

INTERNATIONAL STANDARD



Hollow metallic waveguides – Part 4: Relevant specifications for circular waveguides



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CONTENTS

FOREWORD.....	3
1 Scope.....	5
2 Normative references	5
3 Terms and definitions	5
4 General	5
4.1 Standardized types	5
4.2 Type designation	5
4.3 Frequency range.....	5
5 Mechanical requirements.....	6
5.1 General.....	6
5.2 Dimensions	6
5.2.1 Basic diameter and deviations	6
5.2.2 Basic diameter deviations	9
5.2.3 Ellipticity.....	9
5.2.4 Wall thickness	9
5.2.5 Eccentricity.....	9
5.2.6 Outside dimensions	9
5.3 Other mechanical requirements	10
5.3.1 Bow	10
5.3.2 Surface roughness.....	10
5.3.3 Internal stresses	10
6 Electrical tests – Attenuation	10
7 Additional tests – Gastightness.....	11
Bibliography.....	12
Table 1 – Basic diameter and deviations	7
Table 2 – Circular waveguides	8
Table 3 – Inner Diameter deviations.....	9
Table 3 – Outer diameter deviations	9

INTERNATIONAL ELECTROTECHNICAL COMMISSION

HOLLOW METALLIC WAVEGUIDES –**Part 4: Relevant specifications for circular waveguides**

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International Standard IEC 60153-4 has been prepared by subcommittee 46F: RF and microwave passive components, of IEC technical committee TC:46: Cables, wires, waveguides, RF connectors, RF and microwave passive components and accessories.

This third edition cancels and replaces the second edition published in 1973-1. This edition constitutes a technical revision.

This edition includes the following significant technical changes with respect to the previous edition:

- a) Expand and revise the operation frequency range for waveguides;
- b) Revise the allowance of aperture dimensions;
- c) Revise the test method for aperture dimensions;
- d) Revise the equation of attenuation.

The text of this International Standard is based on the following documents:

CDV	Report on voting
46F/344/CDV	46F/356/RVC

Full information on the voting for the approval of this International Standard can be found in the report on voting indicated in the above table.

This document has been drafted in accordance with the ISO/IEC Directives, Part 2.

A list of all the parts in the IEC 60153 series, published under the general title *Hollow metallic waveguides*, can be found on the IEC website.

The committee has decided that the contents of this document will remain unchanged until the stability date indicated on the IEC website under "<http://webstore.iec.ch>" in the data related to the specific document. At this date, the document will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

A bilingual version of this publication may be issued at a later date.

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HOLLOW METALLIC WAVEGUIDES –

Part 4: Relevant specifications for circular waveguides

1 Scope

This part of IEC 60153 specifies straight hollow metallic tubing of circular waveguides for use as waveguides in electronic equipment.

The aim of this recommendation is to specify for hollow metallic waveguides:

- a) the details necessary to ensure compatibility and, as far as essential, interchangeability;
- b) test methods;
- c) uniform requirements for the electrical and mechanical properties.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60050-726:1982, *International Electrotechnical Vocabulary. Transmission lines and waveguides*

IEC 60261, *Sealing test for pressurized waveguide tubing and assemblies*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in IEC 60050-726:1982 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

4 General

4.1 Standardized types

The series of circular waveguides covered by this publication are shown in Tables 1 and 2. The preferred types are shown in Table 2. As it might be desirable to use circular waveguides of intermediate sizes, Table 3 has been added in which the latter types are included.

4.2 Type designation

For these waveguides, the type designation comprises:

- The code: 60153 IEC-C
- A number characterizing a particular size of waveguide. This number expresses 'approximately in multiples of 100 MHz the geometric mean frequency in the H_{11} (TE_{11}) mode.

4.3 Frequency range

In Table 2, the cut-off frequencies are shown for the following modes:

TE_{11} , TM_{01} , TE_{21} , TE_{01} and TE_{02} .

5 Mechanical requirements

5.1 General

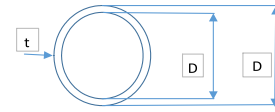
It should be noted that no recommendations are made for the materials to be used for waveguides. The choice of material must be agreed between customer and manufacturer.

