

ASME B16.18-2012

[Revision of ASME B16.18-2001 (R2005)]

Cast Copper Alloy Solder Joint Pressure Fittings

AN AMERICAN NATIONAL STANDARD



**The American Society of
Mechanical Engineers**

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Three Park Avenue • New York, NY • 10016 USA

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FOREWORD

This American National Standard for solder joint fittings was originally developed by a subcommittee of American Standards Association (ASA) Sectional Committee A40 on Minimum Requirements for Plumbing and Standardization of Plumbing Equipment, organized in August 1928, under the procedures of the ASA. Subcommittee No. 11 on Solder-Joint Fittings for Tubing was appointed in October 1936.

At its first meeting, the subcommittee was informed of the investigation of solder joints being carried out by the National Bureau of Standards (now the National Institute of Standards and Technology). It was decided that the committee's scope should cover only solder fittings for use in plumbing. A subgroup was appointed to study the tolerances of commercial fittings, including depth of bore, laying lengths, and diameters of copper tube.

A draft standard was sent to the subcommittee in February 1939; a revision was distributed in August to selected organizations and individuals for review. A new subcommittee draft dated April 1940 was approved by Sectional Committee A40, the sponsor, and following ASA approval, was published in January 1941 as ASA A40.3-1941.

In 1949, the sponsors agreed to transfer responsibility for solder joint fittings to Sectional Committee B16 of ASA, because the fittings were being used in many applications other than plumbing. Subcommittee 9, Standardization of Solder Joint Fittings was established and charged with developing a revised standard. An April 1949 draft was distributed for industry review, resulting in recommended changes. A new draft was approved by Sectional Committee B16, sponsor organizations, and ASA and published as ASA B16.18-1950.

Work began in 1958 on a revision, including improvements in language. It was approved by B16, sponsor organizations, and ASA and published as ASA B16.18-1963. Starting in 1969, a comprehensive review resulted in revisions to clarify the text and to permit additional material. Final approval was granted by the American National Standards Institute (formerly ASA) on March 2, 1972, for publication as ANSI B16.18-1972.

The subcommittee, now Subcommittee I, began a new revision on 1974, resulting in the addition of supply and return tees, baseboard tees, and flush bushings, as well as metrication, and change of "bronze" to "copper alloy." The draft finally approved was published as ANSI B16.18-1978.

In 1982, American National Standards Committee B16 became the ASME B16 Standards Committee, operating with the same scope under ASME procedures accredited by ANSI. Subsequently, Subcommittee I merged with Subcommittee J, which had a related scope. A general review was then started, resulting in a number of editorial changes and a few pictorial corrections. Table 2 (now Table 3) was updated to three place decimals from four, bringing the table more in line with practical gaging methods. Table B2 (now Table I-3) was correspondingly corrected. Following approval by Subcommittee J, the B16 Standards Committee, and ASME, the American National Standards Institute granted approval on January 13, for publication as ANSI B16.18-1984. The standard was reaffirmed in 1994 with no change.

The 2001 edition of B16.18 contained a defined bursting strength, defined standard gaging method of threaded ends, and other clarifications and updates to text. Following approval by the Standards Committee and ASME, approval as an American National Standard was given on October 17, 2001 with the designation ASME B16.18-2001.

In this edition, new copper alloys were added for potable water applications. Also, references to ASME standards were revised to no longer list specific edition years; the latest edition of ASME publications applies unless stated otherwise. Materials manufactured to other editions of the referenced ASTM standards have been permitted to be used to manufacture fittings meeting the requirements of this Standard as long as the fitting manufacturer verifies the material meets

the requirements of the referenced edition. Following approval by the B16 Standards Committee and the ASME Board on PTCS, this revision to the 2001 edition was approved as an American National Standard by ANSI on January 13, 2012 with the new designation, ASME B16.18-2012.

Requests for interpretations and suggestions for revision should be sent to the Secretary, B16 Committee, The American Society of Mechanical Engineers, Three Park Avenue, New York, NY 10016-5990.

ASME B16 COMMITTEE

Standardization of Valves, Flanges, Fittings, and Gaskets

(The following is the roster of the Committee at the time of approval of this Standard.)

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General. ASME Standards are developed and maintained with the intent to represent the consensus of concerned interests. As such, users of this Standard may interact with the Committee by requesting interpretations, proposing revisions, and attending Committee meetings. Correspondence should be addressed to:

Secretary, B16 Standards Committee
The American Society of Mechanical Engineers
Three Park Avenue
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As an alternative, inquiries may be submitted via email to: SecretaryB16@asme.org.

Proposing Revisions. Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

Proposing a Case. Cases may be issued for the purpose of providing alternative rules when justified, to permit early implementation of an approved revision when the need is urgent, or to provide rules not covered by existing provisions. Cases are effective immediately upon ASME approval and shall be posted on the ASME Committee Web page.

Requests for Cases shall provide a Statement of Need and Background Information. The request should identify the Standard, the paragraph, figure or table number(s), and be written as a Question and Reply in the same format as existing Cases. Requests for Cases should also indicate the applicable edition(s) of the Standard to which the proposed Case applies.

Interpretations. Upon request, the B16 Committee will render an interpretation of any requirement of the Standard. Interpretations can only be rendered in response to a written request sent to the Secretary of the B16 Standards Committee.

The request for interpretation should be clear and unambiguous. It is further recommended that the inquirer submit his/her request in the following format:

Subject:	Cite the applicable paragraph number(s) and the topic of the inquiry.
Edition:	Cite the applicable edition of the Standard for which the interpretation is being requested.
Question:	Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. The inquirer may also include any plans or drawings that are necessary to explain the question; however, they should not contain proprietary names or information.

Requests that are not in this format will be rewritten in this format by the Committee prior to being answered, which may inadvertently change the intent of the original request.

ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME Committee or Subcommittee. ASME does not "approve," "certify," "rate," or "endorse" any item, construction, proprietary device, or activity.

Attending Committee Meetings. The B16 Standards Committee regularly holds meetings, which are open to the public. Persons wishing to attend any meeting should contact the Secretary of the B16 Standards Committee.

ASME B16.18-2012

SUMMARY OF CHANGES

Following approval by the ASME B16 Committee and ASME, and after public review, ASME B16.18-2012 was approved by the American National Standards Institute on January 13, 2012.

ASME B16.18-2012 includes the following changes identified by a margin note, **(12)**. In addition, in the main text, the “General” section was moved to section 2, and the subsequent sections and their paragraphs were renumbered accordingly.

<i>Page</i>	<i>Location</i>	<i>Change</i>
1	5	Revised
2	6	Revised
	9.3	First paragraph deleted
3	11	Revised in its entirety
6	Table 1	(1) All values in 200°F (93°C) column revised (2) Value for Standard Water Tube Size 1¼ at 400°F (204°C) revised
44	Mandatory Appendix II	Updated

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CAST COPPER ALLOY SOLDER JOINT PRESSURE FITTINGS

1 SCOPE

This Standard for cast copper alloy solder joint pressure fittings designed for use with copper water tube establishes requirements for

- (a) pressure–temperature ratings
- (b) abbreviations for end connections
- (c) sizes and method of designating openings of fittings
- (d) marking
- (e) material
- (f) dimensions and tolerances
- (g) tests

2 GENERAL

2.1 Relevant Units

This Standard states values in both SI (Metric) and U.S. Customary units. These systems of units are to be regarded separately as standard. Within the text, the SI units are shown in parentheses or in separate tables that appear in Mandatory Appendix I. The values stated in each system are not exact equivalents; therefore, it is required that each system of units be used independently of the other. Combining values from the two systems constitutes nonconformance with the Standard.

2.2 References

Standards and specifications adopted by reference in this Standard are shown in Mandatory Appendix II, which is part of this Standard. It is not considered practical to identify the specific edition of each standard and specification in the individual references. Instead, the specific edition reference is identified in Mandatory Appendix II.

2.3 Quality System

Requirements relating to the product manufacturer's quality system programs are described in Nonmandatory Appendix C.

3 PRESSURE–TEMPERATURE RATINGS

3.1 Rating of Fitting and of Joint

The internal pressure–temperature ratings of the fittings are shown in Table 1.

The internal pressure–temperature rating for a solder joint fitting is dependent not only on fitting and tube

strength, but also on the composition of the solder used for the joint and selection of valves and appurtenances.

The internal pressure–temperature rating of the system shall be the lowest of the values shown in Table 1, the solder joint, and those of the tube, valves, or appurtenances.

The maximum recommended pressure–temperature ratings for solder joints using the dimensions of Table 3 and Table I-3, made with typical commercial solders, are given in Nonmandatory Appendix A.

3.2 Bursting Strength

Burst strength at $73^{\circ}\text{F} \pm 5^{\circ}\text{F}$ ($23^{\circ}\text{C} \pm 2^{\circ}\text{C}$) shall not be less than four times the 100°F (38°C) internal working-pressure rating shown in Table 1. For reducing fittings, the applicable internal working pressure shall be that of the largest size of end connection.

4 FITTING SIZE AND ENDS

The size of the fittings shown in Table 3 and Table A-1 corresponds to standard water tube size as shown in ASTM B88, Standard Specification for Seamless Copper Water Tube. The size of the threaded ends corresponds to nominal pipe size as shown in ANSI/ASME B1.20.1.

Fittings are designated by the size of the openings in the sequence illustrated in Fig. 1.

The following symbols are used to designate the type of fitting end:

- C* = solder-joint fitting end made to receive copper tube diameter (female)
- F* = internal ANSI standard taper pipe thread (female) NPT
- FTG* = solder-joint fitting end made to copper tube diameter (male)
- M* = external ANSI standard taper pipe thread (male) NPT

5 MARKING

Each fitting shall be permanently marked with the manufacturer's name or trademark and other applicable markings as required by MSS SP-25. Marking of fittings less than Standard Water Tube Size $\frac{1}{2}$, or on any fitting where it damages soldering surfaces is not required.

Fittings manufactured from cast copper alloys containing silicon shall be permanently marked with the designation Si.

(12)

Fittings manufactured from cast copper alloys containing bismuth shall be permanently marked with the designation B or Bi.

