

This is a preview of "ISO 8535-1:2011". [Click here to purchase the full version from the ANSI store.](#)

Fifth edition  
2011-12-01

---

---

## **Diesel engines — Steel tubes for high-pressure fuel injection pipes —**

Part 1:

### **Requirements for seamless cold-drawn single-wall tubes**

*Moteurs diesels — Tubes en acier pour lignes d'injection de combustible à haute pression —*

*Partie 1: Exigences pour les tubes monoparoi sans soudure étirés à froid*



Reference number  
ISO 8535-1:2011(E)

© ISO 2011

This is a preview of "ISO 8535-1:2011". [Click here to purchase the full version from the ANSI store.](#)



**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2011

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Case postale 56 • CH-1211 Geneva 20  
Tel. + 41 22 749 01 11  
Fax + 41 22 749 09 47  
E-mail [copyright@iso.org](mailto:copyright@iso.org)  
Web [www.iso.org](http://www.iso.org)

Published in Switzerland

This is a preview of "ISO 8535-1:2011". [Click here to purchase the full version from the ANSI store.](#)

## Contents

Page

Foreword .....	v
<b>1 Scope .....</b>	<b>1</b>
<b>2 Normative references .....</b>	<b>1</b>
<b>3 Dimensions and tolerances .....</b>	<b>1</b>
3.1 Diameters .....	1
3.2 Length .....	2
<b>4 Material processing .....</b>	<b>2</b>
4.1 Steel manufacturing process .....	2
4.2 Manufacturing of tubes .....	2
4.3 Surface quality .....	4
4.4 Surface finish .....	4
4.5 Minimum mechanical properties of tubes .....	5
4.6 Cleanliness .....	5
4.7 Straightness .....	5
4.8 Corrosion resistance .....	5
<b>5 Testing .....</b>	<b>5</b>
5.1 General .....	5
5.2 Scope of tests .....	5
5.3 Dimension tests .....	5
5.4 Mechanical-property tests .....	6
5.5 Bending test .....	6
5.6 Cold upsetting of tubes .....	6
5.7 Surface quality test .....	6
5.8 Inside pressure test .....	6
5.9 Retesting .....	6
5.10 Test certificate .....	7
<b>6 Designation .....</b>	<b>7</b>
<b>7 Identification and marking .....</b>	<b>8</b>
<b>8 Packing .....</b>	<b>8</b>
<b>Annex A (informative) Theoretical maximum pressure for inside pressure testing .....</b>	<b>9</b>
<b>Bibliography .....</b>	<b>10</b>

This is a preview of "ISO 8535-1:2011". [Click here to purchase the full version from the ANSI store.](#)

This is a preview of "ISO 8535-1:2011". [Click here to purchase the full version from the ANSI store.](#)

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 8535-1 was prepared by Technical Committee ISO/TC 22, *Road vehicles*, Subcommittee SC 7, *Injection equipment and filters for use on road vehicles*.

This fifth edition cancels and replaces the fourth edition (ISO 8535-1:2006), which has been technically revised.

ISO 8535 consists of the following parts, under the general title *Diesel engines — Steel tubes for high-pressure fuel injection pipes*:

- *Part 1: Requirements for seamless cold-drawn single-wall tubes*
- *Part 2: Requirements for composite tubes*

NOTE The first part of the general title, "*Diesel engines*", is used for Part 1 only; for Part 2 "*Compression-ignition engines*" is still used but will be replaced at the next revision.