5.2 Dimensions

5.2.1 Basic diameter and deviations

The basic diameters (inner diameters) and the deviations are specified in Table 1.

Table 1 – Basic diameter and deviations



Dimensions in millimetres															
Type designation	Cut-off frequency in GHz for the mode					Inside cross-section		Basic wall thickness	Outside cross-section		Theoretical value of attenuation in dB/m				
	TE ₁₁	TM ₀₁	TE ₂₁	TE ₀₁	TE ₀₂	Basic diameter D	Deviation		Basic diameter	Deviation	Frequency in GHz	Standard Copper	Aluminium	Gold	Brass
C 3.3	0.27	0.35	0.45	0.56	1.03	647.90	0.64	For subsequent study			0.325	0.0007	0.00084	0.00077	0.00102
C 4	0.32	0.41	0.53	0.66	1.21	553.49	0.56				0.38	0.0009	0.0011	0.0010	0.00129
C 4.5	0.37	0.48	0.62	0.77	1.42	472.85	0.48				0.446	0.0011	0.0013	0.0012	0.0016
C 5.3	0.43	0.57	0.72	0.90	1.66	403.94	0.41				0.522	0.0014	0.0017	0.0015	0.0021
C 6.2	0.51	0.66	0.84	1.06	1.94	345.06	0.36				0.611	0.0017	0.0021	0.0020	0.0026
C 7	0.60	0.78	0.99	1.24	2.27	294.79	0.30				0.715	0.0022	0.0027	0.0025	0.0033
C 8	0.70	0.91	1.16	1.45	2.66	251.84	0.25				0.838	0.0028	0.0034	0.0031	0.0042
C 10	0.82	1.07	1.35	1.70	3.11	215.14	0.22				0.98	0.0035	0.0044	0.0040	0.0053
C 12	0.96	1.25	1.59	1.99	3.64	183.77	0.18				1.147	0.0045	0.0055	0.0051	0.0067
C 14	1.12	1.46	1.86	2.33	4.26	157.00	0.16				1.343	0.0056	0.0070	0.0064	0.0085
C 16	1.31	1.71	2.17	2.73	4.99	134.11	0.13	1.572	0.007	0.0089	0.0081	0.0108			
C 18	1.53	2.00	2.54	3.19	5.84	114.58	0.11	1.8410	0.009	0.011	0.010	0.0136			
C 22	1.79	2.34	2.98	3.74	6.84	97.87	0.10	3.3	121.21	0.13	1.8410	0.009	0.011	0.010	
C 25	2.10	2.74	3.49	4.37	8.01	83.617	0.081	3.3	104.50	0.10	2.1540	0.011	0.014	0.013	0.017
C 30	2.46	3.21	4.08	5.12	9.37	71.425	0.071	3.3	90.20	0.10	2.5210	0.015	0.018	0.016	0.022
C 35	2.88	3.76	4.77	5.99	11.00	61.036	0.061	3.3	78.029	0.089	2.9520	0.018	0.023	0.021	0.028
C 40	3.38	4.41	5.61	7.03	12.90	51.994	0.051	3.3	67.640	0.089	3.4550	0.023	0.029	0.026	0.035
C 48	3.95	5.16	6.56	8.23	15.10	44.450	0.043	2.5	57.074	0.089	4.0560	0.030	0.037	0.034	0.045
C 56	4.61	6.02	7.65	9.60	17.60	38.100	0.038	2.0	49.530	0.076	4.7440	0.037	0.046	0.042	0.056
C 65	5.40	7.05	8.96	11.20	20.60	32.537	0.033	2.0	42.164	0.076	5.5340	0.047	0.059	0.053	0.071
C 76	6.32	8.26	10.50	13.20	24.10	27.788	0.028	1.7	36.601	0.076	6.4800	0.060	0.074	0.068	0.090
C 89	7.37	9.63	12.20	15.30	28.10	23.825	0.023	1.7	31.090	0.076	7.5880	0.08	0.094	0.086	0.114
C 104	8.68	11.30	14.40	18.10	33.10	20.244	0.020	1.3	27.127	0.064	8.8500	0.10	0.12	0.11	0.144
C 120	10.00	13.10	16.70	20.90	38.30	17.475	0.018	1.3	22.784	0.064	10.42	0.12	0.15	0.14	0.18
C 140	11.60	15.20	19.30	24.20	44.40	17.628	0.015	1.0	20.015	0.064	12.07	0.15	0.19	0.17	0.23
C 165	13.80	18.10	22.90	28.80	52.70	12.700	0.013	1.0	17.120	0.051	13.98	0.11	0.13	0.12	0.16