(12) 6 MATERIAL

(a) Castings intended for use in applications up to 400°F (204°C) shall be of a copper alloy produced to meet

(1) the requirement of ASTM B62 Alloy C83600

(2) the tensile requirements of ASTM B584 Alloy C83800 or C84400 and in all other respects comply with the requirements of ASTM B62

(b) Castings intended for use in potable water applications, up to 200°F (93°C), shall be either

(1) of a copper alloy produced to meet the requirements of ASTM B584 Alloy C87850 or C89833, or

(2) of other cast copper alloys, provided the fittings produced meet mechanical and corrosion-resistant properties needed for potable water application

7 METAL THICKNESS

Dimensional variations occur in the casting process. Pattern equipment shall be designed to produce the metal thickness given for fittings in Table 3 or Table I-3. The minimum wall-thickness shall not be less than 90% of the body and joint wall-thickness as shown in Table 3 or Table I-3.

8 INSPECTION TOLERANCE

8.1 Convention

For determining conformance with this Standard, the convention for fixing significant digits where limits (maximum or minimum values) are specified shall be as defined in ASTM E29. This requires that an observed or calculated value be rounded off to the nearest unit in the last right-hand digit used for expressing the limit. Decimal values and tolerances do not imply a particular method of measurement.

8.2 Linear Dimensions

An inspection tolerance as shown in Table 2 shall be allowed on center-to-shoulder, center-to-center, center-to-threaded end, and shoulder-to-threaded end dimensions on all fittings having female solder (solder cup) ends, and on center-to-solder end and solder-to-threaded end dimensions on all fittings having male solder (fitting) ends.

Coupling inspection limits for shoulder-to-shoulder and shoulder-to-end dimensions shall be double those shown in Table 2, except that the minus tolerance applied to dimensions M , N , and W , and Tables 7 and I-7 shall not result in a dimension less than 0.06 in. (1.5 mm) for sizes $\frac{1}{4}$ through 1 in., inclusive, or a dimension less than 0.09 in. (2.3 mm) for the larger sizes.

The largest opening in the fitting governs the tolerance to be applied to all openings.

Tables 3 through 19 and Tables I-3 through I-19 offer dimensions for pressure fittings covered by this Standard.

8.3 Ovality

Maximum ovality shall not exceed 1% of the maximum diameters shown in Table 3 or Table I-3. The average of the maximum and minimum diameters must be within the dimensions shown in the table.

8.4 Gaging of Solder Joint Ends

8.4.1 Standard Gaging Method. The standard method of gaging the diameter tolerances for male and female ends shall be by the use of plain plug and ring gages designed to hold the product within the limits established in Table 3 or Table I-3.

8.4.2 Optional Gaging Method. For gaging the diameter tolerance of male and female ends, the manufacturer may use direct reading instruments instead of ring and plug gages as specified in para. 8.4.1. When gaging the diameters of male and female ends using direct reading instruments, refer to para. 8.3.

8.5 Standard Gaging Method of Threaded Ends

The standard method of gaging the external and internal threaded ends shall be in accordance with the requirements of ANSI/ASME B1.20.1.

8.6 Alignment

The maximum-allowable deviation in the angular alignment of any opening shall be 0.06 in./ft (5 mm/m) (0.5%).

9 THREADED ENDS

9.1 Thread Type

Fitting threads shall be right hand, conforming to ANSI/ASME B1.20.1, Pipe Threads, General Purpose (Inch). They shall be taper threads (NPT).

9.2 Countersink or Chamfer

All internal threads shall be countersunk a distance not less than one-half the pitch of the thread at an angle approximately 45 deg with the axis of the thread, and all external threads shall be chamfered at an angle of 30 deg to 45 deg from the axis, for easier entrance in making a joint and protection of the thread. Countersinking and chamfering shall be concentric with the threads.

9.3 Threading Tolerances

Tolerance for an internal threaded end having an internal shoulder shall be from the gage reference point

(12)

(notch) to one turn small. Tolerance for an internal threaded end without shoulder and for an external threaded end shall be from one turn small to one turn large.

9.4 Thread Length

The length of threads specified in all tables shall be measured to include the countersink or chamfer.

10 CONFIGURATION OF THREADED ENDS

At the manufacturer's option, female ends of fittings may be furnished with a polygon or bead with or

without ribs, and male ends of fittings may be furnished with a polygon, ribs, or flats.

11 PRODUCTION TESTING

(12)

Each fitting shall be tested for evidence of leakage by one of the following methods:

(a) Each fitting shall be pressurized with air, or other compressed gas, at 60 psi (410 kPa) while under water for a minimum duration of 5 sec.

(b) Each fitting shall be hydrostatically tested with water at 250 psi (1 720 kPa) for a minimum duration of 15 sec.

Fig. 1 Method of Designating Openings of Fittings

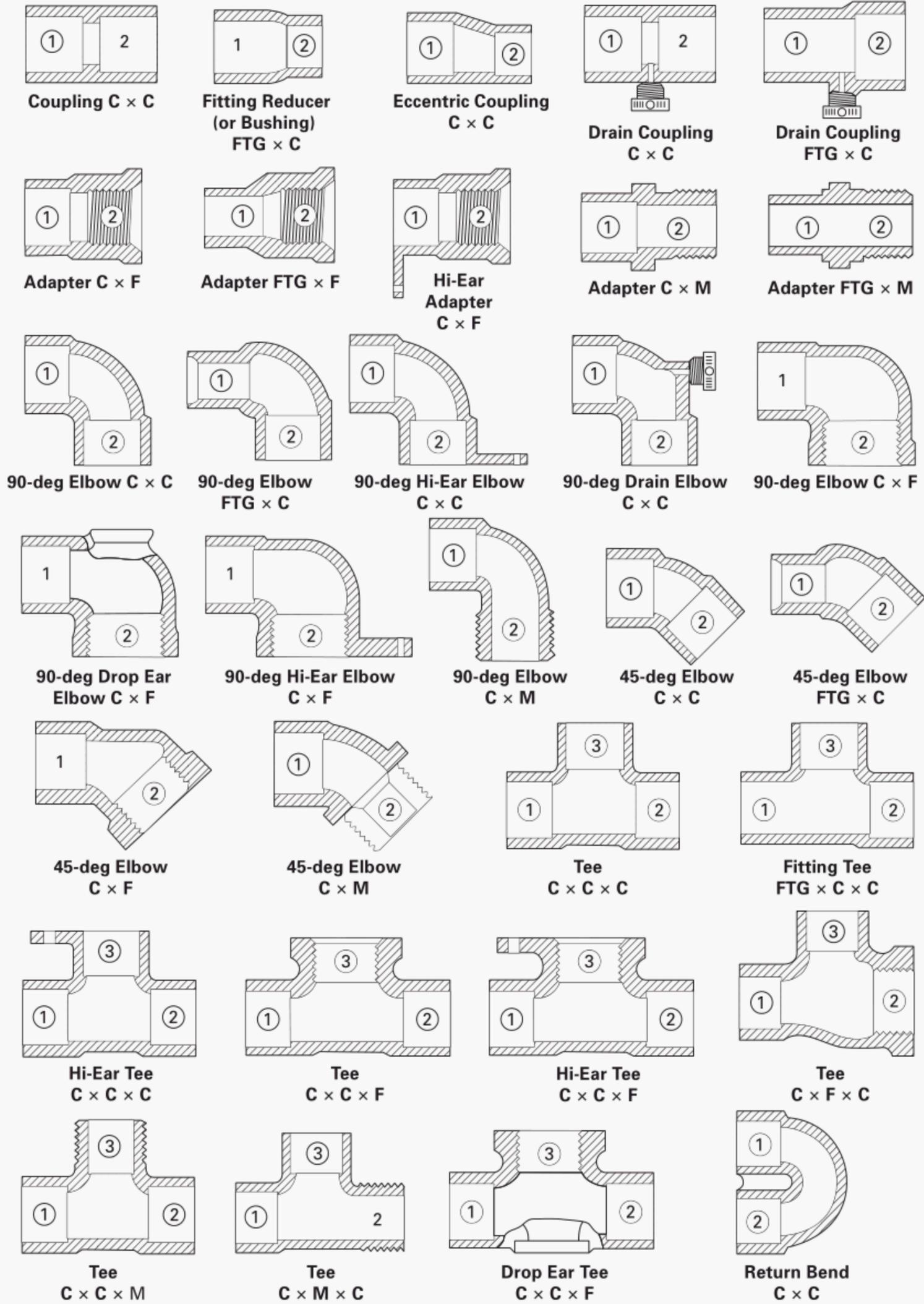
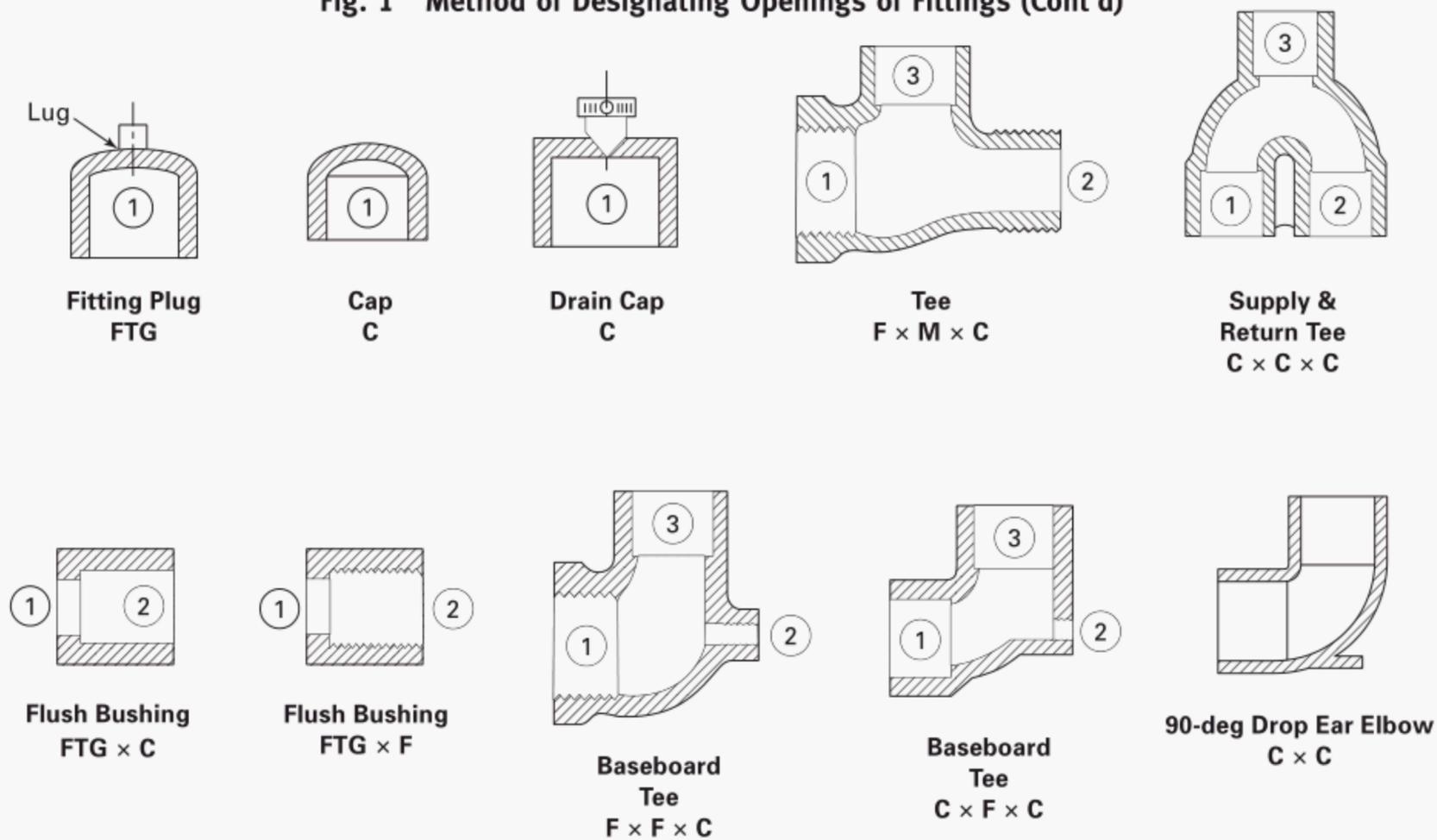


