ratified with the order of Estonian Centre for Standardisation dated 19.05.2008 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

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**Võtmesõnad:** alumiinium, alumiiniumisulamid, alumiiniumtorud, kuju lubatud piirhälbed, mõõtmeterolerantsid, tõmmatud tooted

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## English Version

**Aluminium and aluminium alloys - Cold drawn rod/bar and tube -  
Part 8: Porthole tubes, tolerances on dimensions and form**

Aluminium et alliages d'aluminium - Barres et tubes étirés -  
Partie 8: Tubes filés à pont, tolérances sur dimensions et  
forme

Aluminium und Aluminiumlegierungen - Gezogene Stangen  
und Rohre - Teil 8: Mit Kammerwerkzeug Stranggepresste  
Rohre, Grenzabmaße und Formtoleranzen

This European Standard was approved by CEN on 10 February 2008.

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## Foreword

This document (EN 754-8:2008) 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of an identical text or by endorsement, at the latest by September 2008, and conflicting national standards shall be withdrawn at the latest by September 2008.

This document supersedes EN 754-8:1998.

Within its programme of work, Technical committee CEN/TC 132 entrusted CEN/TC 132/WG 5 "*Extruded and drawn products*" to revise EN 754-8:1998.

The following technical modifications have been introduced during the revision:

- Clause 1: Scope is clarified with respect to what is not included
- Clause 1: Alloy EN AW-5049, EN AW-6262A and EN AW-6065 are added
- Subclause 2.4 and Table 3: Requirements to wall thickness variation (eccentricity) is introduced
- Annex A: Informative Annex A is added explaining wall thickness variation (eccentricity)

EN 754 comprises the following parts under the general title "*Aluminium and aluminium alloys — Cold drawn rod/bar and tube*":

- *Part 1: Technical conditions for inspection and delivery*
- *Part 2: Mechanical properties*
- *Part 3: Round bars, tolerances on dimensions and form*
- *Part 4: Square bars, tolerances on dimensions and form*
- *Part 5: Rectangular bars, tolerances on dimensions and form*
- *Part 6: Hexagonal bars, tolerances on dimensions and form*
- *Part 7: Seamless tubes, tolerances on dimensions and form*
- *Part 8: Porthole tubes, tolerances on dimensions and form*

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## 1 Scope

This document specifies the tolerances on dimensions and form for aluminium and aluminium alloy cold drawn porthole tubes with an outside diameter ( $OD$ ) from 3 mm to 350 mm (round tube, see Figure 1) or with a cross section contained within a circumscribing circle ( $CD$ ) from 8 mm to 300 mm (other than round tube, see Figure 2), supplied in straight lengths.

This document only applies to cold drawn tube for general engineering applications made in the following alloys:

- EN AW-1050A, EN AW-1200;
- EN AW-3003, EN AW-3103;
- EN AW-5005, EN AW-5005A, EN AW-5049, EN AW-5251, EN AW-5052;
- EN AW-6012, EN AW-6060, EN AW-6061, EN AW-6262, EN AW-6262A;
- EN AW-6063, EN AW-6063A, EN AW-6065, EN AW-6082;
- EN AW-7020.

The temper designations used in this part are according to EN 515.

This document only applies to tube produced by the porthole/bridge method of extrusion only (and then cold drawn to the final dimensions).

This document does not apply to:

- cold drawn tubes produced by the seamless, die/mandrel method (EN 754-7),
- tubes delivered in coils (EN 13958),
- coiled tubes cut to length (EN 13958).

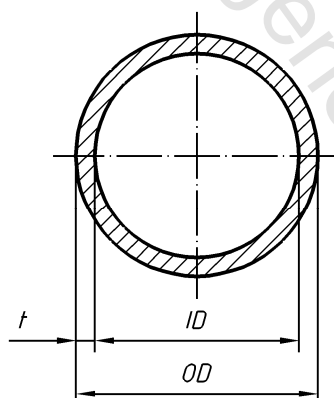


Figure 1 — Round tube