C 190	15.80	20.60	26.20	32.90	60.20	11.125	0.010	1.0	14.732	0.051	16.61	0.25	0.30	0.28	0.37
C 220	18.40	24.10	30.60	38.40	70.30	9.525	0.010	0.76	13.106	0.051	18.95	0.30	0.37	0.34	0.45
C 255	21.10	27.50	35.00	43.90	80.40	8.3312	0.0076	0.76	11.049	0.051	22.14	0.38	0.47	0.43	0.57
C 290	24.60	32.20	40.80	51.20	93.80	7.1374	0.0076	0.76	9.855	0.051	25.31	0.46	0.57	0.52	0.69
C 330	27.70	36.10	45.90	57.60	105.00	6.3500	0.0076	0.51	8.661	0.051	29.54	0.58	0.72	0.66	0.88
C 380	31.60	41.30	52.40	65.70	120.00	5.5626	0.0076	0.51	7.366	0.051	33.20	0.7	0.86	0.79	1.04
C 430	36.80	48.10	61.00	76.60	140.00	4.7752	0.0076	0.51	6.579	0.051	37.91	0.8	1.0	0.96	1.27
C 495	40.20	52.50	66.70	83.70	153.00	4.3688	0.0076	0.51	5.791	0.051	44.16	1.1	1.3	1.2	1.6
C 580	49.10	64.10	81.40	102.00	187.00	3.5814	0.0076	0.51	5.385	0.051	48.26	1.2	1.5	1.4	1.8
C 660	55.30	72.30	91.80	115.00	211.00	3.1750	0.0076	0.38	5.385	0.051	58.88	1.6	2.0	1.9	2.5
C 765	63.50	82.90	105.00	132.00	242.00	2.7686	0.0076	0.38	4.597	0.051	66.41	2.0	2.4	2.2	3.0
C 890	73.60	96.10	122.00	153.00	280.00	2.3876	0.0076	0.38	3.937	0.051	66.41	2.0	2.4	2.2	3.0
C1040	86.8	113	144	181	331	2.0244	0.0076	If necessary, outside dimension should specified.			88.30	3.0	3.7	3.4	4.5
C1650	100	131	167	209	383	1.7475	0.0076				104.16	3.9	4.8	4.4	5.8
C 1400	116	152	193	242	444	1.7628	0.0076				120	4.9	6.1	5.5	7.4
C 1650	138	181	229	288	527	1.2700	0.0076				139.2	3.4	4.2	3.8	5.1
C 1900	158	206	262	329	602	1.1125	0.0076				165.6	7.8	9.7	8.9	11.8
C 2200	184	241	306	384	703	0.9525	0.0076				189.6	9.5	11.7	10.7	14.2
C 2550	211	275	350	439	804	0.8331	0.0076				220.8	12.0	14.9	13.6	18.1
C 2900	246	322	408	512	938	0.7137	0.0076				253.2	14.6	18.1	16.5	21.9
C 3300	277	361	459	576	1050	0.6350	0.0076				295.2	18.5	22.9	20.9	27.8
C 3800	316	413	524	657	1200	0.5563	0.0076				332.4	21.9	27.1	24.8	32.9
C 4300	368	481	610	766	1400	0.4775	0.0076	379.2	26.7	33.2	30.3	40.2			
C 4950	402	525	667	837	1530	0.4369	0.0076	441.6	33.6	41.7	38.1	50.6			
C 5800	491	641	814	1020	1870	0.3581	0.0076	482.4	38.5	47.8	43.6	58.0			
C 6600	553	723	918	1150	2110	0.3175	0.0076	589.2	51.7	64.1	58.5	77.8			
C 7650	635	829	1050	1320	2420	0.2769	0.0076	663.6	62.2	77.2	70.5	93.6			
C 8900	736	961	1220	1530	2800	0.2388	0.0076	762	76	94.4	86.2	114.5			
C10400	868	1130	1440	1810	3310	0.2024	0.0076	883.2	95	118	108	143.2			
C16500	1000	1310	1670	2090	3830	0.1748	0.0076	1041.6	122	151	138	183			
C 14000	1160	1520	1930	2420	4440	0.1763	0.0076	1200	155	192	175	233			
C 16500	1380	1810	2290	2880	5270	0.1270	0.0076	1392	107	133	122	162			
C 19000	1580	2060	2620	3290	6020	0.1113	0.0076	1656	247	307	280	372			
C 22000	1840	2410	3060	3840	7030	0.0953	0.0076	1896	299	371	339	450			
C 25500	2110	2750	3500	4390	8040	0.0833	0.0076	2208	381	472	431	573			
C 29000	2460	3220	4080	5120	9380	0.0714	0.0076	2532	461	572	522	694			
											2952	584	724	661	878