Fig. 1 Method of Designating Openings of Fittings (Cont'd)



GENERAL NOTE: Fittings are designated by size in the order shown — i.e., 1 x 2 x 3.

(12) **Table 1 Internal Pressure–Temperature Ratings for Cast Copper Alloy Fittings, psi (kPa)**

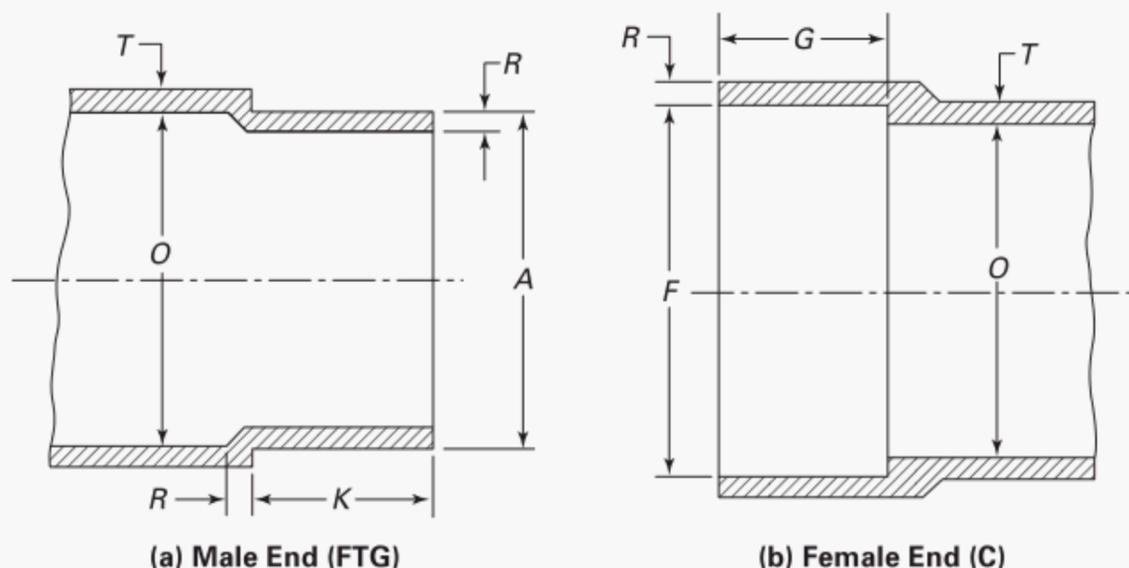
Standard Water Tube Size	–20°F to 100°F (–29°C to 38°C)	150°F (66°C)	200°F (93°C)	250°F (121°C)	300°F (149°C)	350°F (177°C)	400°F (204°C)
1/4	910 (6 280)	770 (5 340)	745 (5 130)	725 (5 020)	710 (4 920)	605 (4 190)	455 (3 140)
3/8	775 (5 360)	660 (4 560)	635 (4 380)	620 (4 290)	610 (4 200)	515 (3 570)	385 (2 680)
1/2	720 (4 970)	610 (4 220)	585 (4 060)	575 (3 980)	565 (3 890)	480 (3 310)	360 (2 480)
5/8	630 (4 350)	535 (3 700)	515 (3 555)	505 (3 480)	490 (3 410)	420 (2 900)	315 (2 170)
3/4	580 (4 010)	490 (3 410)	475 (3 275)	465 (3 210)	455 (3 140)	385 (2 670)	290 (2 000)
1	490 (3 400)	420 (2 890)	400 (2 780)	395 (2 720)	385 (2 660)	325 (2 270)	245 (1 700)
1 1/4	435 (3 020)	370 (2 570)	355 (2 470)	350 (2 420)	340 (2 370)	290 (2 010)	215 (1 510)
1 1/2	405 (2 810)	345 (2 390)	330 (2 300)	325 (2 250)	315 (2 200)	270 (1 870)	200 (1 400)
2	360 (2 500)	305 (2 130)	295 (2 045)	290 (2 000)	280 (1 960)	240 (1 670)	180 (1 250)
2 1/2	335 (2 310)	285 (1 960)	270 (1 890)	265 (1 850)	260 (1 810)	220 (1 540)	165 (1 150)
3	315 (2 180)	265 (1 850)	255 (1 785)	250 (1 740)	245 (1 710)	210 (1 450)	155 (1 090)
3 1/2	300 (2 090)	255 (1 770)	245 (1 705)	240 (1 670)	235 (1 630)	200 (1 390)	150 (1 040)
4	290 (2 020)	245 (1 710)	240 (1 650)	230 (1 610)	225 (1 580)	195 (1 340)	145 (1 010)
5	265 (1 850)	225 (1 570)	220 (1 515)	215 (1 480)	210 (1 450)	175 (1 230)	130 (920)
6	250 (1 720)	210 (1 460)	205 (1 420)	200 (1 380)	195 (1 350)	165 (1 150)	125 (860)
8	270 (1 860)	225 (1 580)	220 (1 520)	215 (1 490)	210 (1 460)	180 (1 240)	135 (930)
10	270 (1 860)	230 (1 580)	220 (1 525)	215 (1 490)	210 (1 460)	180 (1 240)	135 (930)
12	250 (1 740)	215 (1 480)	205 (1 425)	200 (1 390)	195 (1 360)	165 (1 160)	125 (870)

GENERAL NOTES:

- For size designation of fittings, see section 4.
- The internal pressure rating applies to the largest opening of the fitting.
- The internal pressure rating is calculated, as shown in Nonmandatory Appendix B, then rounded down to the nearest unit of 5 for psi and 10 for kPa.

Table 2 Inspection Tolerances

Standard Water Tube and Pipe Thread Size	Plus or Minus	
	in.	mm
$\frac{1}{4}$, $\frac{3}{8}$	0.05	1.3
$\frac{1}{2}$, $\frac{3}{4}$	0.06	1.5
1 to 2 incl.	0.08	2.0
$2\frac{1}{2}$ to $3\frac{1}{2}$ incl.	0.11	2.8
4, 5	0.12	3.2
6, 8	0.16	4.0
10, 12	0.20	5.2

Table 3 Dimensions of Solder Joint Ends

Standard Water Tube Size [Note (1)]	Male End			Female End			Metal Thickness [Note (3)]		Minimum Inside Diameter of Fitting, <i>O</i>
	Outside Diameter [Note (2)], <i>A</i>		Minimum Length, <i>K</i>	Inside Diameter, <i>F</i>		Minimum Depth, <i>G</i>	Body, <i>T</i>	Joint, <i>R</i>	
	Min.	Max.		Min.	Max.				
1/4	0.373	0.376	0.38	0.377	0.381	0.31	0.08	0.05	0.31
3/8	0.497	0.501	0.44	0.502	0.506	0.38	0.09	0.05	0.43
1/2	0.622	0.626	0.56	0.627	0.631	0.50	0.09	0.05	0.54
3/4	0.872	0.876	0.81	0.877	0.881	0.75	0.10	0.06	0.78
1	1.122	1.127	0.97	1.128	1.132	0.91	0.11	0.07	1.02
1 1/4	1.372	1.377	1.03	1.378	1.382	0.97	0.12	0.07	1.26
1 1/2	1.621	1.627	1.16	1.628	1.633	1.09	0.13	0.08	1.50
2	2.121	2.127	1.41	2.128	2.133	1.34	0.15	0.09	1.98
2 1/2	2.621	2.627	1.53	2.628	2.633	1.47	0.17	0.10	2.46
3	3.121	3.127	1.72	3.128	3.133	1.66	0.19	0.11	2.94
3 1/2	3.621	3.627	1.97	3.628	3.633	1.91	0.20	0.12	3.42
4	4.121	4.127	2.22	4.128	4.133	2.16	0.22	0.13	3.90
5	5.121	5.127	2.72	5.128	5.133	2.66	0.28	0.17	4.87
6	6.121	6.127	3.22	6.128	6.133	3.09	0.34	0.20	5.84
8	8.119	8.127	4.09	8.128	8.133	3.97	0.38	0.31	7.72
10	10.119	10.127	4.12	10.128	10.133	4.00	0.48	0.48	9.62
12	12.119	12.127	4.62	12.128	12.133	4.50	0.56	0.56	11.56

GENERAL NOTES:

(a) Dimensions are in inches.

(b) The sketches and designs of fittings are illustrative only. Dimensions herein shall govern in all cases.

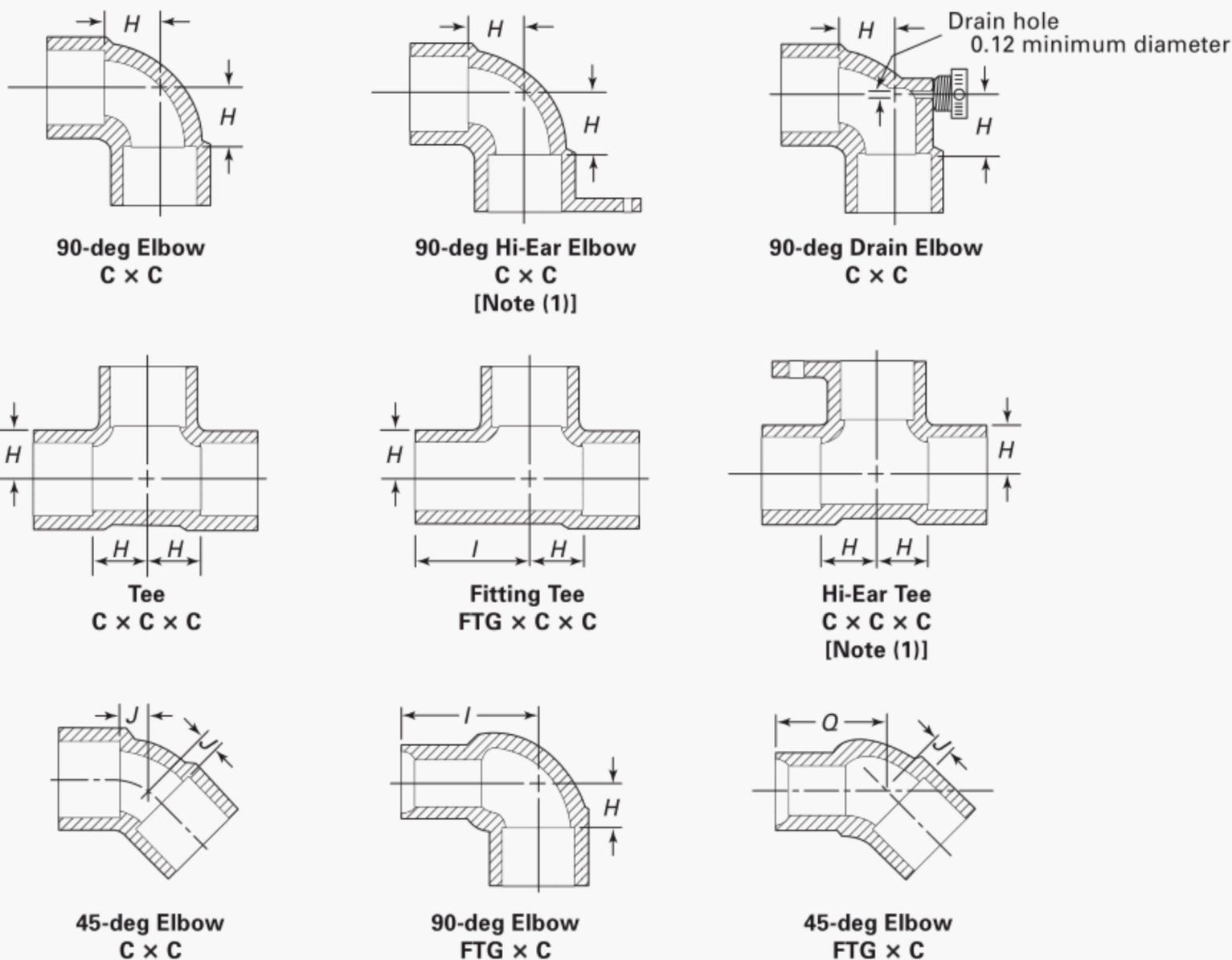
NOTES:

(1) For size designation of fitting, see section 4.

(2) For ovality and gaging tolerances, see section 8.

(3) For metal thickness, see section 7.

Table 4 Dimensions of Elbows, Tees, and 45-deg Elbows



Standard Water Tube Size [Note (2)]	Laying Length Tee and 90-deg Elbow [Note (3)], H	Center-to-End 90-deg Elbow and Tee [Note (3)], I	Laying Length 45-deg Elbow [Note (3)], J	Center-to-End 45-deg Elbow [Note (3)], Q
1/4	0.25	0.75
3/8	0.31	0.88	0.19	0.75
1/2	0.44	1.12	0.19	0.88
3/4	0.56	1.50	0.25	1.19
1	0.75	1.84	0.31	1.31
1 1/4	0.88	2.03	0.44	1.56
1 1/2	1.00	2.28	0.50	1.75
2	1.25	2.78	0.56	2.12
2 1/2	1.50	3.16	0.62	...
3	1.75	3.59	0.75	...
3 1/2	2.00	...	0.88	...
4	2.25	4.59	0.94	...
5	3.12	...	1.44	...
6	3.62	...	1.62	...
8	4.88	...	2.12	...

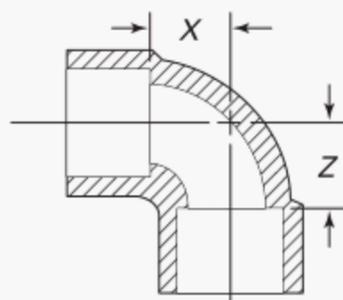
Table 4 Dimensions of Elbows, Tees, and 45-deg Elbows (Cont'd)

GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.

NOTES:

- (1) Hi-ear fittings are designed for use with $\frac{9}{16}$ in. maximum width strap.
- (2) For size designation of fitting, see section 4.
- (3) For inspection tolerances, see section 8 and Table 2.

Table 5 Dimensions of Reducing 90-deg Elbows**90-deg Elbow
C × C**

Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]	
	X	Z
$\frac{3}{8} \times \frac{1}{4}$	0.25	0.31
$\frac{1}{2} \times \frac{3}{8}$	0.38	0.44
$\frac{3}{4} \times \frac{1}{2}$	0.44	0.56
$1 \times \frac{3}{4}$	0.62	0.75
$1 \times \frac{1}{2}$	0.50	0.75
$1\frac{1}{4} \times 1$	0.75	0.88
$1\frac{1}{4} \times \frac{3}{4}$	0.62	0.88
$1\frac{1}{4} \times \frac{1}{2}$	0.50	0.88
$1\frac{1}{2} \times 1\frac{1}{4}$	0.88	1.00
$1\frac{1}{2} \times 1$	0.75	1.00
$1\frac{1}{2} \times \frac{3}{4}$	0.62	1.00
$2 \times 1\frac{1}{2}$	1.00	1.25
$2 \times 1\frac{1}{4}$	0.88	1.25
2×1	0.75	1.25
$2 \times \frac{3}{4}$	0.62	1.25
$2\frac{1}{2} \times 2$	1.25	1.50
$2\frac{1}{2} \times 1\frac{1}{2}$	1.00	1.50
$2\frac{1}{2} \times 1\frac{1}{4}$	0.88	1.50
$2\frac{1}{2} \times 1$	0.75	1.50
$3 \times 2\frac{1}{2}$	1.50	1.75
3×2	1.25	1.75
$3 \times 1\frac{1}{2}$	1.00	1.75
$3 \times 1\frac{1}{4}$	0.88	1.75
4×3	1.75	2.25
$4 \times 2\frac{1}{2}$	1.50	2.25
4×2	1.25	2.25
6×4	2.62	3.62
6×3	2.00	3.62
8×6	3.88	4.88

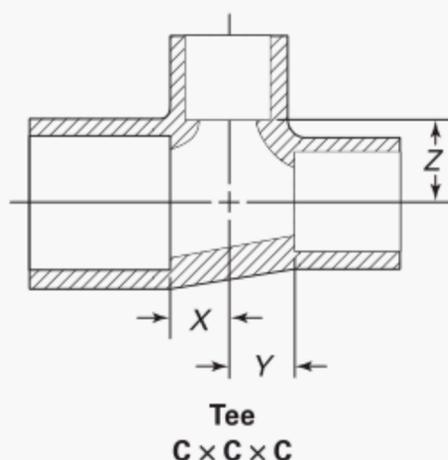
GENERAL NOTES:

- (a) Dimensions are in inches.
 (b) For dimensions not given in this table, see Table 3.

NOTES:

- (1) For size designation of fitting, see section 4.
 (2) For inspection tolerances, see section 8 and Table 2.