Table 2 – Circular waveguides



Dimensions in millimetres

Type designation	Cut-off frequency in GHz for the mode					Inside cross-section		Basic wall thickness	Outside cross-section		Theoretical value of attenuation in dB/m					
	TE ₁₁	TM ₀₁	TE ₂₁	TE ₀₁	TE ₀₂	Basic diameter D	Deviation		Basic diameter	Deviation	Frequency in GHz	Standard Copper	Aluminium	Gold	Brass	
C 3.3	0.27	0.35	0.45	0.56	1.03	647.90	0.64	For subsequent study			0.325	0.0007	0.00084	0.00077	0.00102	
C 4	0.32	0.41	0.53	0.66	1.21	553.49	0.56				0.38	0.0009	0.0011	0.0010	0.0010	0.00129
C 4.5	0.37	0.48	0.62	0.77	1.42	472.85	0.48				0.446	0.0011	0.0013	0.0012	0.0012	0.0016
C 5.3	0.43	0.57	0.72	0.90	1.66	403.94	0.41				0.522	0.0014	0.0017	0.0015	0.0015	0.0021
C 6.2	0.51	0.66	0.84	1.06	1.94	345.06	0.36				0.611	0.0017	0.0021	0.0020	0.0020	0.0026
C 7	0.60	0.78	0.99	1.24	2.27	294.79	0.30				0.715	0.0022	0.0027	0.0025	0.0025	0.0033
C 8	0.70	0.91	1.16	1.45	2.66	251.84	0.25				0.838	0.0028	0.0034	0.0031	0.0031	0.0042
C 10	0.82	1.07	1.35	1.70	3.11	215.14	0.22				0.98	0.0035	0.0044	0.0040	0.0040	0.0053
C 12	0.96	1.25	1.59	1.99	3.64	183.77	0.18				1.147	0.0045	0.0055	0.0051	0.0051	0.0067
C 14	1.12	1.46	1.86	2.33	4.26	157.00	0.16				1.343	0.0056	0.0070	0.0064	0.0064	0.0085
C 16	1.31	1.71	2.17	2.73	4.99	134.11	0.13	1.572	0.007	0.0089	0.0081	0.0081	0.0108			
C 18	1.53	2.00	2.54	3.19	5.84	114.58	0.11	1.8410	0.009	0.011	0.010	0.010	0.0136			
C 22	1.79	2.34	2.98	3.74	6.84	97.87	0.10	3.3	121.21	0.13	1.8410	0.009	0.011	0.010		
C 25	2.10	2.74	3.49	4.37	8.01	83.617	0.081	3.3	104.50	0.10	2.1540	0.011	0.014	0.013	0.017	
C 30	2.46	3.21	4.08	5.12	9.37	71.425	0.071	3.3	90.20	0.10	2.5210	0.015	0.018	0.016	0.022	
C 35	2.88	3.76	4.77	5.99	11.00	61.036	0.061	3.3	78.029	0.089	2.9520	0.018	0.023	0.021	0.028	
C 40	3.38	4.41	5.61	7.03	12.90	51.994	0.051	3.3	67.640	0.089	3.4550	0.023	0.029	0.026	0.035	
C 48	3.95	5.16	6.56	8.23	15.10	44.450	0.043	2.5	57.074	0.089	4.0560	0.030	0.037	0.034	0.045	