Table 6 Dimensions of Reducing Tees



Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]			Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]		
	X	Y	Z		X	Y	Z
$\frac{3}{8} \times \frac{3}{8} \times \frac{1}{2}$	0.44	0.44	0.38	$1\frac{1}{4} \times \frac{3}{4} \times \frac{3}{4}$	0.62	0.62	0.88
$\frac{3}{8} \times \frac{3}{8} \times \frac{1}{4}$	0.25	0.25	0.31	$1\frac{1}{4} \times \frac{1}{2} \times 1\frac{1}{4}$	0.88	0.88	0.88
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{4}$	0.56	0.56	0.44	$1\frac{1}{4} \times \frac{1}{2} \times 1$	0.75	0.75	0.88
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{8}$	0.38	0.38	0.44	$1\frac{1}{2} \times 1\frac{1}{2} \times 2\frac{1}{2}$	1.50	1.50	1.00
$\frac{1}{2} \times \frac{1}{2} \times \frac{1}{4}$	0.31	0.31	0.44	$1\frac{1}{2} \times 1\frac{1}{2} \times 2$	1.25	1.25	1.00
$\frac{1}{2} \times \frac{3}{8} \times \frac{1}{2}$	0.44	0.44	0.44	$1\frac{1}{2} \times 1\frac{1}{2} \times 1\frac{1}{4}$	0.88	0.88	1.00
$\frac{1}{2} \times \frac{3}{8} \times \frac{3}{8}$	0.38	0.38	0.44	$1\frac{1}{2} \times 1\frac{1}{2} \times 1$	0.75	0.75	1.00
$\frac{3}{4} \times \frac{3}{4} \times 1$	0.75	0.75	0.62	$1\frac{1}{2} \times 1\frac{1}{2} \times \frac{3}{4}$	0.62	0.62	1.00
$\frac{3}{4} \times \frac{3}{4} \times \frac{1}{2}$	0.44	0.44	0.56	$1\frac{1}{2} \times 1\frac{1}{2} \times \frac{1}{2}$	0.50	0.50	1.00
$\frac{3}{4} \times \frac{3}{4} \times \frac{3}{8}$	0.38	0.38	0.56	$1\frac{1}{2} \times 1\frac{1}{4} \times 1\frac{1}{2}$	1.00	1.00	1.00
$\frac{3}{4} \times \frac{1}{2} \times \frac{3}{4}$	0.56	0.56	0.56	$1\frac{1}{2} \times 1\frac{1}{4} \times 1\frac{1}{4}$	0.88	0.88	1.00
$\frac{3}{4} \times \frac{1}{2} \times \frac{1}{2}$	0.44	0.44	0.56	$1\frac{1}{2} \times 1\frac{1}{4} \times 1$	0.75	0.75	1.00
$\frac{3}{4} \times \frac{1}{2} \times \frac{3}{8}$	0.38	0.38	0.56	$1\frac{1}{2} \times 1\frac{1}{4} \times \frac{3}{4}$	0.62	0.62	1.00
$1 \times 1 \times 1\frac{1}{2}$	1.00	1.00	0.75	$1\frac{1}{2} \times 1\frac{1}{4} \times \frac{1}{2}$	0.50	0.50	1.00
$1 \times 1 \times 1\frac{1}{4}$	0.88	0.88	0.75	$1\frac{1}{2} \times 1 \times 1\frac{1}{2}$	1.00	1.00	1.00
$1 \times 1 \times \frac{3}{4}$	0.62	0.62	0.75	$1\frac{1}{2} \times 1 \times 1\frac{1}{4}$	0.88	0.88	1.00
$1 \times 1 \times \frac{1}{2}$	0.50	0.50	0.75	$1\frac{1}{2} \times 1 \times 1$	0.75	0.75	1.00
$1 \times 1 \times \frac{3}{8}$	0.44	0.44	0.75	$1\frac{1}{2} \times \frac{3}{4} \times 1\frac{1}{2}$	1.00	1.00	1.00
$1 \times \frac{3}{4} \times 1$	0.75	0.75	0.75	$1\frac{1}{2} \times \frac{1}{2} \times 1\frac{1}{2}$	1.00	1.00	1.00
$1 \times \frac{3}{4} \times \frac{3}{4}$	0.62	0.62	0.75	$2 \times 2 \times 4$	2.25	2.25	1.25
$1 \times \frac{3}{4} \times \frac{1}{2}$	0.50	0.50	0.75	$2 \times 2 \times 3$	1.75	1.75	1.25
$1 \times \frac{1}{2} \times 1$	0.75	0.75	0.75	$2 \times 2 \times 2\frac{1}{2}$	1.50	1.50	1.25
$1 \times \frac{1}{2} \times \frac{3}{4}$	0.62	0.62	0.75	$2 \times 2 \times 1\frac{1}{2}$	1.00	1.00	1.25
$1 \times \frac{1}{2} \times \frac{1}{2}$	0.50	0.50	0.75	$2 \times 2 \times 1\frac{1}{4}$	0.88	0.88	1.25
$1\frac{1}{4} \times 1\frac{1}{4} \times 2$	1.25	1.25	0.88	$2 \times 2 \times 1$	0.75	0.75	1.25
$1\frac{1}{4} \times 1\frac{1}{4} \times 1\frac{1}{2}$	1.00	1.00	0.88	$2 \times 2 \times \frac{3}{4}$	0.62	0.62	1.25
$1\frac{1}{4} \times 1\frac{1}{4} \times 1$	0.75	0.75	0.88	$2 \times 2 \times \frac{1}{2}$	0.50	0.50	1.25
$1\frac{1}{4} \times 1\frac{1}{4} \times \frac{3}{4}$	0.62	0.62	0.88	$2 \times 1\frac{1}{2} \times 2$	1.25	1.25	1.25
$1\frac{1}{4} \times 1\frac{1}{4} \times \frac{1}{2}$	0.50	0.50	0.88	$2 \times 1\frac{1}{2} \times 1\frac{1}{2}$	1.00	1.00	1.25
$1\frac{1}{4} \times 1 \times 1\frac{1}{4}$	0.88	0.88	0.88	$2 \times 1\frac{1}{2} \times 1\frac{1}{4}$	0.88	0.88	1.25
$1\frac{1}{4} \times 1 \times 1$	0.75	0.75	0.88	$2 \times 1\frac{1}{2} \times 1$	0.75	0.75	1.25
$1\frac{1}{4} \times 1 \times \frac{3}{4}$	0.62	0.62	0.88	$2 \times 1\frac{1}{2} \times \frac{3}{4}$	0.62	0.62	1.25
$1\frac{1}{4} \times 1 \times \frac{1}{2}$	0.50	0.50	0.88	$2 \times 1\frac{1}{2} \times \frac{1}{2}$	0.50	0.50	1.25
$1\frac{1}{4} \times \frac{3}{4} \times 1\frac{1}{4}$	0.88	0.88	0.88	$2 \times 1\frac{1}{4} \times 2$	1.25	1.25	1.25
$1\frac{1}{4} \times \frac{3}{4} \times 1$	0.75	0.75	0.88	$2 \times 1\frac{1}{4} \times 1\frac{1}{2}$	1.00	1.00	1.25

Table 6 Dimensions of Reducing Tees (Cont'd)

Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]			Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]		
	X	Y	Z		X	Y	Z
$2 \times 1\frac{1}{4} \times 1\frac{1}{4}$	0.88	0.88	1.25	$3 \times 2 \times 1\frac{1}{2}$	1.00	1.00	1.75
$2 \times 1 \times 2$	1.25	1.25	1.25	$3 \times 1\frac{1}{2} \times 3$	1.75	1.75	1.75
$2 \times \frac{3}{4} \times 2$	1.25	1.25	1.25	$3 \times 1\frac{1}{4} \times 3$	1.75	1.75	1.75
$2 \times \frac{1}{2} \times 2$	1.25	1.25	1.25	$3 \times 1 \times 3$	1.75	1.75	1.75
$2\frac{1}{2} \times 2\frac{1}{2} \times 4$	2.25	2.25	1.50	$3\frac{1}{2} \times 3\frac{1}{2} \times 3$	1.75	1.75	2.00
$2\frac{1}{2} \times 2\frac{1}{2} \times 3$	1.75	1.75	1.50	$3\frac{1}{2} \times 3 \times 3\frac{1}{2}$	2.00	2.00	2.00
$2\frac{1}{2} \times 2\frac{1}{2} \times 2$	1.25	1.25	1.50	$4 \times 4 \times 6$	3.62	3.62	2.62
$2\frac{1}{2} \times 2\frac{1}{2} \times 1\frac{1}{2}$	1.00	1.00	1.50	$4 \times 4 \times 3$	1.75	1.75	2.25
$2\frac{1}{2} \times 2\frac{1}{2} \times 1\frac{1}{4}$	0.88	0.88	1.50	$4 \times 4 \times 2\frac{1}{2}$	1.50	1.50	2.25
$2\frac{1}{2} \times 2\frac{1}{2} \times 1$	0.75	0.75	1.50	$4 \times 4 \times 2$	1.25	1.25	2.25
$2\frac{1}{2} \times 2\frac{1}{2} \times \frac{3}{4}$	0.62	0.62	1.50	$4 \times 4 \times 1\frac{1}{2}$	1.00	1.00	2.25
$2\frac{1}{2} \times 2\frac{1}{2} \times \frac{1}{2}$	0.50	0.50	1.50	$4 \times 4 \times 1\frac{1}{4}$	0.88	0.88	2.25
$2\frac{1}{2} \times 2 \times 2\frac{1}{2}$	1.50	1.50	1.50	$4 \times 4 \times 1$	0.75	0.75	2.25
$2\frac{1}{2} \times 2 \times 2$	1.25	1.25	1.50	$4 \times 4 \times \frac{3}{4}$	0.62	0.62	2.25
$2\frac{1}{2} \times 2 \times 1\frac{1}{2}$	1.00	1.00	1.50	$4 \times 3 \times 4$	2.25	2.25	2.25
$2\frac{1}{2} \times 2 \times 1\frac{1}{4}$	0.88	0.88	1.50	$4 \times 3 \times 3$	1.75	1.75	2.25
$2\frac{1}{2} \times 2 \times 1$	0.75	0.75	1.50	$4 \times 3 \times 2\frac{1}{2}$	1.50	1.50	2.25
$2\frac{1}{2} \times 2 \times \frac{3}{4}$	0.62	0.62	1.50	$4 \times 3 \times 2$	1.25	1.25	2.25
$2\frac{1}{2} \times 2 \times \frac{1}{2}$	0.50	0.50	1.50	$4 \times 2\frac{1}{2} \times 4$	2.25	2.25	2.25
$2\frac{1}{2} \times 1\frac{1}{2} \times 2\frac{1}{2}$	1.50	1.50	1.50	$4 \times 2 \times 4$	2.25	2.25	2.25
$2\frac{1}{2} \times 1\frac{1}{2} \times 2$	1.25	1.25	1.50	$4 \times 2 \times 3$	1.75	1.75	2.25
$2\frac{1}{2} \times 1\frac{1}{2} \times 1\frac{1}{2}$	1.00	1.00	1.50	$4 \times 2 \times 2$	1.25	1.25	2.25
$2\frac{1}{2} \times 1\frac{1}{4} \times 2\frac{1}{2}$	1.50	1.50	1.50	$4 \times 1\frac{1}{2} \times 4$	2.25	2.25	2.25
$2\frac{1}{2} \times 1 \times 2\frac{1}{2}$	1.50	1.50	1.50	$4 \times 1\frac{1}{4} \times 4$	2.25	2.25	2.25
$2\frac{1}{2} \times \frac{3}{4} \times 2\frac{1}{2}$	1.50	1.50	1.50	$4 \times 1 \times 4$	2.25	2.25	2.25
$2\frac{1}{2} \times \frac{1}{2} \times 2\frac{1}{2}$	1.50	1.50	1.50	$5 \times 5 \times 4$	2.62	2.62	3.12
$3 \times 3 \times 4$	2.25	2.25	1.75	$5 \times 4 \times 5$	3.12	3.12	3.12
$3 \times 3 \times 2\frac{1}{2}$	1.50	1.50	1.75	$6 \times 6 \times 8$	4.88	4.88	3.88
$3 \times 3 \times 2$	1.25	1.25	1.75	$6 \times 6 \times 4$	2.62	2.62	3.62
$3 \times 3 \times 1\frac{1}{2}$	1.00	1.00	1.75	$6 \times 6 \times 3$	2.00	2.00	3.62
$3 \times 3 \times 1\frac{1}{4}$	0.88	0.88	1.75	$6 \times 6 \times 2\frac{1}{2}$	1.88	1.88	3.62
$3 \times 3 \times 1$	0.75	0.75	1.75	$6 \times 6 \times 2$	1.62	1.62	3.62
$3 \times 3 \times \frac{3}{4}$	0.62	0.62	1.75	$6 \times 6 \times 1\frac{1}{2}$	1.38	1.38	3.62
$3 \times 3 \times \frac{1}{2}$	0.50	0.50	1.75	$6 \times 6 \times 1\frac{1}{4}$	1.25	1.25	3.62
$3 \times 2\frac{1}{2} \times 3$	1.75	1.75	1.75	$6 \times 6 \times 1$	1.12	1.12	3.62
$3 \times 2\frac{1}{2} \times 2\frac{1}{2}$	1.50	1.50	1.75	$6 \times 4 \times 6$	3.62	3.62	3.62
$3 \times 2\frac{1}{2} \times 2$	1.25	1.25	1.75	$6 \times 4 \times 4$	2.62	2.62	3.62
$3 \times 2\frac{1}{2} \times 1\frac{1}{2}$	1.00	1.00	1.75	$6 \times 3 \times 6$	3.62	3.62	3.62
$3 \times 2\frac{1}{2} \times 1\frac{1}{4}$	0.88	0.88	1.75	$6 \times 2\frac{1}{2} \times 6$	3.62	3.62	3.62
$3 \times 2\frac{1}{2} \times 1$	0.75	0.75	1.75	$6 \times 2 \times 6$	3.62	3.62	3.62
$3 \times 2 \times 3$	1.75	1.75	1.75	$8 \times 8 \times 6$	3.88	3.88	4.88
$3 \times 2 \times 2\frac{1}{2}$	1.50	1.50	1.75	$8 \times 8 \times 4$	2.88	2.88	4.88
$3 \times 2 \times 2$	1.25	1.25	1.75

Table 6 Dimensions of Reducing Tees (Cont'd)

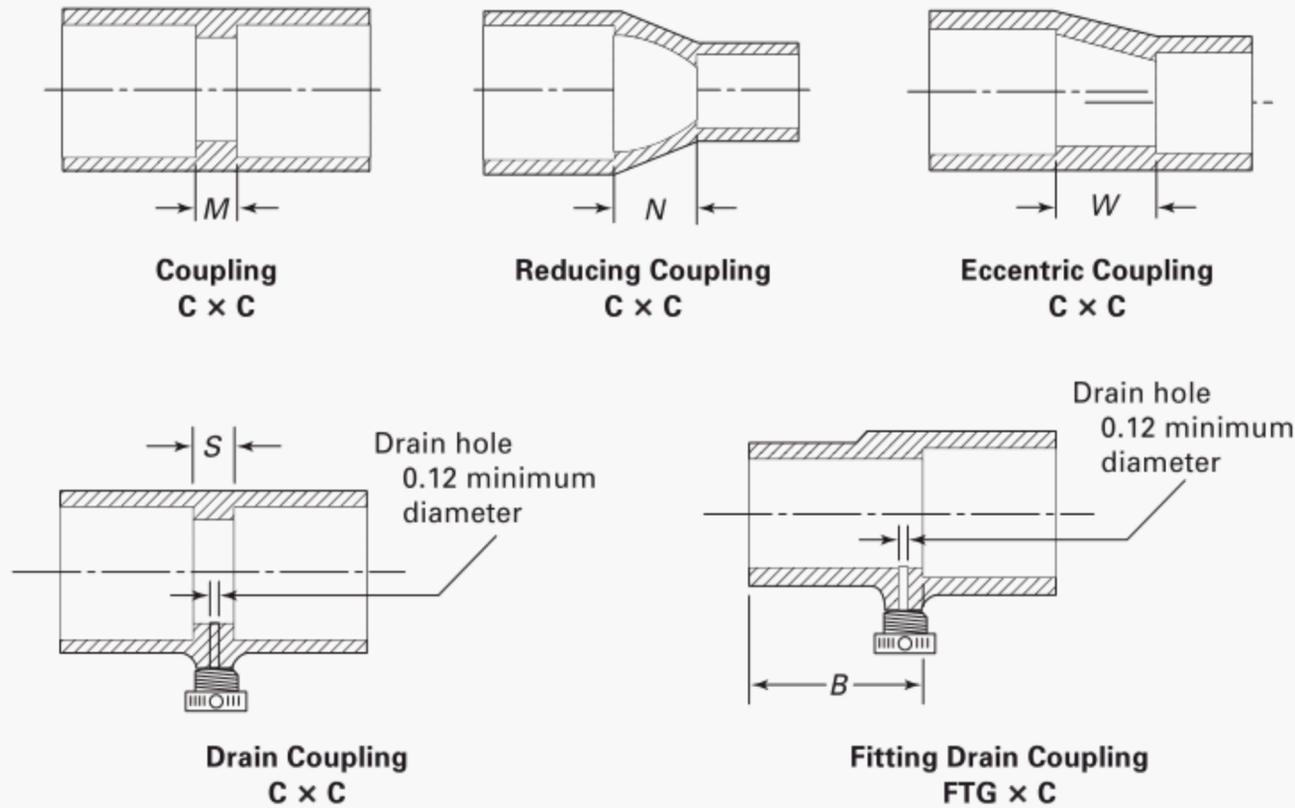
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.

NOTES:

- (1) For size designation of fitting, see section 4.
- (2) For inspection tolerances, see section 8 and Table 2.

Table 7 Dimensions of Couplings



Straight		Reducing		Eccentric		Drain	
Standard Water Tube Size [Note (1)]	Laying Length [Note (2)], <i>M</i>	Standard Water Tube Size [Note (1)]	Laying Length [Note (2)], <i>N</i>	Standard Water Tube Size [Note (1)]	Laying Length [Note (2)], <i>W</i>	Laying Length [Note (2)], <i>S</i>	Laying Length [Note (2)], <i>B</i>
1/4	0.06	3/4 x 1/2	0.31	3/4 x 1/2	0.62	0.25	...
3/8	0.06	1 x 3/4	0.38	1 x 3/4	0.69	0.25	...
1/2	0.12	1 1/4 x 1	0.38	1 1/4 x 1	0.75	0.25	1.00
3/4	0.12	1 1/4 x 3/4	0.38	1 1/4 x 3/4	0.75	0.25	1.28
1	0.12	1 1/2 x 1 1/4	0.38	1 1/2 x 1 1/4	0.69	0.25	...
1 1/4	0.12	1 1/2 x 1	0.38	1 1/2 x 1	0.69	0.25	...
1 1/2	0.12	1 1/2 x 3/4	0.44	2 x 1 1/2	1.12	0.25	...
2	0.19	2 x 1 1/2	0.50	2 x 1 1/4	0.94	0.25	...
2 1/2	0.19	2 x 1 1/4	0.50	2 1/2 x 2	1.19
3	0.19	2 x 1	0.50	3 x 2 1/2	1.25
3 1/2	0.25	2 x 3/4	0.50	3 x 2	1.31
4	0.25	2 1/2 x 2	0.56	4 x 3	2.00
5	0.25	2 1/2 x 1 1/2	0.56
6	0.25	2 1/2 x 1 1/4	0.62
8	0.62	2 1/2 x 1	0.62
...	...	3 x 2 1/2	0.62
...	...	3 x 2	0.62
...	...	4 x 3	0.69
...	...	4 x 2 1/2	1.12
...	...	4 x 2	1.19
...	...	6 x 4	1.31
...	...	8 x 6	1.38

Table 7 Dimensions of Couplings (Cont'd)

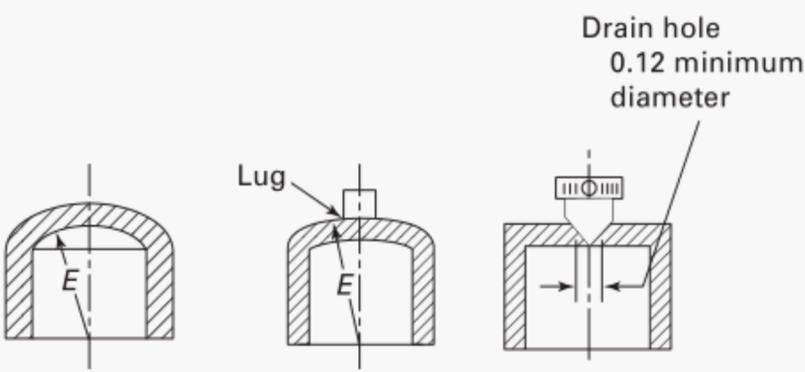
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.

NOTES:

- (1) For size designation of fitting, see section 4.
- (2) For inspection tolerances, see section 8 and Table 2.

Table 8 Dimensions of Caps and Plugs



Standard Water Tube Size [Note (1)]	Caps and Plugs, Radius [Note (2)], <i>E</i>
1/4	0.38
3/8	0.50
1/2	0.62
3/4	0.88
1	1.12
1 1/4	1.38
1 1/2	1.62
2	2.12
2 1/2	2.62
3	3.12
3 1/2	3.62
4	4.12
5	5.12
6	6.12

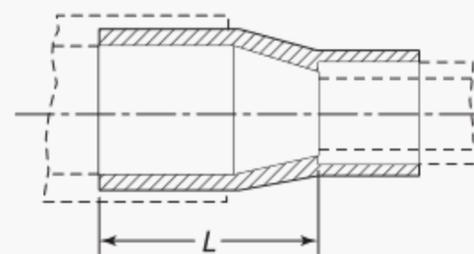
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For other dimensions not given in this table, see Table 3.
- (c) Casting of lug or square on plugs shall be optional.