C 56	4.61	6.02	7.65	9.60	17.60	38.100	0.038	2.0	49.530	0.076	4.7440	0.037	0.046	0.042	0.056	
C 65	5.40	7.05	8.96	11.20	20.60	32.537	0.033	2.0	42.164	0.076	5.5340	0.047	0.059	0.053	0.071	
C 76	6.32	8.26	10.50	13.20	24.10	27.788	0.028	1.7	36.601	0.076	6.4800	0.060	0.074	0.068	0.090	
C 89	7.37	9.63	12.20	15.30	28.10	23.825	0.023	1.7	31.090	0.076	7.5880	0.08	0.094	0.086	0.114	
C 104	8.68	11.30	14.40	18.10	33.10	20.244	0.020	1.3	27.127	0.064	8.8500	0.10	0.12	0.11	0.144	
C 120	10.00	13.10	16.70	20.90	38.30	17.475	0.018	1.3	22.784	0.064	10.42	0.12	0.15	0.14	0.18	
C 140	11.60	15.20	19.30	24.20	44.40	17.628	0.015	1.0	20.015	0.064	12.07	0.15	0.19	0.17	0.23	
C 165	13.80	18.10	22.90	28.80	52.70	12.700	0.013	1.0	17.120	0.051	13.98	0.11	0.13	0.12	0.16	
C 190	15.80	20.60	26.20	32.90	60.20	11.125	0.010	1.0	14.732	0.051	16.61	0.25	0.30	0.28	0.37	
C 220	18.40	24.10	30.60	38.40	70.30	9.525	0.010	0.76	13.106	0.051	18.95	0.30	0.37	0.34	0.45	
C 255	21.10	27.50	35.00	43.90	80.40	8.3312	0.0076	0.76	11.049	0.051	22.14	0.38	0.47	0.43	0.57	
C 290	24.60	32.20	40.80	51.20	93.80	7.1374	0.0076	0.76	9.855	0.051	25.31	0.46	0.57	0.52	0.69	
C 330	27.70	36.10	45.90	57.60	105.00	6.3500	0.0076	0.51	8.661	0.051	29.54	0.58	0.72	0.66	0.88	
C 380	31.60	41.30	52.40	65.70	120.00	5.5626	0.0076	0.51	7.366	0.051	33.20	0.7	0.86	0.79	1.04	
C 430	36.80	48.10	61.00	76.60	140.00	4.7752	0.0076	0.51	6.579	0.051	37.91	0.8	1.0	0.96	1.27	
C 495	40.20	52.50	66.70	83.70	153.00	4.3688	0.0076	0.51	5.791	0.051	44.16	1.1	1.3	1.2	1.6	
C 580	49.10	64.10	81.40	102.00	187.00	3.5814	0.0076	0.51	5.385	0.051	48.26	1.2	1.5	1.4	1.8	
C 660	55.30	72.30	91.80	115.00	211.00	3.1750	0.0076	0.38	4.597	0.051	58.88	1.6	2.0	1.9	2.5	
C 765	63.50	82.90	105.00	132.00	242.00	2.7686	0.0076	0.38	3.937	0.051	66.41	2.0	2.4	2.2	3.0	
C 890	73.60	96.10	122.00	153.00	280.00	2.3876	0.0076	0.38	3.531	0.051	76.15	2.4	3.0	2.7	3.6	
C1040	86.8	113	144	181	331	2.0244	0.0076	0.38	3.150	0.051	88.30	3.0	3.7	3.4	4.5	