NOTES:

- (1) For size designation of fitting, see section 4.
- (2) Caps may have either flat or rounded top.

Table 9 Dimensions of Fitting Reducers



Standard Water Tube Size [Note (1)]	Length, <i>L</i>
3/8 x 1/4	0.69
1/2 x 3/8	0.94
1/2 x 1/4	0.94
3/4 x 1/2	1.19
3/4 x 3/8	1.25
1 x 3/4	1.50
1 x 1/2	1.50
1 1/4 x 1	1.62
1 1/4 x 3/4	1.62
1 1/4 x 1 1/2	1.62
1 1/2 x 1 1/4	1.81
1 1/2 x 1	1.81
1 1/2 x 3/4	1.81
2 x 1 1/2	2.12
2 x 1 1/4	2.12
2 x 1	2.12
2 1/2 x 2	2.38
2 1/2 x 1 1/2	2.38
2 1/2 x 1 1/4	2.38
3 x 2 1/2	2.62
3 x 2	2.62
3 x 1 1/2	2.62
4 x 3	3.44
4 x 2 1/2	3.44
4 x 2	3.44

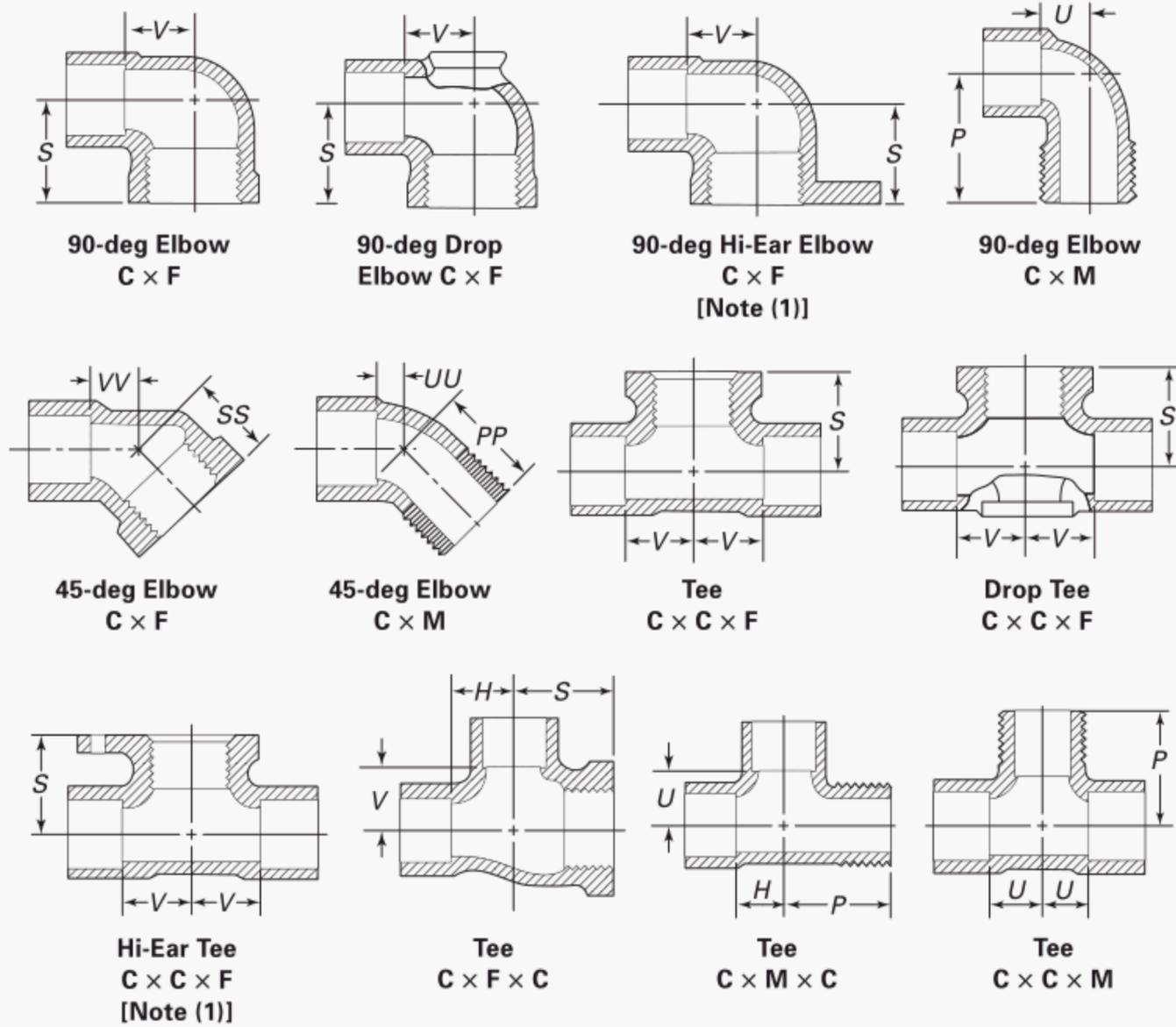
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For other dimensions not given in this table, see Table 3.

NOTE:

- (1) For size designation of fitting, see section 4.

Table 10 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Straight Sizes)



Standard Water Tube and Pipe Thread Size [Note (2)]	Internal Threads [Note (3)]					External Threads [Note (3)]				
	Center-to-End [Note (4)]		Laying Length [Note (4)]			Center-to-End [Note (4)]		Laying Length [Note (4)]		
	Ell and Tee, <i>S</i>	45-deg Ell, <i>SS</i>	Ell and Tee, <i>V</i>	Tee, <i>H</i>	45-deg Ell, <i>VV</i>	Ell and Tee, <i>P</i>	45-deg Ell, <i>PP</i>	Ell and Tee, <i>U</i>	Tee, <i>H</i>	45-deg Ell, <i>UU</i>
1/4	0.56	...	0.38	0.94	...	0.25
3/8	0.69	0.69	0.44	0.31	0.19	1.06	0.81	0.31	0.31	0.19
1/2	0.88	0.94	0.56	0.44	0.19	1.31	1.00	0.44	0.44	0.19
3/4	1.00	1.00	0.69	0.56	0.25	1.50	1.19	0.56	0.56	0.25
1	1.25	1.19	0.88	0.75	0.31	1.64	1.31	0.75	0.75	0.31
1 1/4	1.50	...	1.00	0.88	...	2.00	...	0.88
1 1/2	1.62	...	1.12	1.00	...	2.19	...	1.00
2	1.94	...	1.38	1.25	...	2.62	...	1.25
2 1/2	2.50	...	1.62
3	2.81	...	1.94
4	3.44	...	2.44
6	4.88	...	3.88

Table 10 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Straight Sizes) (Cont'd)

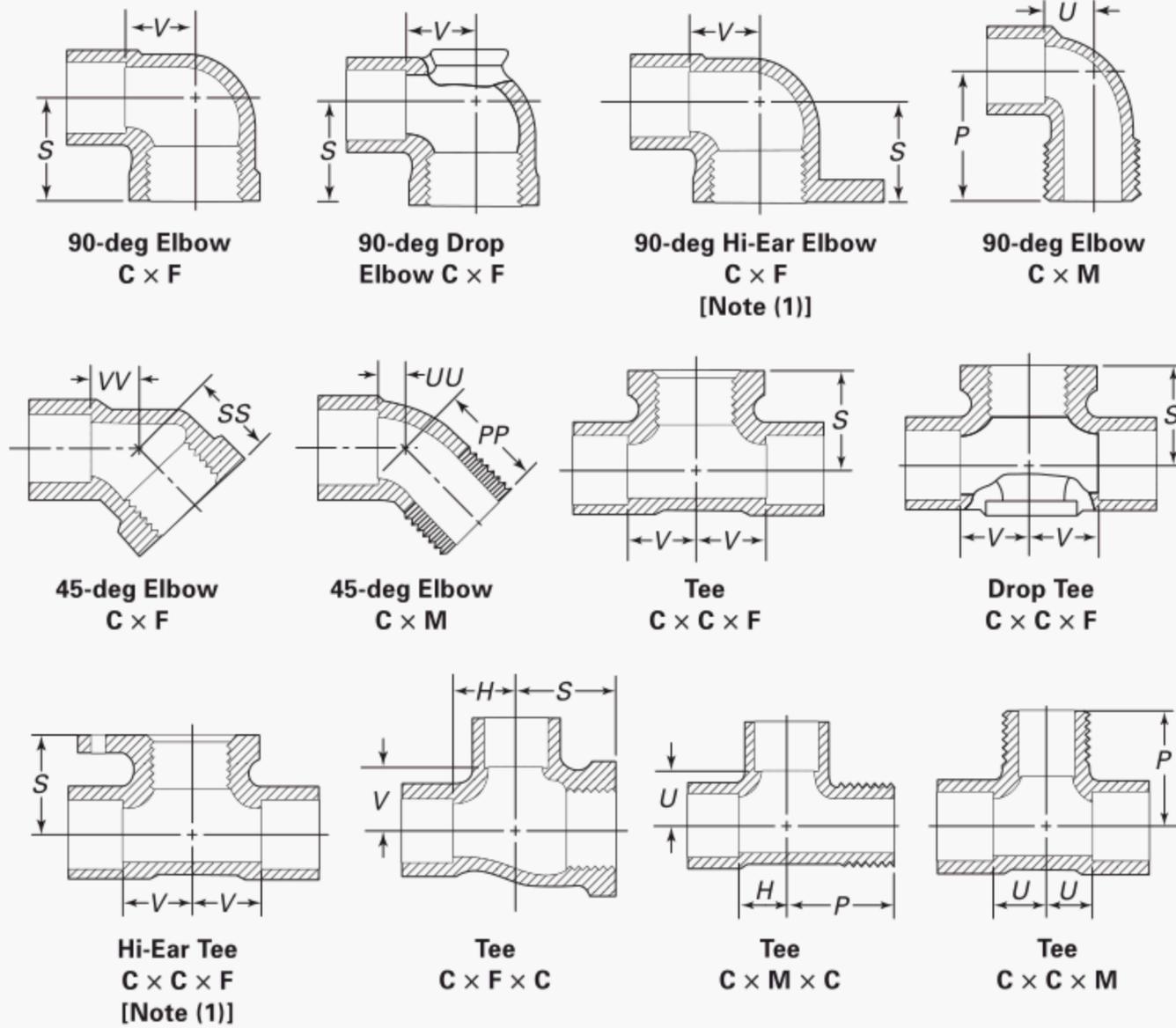
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions of threaded ends, see ASME B16.15. For configuration of threaded ends, see section 10. For dimensions of solder joint ends, see Table 3.
- (c) For dimensions of reducing tees and ells, see Table 11.