C1650	100	131	167	209	383	1.7475	0.0076	0.38	3.150	0.051	104.16	3.9	4.8	4.4	5.8	
C 1400	116	152	193	242	444	1.7628	0.0076	0.38	3.150	0.051	120	4.9	6.1	5.5	7.4	
C 1650	138	181	229	288	527	1.2700	0.0076	0.38	3.150	0.051	139.2	3.4	4.2	3.8	5.1	
C 1900	158	206	262	329	602	1.1125	0.0076	0.38	3.150	0.051	165.6	7.8	9.7	8.9	11.8	
C 2200	184	241	306	384	703	0.9525	0.0076	0.38	3.150	0.051	189.6	9.5	11.7	10.7	14.2	
C 2550	211	275	350	439	804	0.8331	0.0076	0.38	3.150	0.051	220.8	12.0	14.9	13.6	18.1	
C 2900	246	322	408	512	938	0.7137	0.0076	0.38	3.150	0.051	253.2	14.6	18.1	16.5	21.9	
C 3300	277	361	459	576	1050	0.6350	0.0076	0.38	3.150	0.051	295.2	18.5	22.9	20.9	27.8	
C 3800	316	413	524	657	1200	0.5563	0.0076	0.38	3.150	0.051	332.4	21.9	27.1	24.8	32.9	
C 4300	368	481	610	766	1400	0.4775	0.0076	0.38	3.150	0.051	379.2	26.7	33.2	30.3	40.2	
C 4950	402	525	667	837	1530	0.4369	0.0076	0.38	3.150	0.051	441.6	33.6	41.7	38.1	50.6	
C 5800	491	641	814	1020	1870	0.3581	0.0076	0.38	3.150	0.051	482.4	38.5	47.8	43.6	58.0	
C 6600	553	723	918	1150	2110	0.3175	0.0076	0.38	3.150	0.051	589.2	51.7	64.1	58.5	77.8	
C 7650	635	829	1050	1320	2420	0.2769	0.0076	0.38	3.150	0.051	663.6	62.2	77.2	70.5	93.6	
C 8900	736	961	1220	1530	2800	0.2388	0.0076	0.38	3.150	0.051	762	76	94.4	86.2	114.5	
C10400	868	1130	1440	1810	3310	0.2024	0.0076	0.38	3.150	0.051	883.2	95	118	108	143.2	
C16500	1000	1310	1670	2090	3830	0.1748	0.0076	0.38	3.150	0.051	1041.6	122	151	138	183	
C 14000	1160	1520	1930	2420	4440	0.1763	0.0076	0.38	3.150	0.051	1200	155	192	175	233	
C 16500	1380	1810	2290	2880	5270	0.1270	0.0076	0.38	3.150	0.051	1392	107	133	122	162	
C 19000	1580	2060	2620	3290	6020	0.1113	0.0076	0.38	3.150	0.051	1656	247	307	280	372	
C 22000	1840	2410	3060	3840	7030	0.0953	0.0076	0.38	3.150	0.051	1896	299	371	339	450	
C 25500	2110	2750	3500	4390	8040	0.0833	0.0076	0.38	3.150	0.051	2208	381	472	431	573	
C 29000	2460	3220	4080	5120	9380	0.0714	0.0076	0.38	3.150	0.051	2532	461	572	522	694	
											2952	584	724	661	878	

If necessary, outside dimension should specified.

5.2.2 Basic diameter deviations

The values of inner diameter deviations specified in Table 1 are based on the general principle as given in Table 3.

Table 3 – Inner Diameter deviations

Range of sizes	Deviation ±
	mm
C 3.3 to C 165	1/1 000 of inside basic diameter
C 190 to C 890	0,010
C 255 to C 29000	0,0078

5.2.3 Ellipticity

The ellipticity “E” is defined as

$$E = \frac{D_{max} - D_{min}}{D_{nom}}$$

Where

D_{nom} = the basic inside diameter

D_{max} = the largest measured inside dimension

D_{min} = the smallest measured inside dimension

The ellipticity E shall not exceed 0,001 at any cross-section for types C 3.3 to C 165 inclusive.

For sizes C 190 and smaller dimensions: the requirement for ellipticity is for further study.

5.2.4 Wall thickness

The basic values specified in Table 1 conform to the following rules.

The basic wall thickness is defined as half the difference between the basic outside and inside dimensions in the original systems of units.

After conversion from inches into mm, the values were rounded to the nearest 0,005 mm.

After conversion from mm into inches, the values were rounded to the nearest 0,001 in.

5.2.5 Eccentricity

The eccentricity is defined as half the difference between the measured thickness of opposite walls. Unless otherwise specified, the eccentricity shall not exceed 10 % of the basic wall thickness. For the determination of the eccentricity, the thicknesses shall be measured where they give the most unfavourable result.

5.2.6 Outside dimensions

The basic values and the deviations are specified in Table 1.

No outside dimensions have been specified for some of the largest sizes because a variety of manufacturing techniques are used.

The values of the outside diameter deviations specified in Table 1 are based on Table 4.

Table 4 – Outer diameter deviations

Range of sizes	Deviation ±
	mm
C 16 and larger dimensions	No deviation specified

C 18	0.13
C 22 – C 25	0.11
C 30 – C 40	0.095
C 48 – C 76	0.080
C 89 – C 120	0.065
C 140 – C 165	0.055
C 190 – C890	0.051
C1040 – C29000	If necessary, outside dimension should be specified.
NOTE Deviations for the sizes C 18 to C 165 inclusive correspond to ISO limit is If.	

5.3 Other mechanical requirements

5.3.1 Bow

Bow is defined as the maximum departure of the actual axis of the waveguide from a straight line of specified length connecting two points on that axis.

The bow is measured on the external surface of the waveguide. For a length of 10 times the internal width, the external bow shall not exceed 10 times the specified deviation on the internal width.

For a length of 50 times the internal width, the external bow shall not exceed 40 times the specified deviation on the internal width.

For the determination of the external bow, the waveguide shall be so positioned that gravity does not tend to affect the amount of bow.

5.3.2 Surface roughness

Under consideration.

5.3.3 Internal stresses

The waveguide tube shall be cut by means of a saw. The cutting process must be carefully controlled so as to avoid distortion arising from the cutting, and the use of a fine high-speed saw is recommended. After cutting, the cross-section of the waveguide tube shall still be within the specified deviations.

6 Electrical tests – Attenuation

The maximum attenuation in the TE₁₁ mode for waveguide IEC – C 104 and waveguides with larger dimensions shall not exceed 1,3 times the value calculated from the formula below at a frequency of 1,2 times the cut-off frequency in the same mode. The values given in the table are for waveguides made of copper with standard conductivity $\sigma_0 = 5.80 \times 10^7$ Siemens / metre.

Circular waveguides (TE₁₁ mode)

$$\alpha = 5,040 \sqrt{\frac{\sigma_0}{\sigma}} \cdot \frac{1}{D^{3/2}} \cdot \frac{1 + 0,4185 \left(\frac{f}{f_c}\right)^2}{\sqrt{\frac{f}{f_c}} \cdot \sqrt{\left(\frac{f}{f_c}\right)^2 - 1}} \quad \text{dB/m}$$

in which:

σ = electrical conductivity of inside non-magnetic wall metal

σ_0 = electrical conductivity of International Annealed copper standard = 5.80×10^7 Siemens / metre.

D = inner diameter in millimetres

f_c = cut-off frequency for TE₁₁ mode = $175.646/D$ GHz at 1013.25 hPa, 23 °C and Relative humidity = 50 % in air

f = frequency at which the attenuation is to be calculated.

For waveguides of smaller dimensions than C 104, the requirements are for further study.

7 Additional tests – Gastightness

Shall conform to the tests specified in IEC 60261.

Bibliography

IEC 60153-1:2016, *Hollow metallic waveguides - Part 1: General requirements and measuring methods*

ISO/IEC 17025:2005, *General requirements for the competence of testing and calibration laboratories*

ISO/IEC Guide 98-1, *Uncertainty of measurement – Part 1: Introduction to the expression of uncertainty in measurement*

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