NOTES:

- (1) Hi-ear fittings are designed for use with $\frac{9}{16}$ in. maximum width strap.
- (2) For size designation of fitting, see section 4.
- (3) For threads of threaded ends, see section 9.
- (4) For inspection tolerances, see section 8 and Table 2.

Table 11 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Reducing Sizes)



Standard Water Tube and Pipe Thread Size [Note (2)]	Internal Threads [Note (3)]						External Threads [Note (3)]	
	Center-to-End, S			Laying Length [Note (4)]			Center-to- End, P	Laying Length, U [Note (4)]
	90-deg Ell C-F	Tee C-C-F	Tee C-F-C	90-deg Ell C-F	Tee C-C-F	Tee C-F-C		
$\frac{3}{8} \times \frac{3}{8} \times \frac{1}{2}$...	0.81	0.56
$\frac{3}{8} \times \frac{1}{2}$	0.81	0.56	1.25	0.44
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{4}$...	0.94	0.69
$\frac{1}{2} \times \frac{3}{4}$	0.94	0.69	1.38	0.56
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{8}$...	0.81	0.50
$\frac{1}{2} \times \frac{3}{8}$	0.81	0.50	1.12	0.31
$\frac{3}{4} \times \frac{3}{4} \times 1$...	1.12	0.88
$\frac{3}{4} \times 1$	1.12	0.88	1.69	0.75
$\frac{3}{4} \times \frac{3}{4} \times \frac{1}{2}$...	0.94	0.94	...	0.56	0.69	0.44	...
$\frac{3}{4} \times \frac{1}{2}$	0.94	0.56	1.44
$\frac{3}{4} \times \frac{3}{4} \times \frac{3}{8}$...	0.88	0.50
$\frac{3}{4} \times \frac{3}{8}$	0.88	0.50
$\frac{3}{4} \times \frac{1}{2} \times \frac{3}{4}$	0.94	0.56	0.56	...
$\frac{3}{4} \times \frac{1}{2} \times \frac{1}{2}$...	0.94	0.88	...	0.56	0.56	0.44	...

Table 11 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Reducing Sizes) (Cont'd)

Standard Water Tube and Pipe Thread Size [Note (2)]	Internal Threads [Note (3)]							External Threads [Note (3)]	
	Center-to-End, <i>S</i>			Laying Length [Note (4)]				Center-to- End, <i>P</i>	Laying Length, <i>U</i> [Note (4)]
	90-deg Ell C-F	Tee C-C-F	Tee C-F-C	<i>V</i>			<i>H</i>		
				90-deg Ell C-F	Tee C-C-F	Tee C-F-C	Tee C-F-C	90-deg Ell C-M	90-deg Ell C-M
1 × 1 ¹ / ₄	1.38	1.00
1 × 1 × 3 ⁴ / ₄	...	1.19	0.69
1 × 3 ⁴ / ₄	1.19	0.69	1.62	0.56
1 × 1 × 1 ² / ₂	...	1.12	0.56
1 × 1 × 3 ⁸ / ₈	...	1.06	0.50
1 × 3 ⁴ / ₄ × 1	...	1.25	1.19	...	0.88	0.75	0.75
1 × 3 ⁴ / ₄ × 3 ⁴ / ₄	...	1.19	0.69
1 × 3 ⁴ / ₄ × 1 ² / ₂	...	1.12	0.56
1 × 1 ² / ₂ × 1	1.12	0.75	0.75
1 × 1 ² / ₂	1.12	0.56
1 ¹ / ₄ × 1 ¹ / ₄ × 1	...	1.44	0.88
1 ¹ / ₄ × 1	1.44	0.88
1 ¹ / ₄ × 1 ¹ / ₄ × 3 ⁴ / ₄	...	1.31	0.69
1 ¹ / ₄ × 1 ¹ / ₄ × 1 ² / ₂	...	1.25	0.56
1 ¹ / ₄ × 1 ¹ / ₄ × 3 ⁸ / ₈	...	1.19	0.50
1 ¹ / ₄ × 3 ⁴ / ₄ × 1	1.19	0.88	0.75
1 ¹ / ₂ × 1 ¹ / ₂ × 1	...	1.50	1.38	...	0.88	1.12	0.75
1 ¹ / ₂ × 1 ¹ / ₂ × 3 ⁴ / ₄	...	1.44	0.69
1 ¹ / ₂ × 1 ¹ / ₂ × 1 ² / ₂	...	1.38	0.56
1 ¹ / ₂ × 3 ⁴ / ₄ × 1	1.19	1.00	0.75
2 × 2 × 1 ¹ / ₂	...	1.88	1.12
2 × 2 × 1	...	1.75	0.88
2 × 2 × 3 ⁴ / ₄	...	1.69	0.69
2 × 2 × 1 ² / ₂	...	1.62	0.56
2 ¹ / ₂ × 2 ¹ / ₂ × 3 ⁴ / ₄	...	2.06	0.69

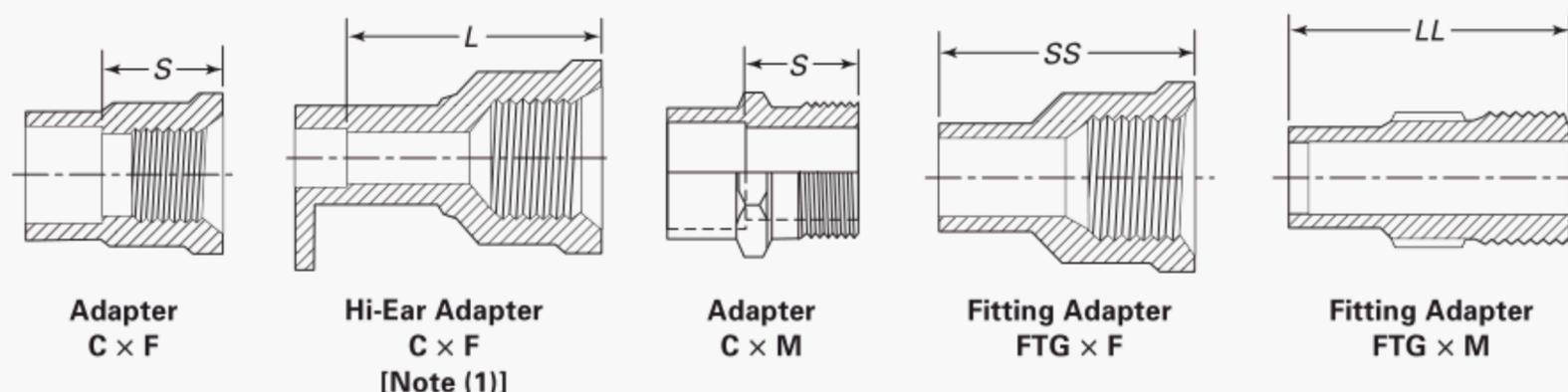
GENERAL NOTES:

- (a) Dimensions are in inches.
 (b) For dimensions of threaded ends, see ASME B16.15. For configuration of threaded ends, see section 10. For dimensions of solder joint ends, see Table 3.

NOTES:

- (1) Hi-ear fittings are designed for use with ⁹/₁₆ in. maximum width strap.
 (2) For size designation of fitting, see section 4.
 (3) For threads of threaded ends, see section 9.
 (4) For inspection tolerance, see section 8 and Table 2.

Table 12 Dimensions of Solder Joint Adapters and Fitting Adapters With Pipe Thread Ends (Straight and Reducing Sizes)



Standard Water Tube and Pipe Thread Size [Note (2)]		Shoulder-to-End, <i>S</i>	End-to-End		End-to-Tube Stop, <i>L</i>
Solder Joint	Pipe Thread		<i>SS</i>	<i>LL</i>	
1/4	3/8	0.62
1/4	1/4	0.62	...	1.00	...
3/8	1/2	0.75	...	1.25	...
3/8	3/8	0.62	1.06	1.12	...
1/2	1	1.00
1/2	3/4	0.88	1.44	1.47	...
1/2	1/2	0.75	1.38	1.38	1.25
1/2	3/8	0.62	1.22	1.25	...
3/4	1	1.00	1.81	1.91	...
3/4	3/4	0.88	1.66	1.72	...
3/4	1/2	0.75	1.62	1.62	...
1	1 1/4	1.06	2.09	2.16	...
1	1	1.00	1.97	2.09	...
1	3/4	0.88	1.81	1.91	...
1 1/4	2	1.12	...	2.38	...
1 1/4	1 1/2	1.06	2.22	2.28	...
1 1/4	1 1/4	1.06	2.03	2.22	...
1 1/4	1	1.06	2.03	2.12	...
1 1/2	2	1.12	...	2.50	...
1 1/2	1 1/2	1.06	2.22	2.41	...
1 1/2	1 1/4	1.06	2.22	2.34	...
1 1/2	1	1.00	...	2.25	...
2	2	1.12	2.53	2.75	...
2	1 1/2	1.12	...	2.66	...
2 1/2	2 1/2	1.38	3.09	3.12	...
3	3	1.50	3.22	3.41	...
4	4	1.69	3.81	4.12	...
6	6	2.00	5.34	5.75	...
8	8	2.25

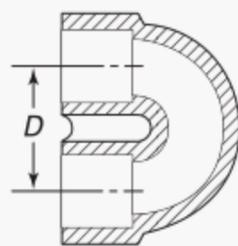
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For threaded ends, see section 9.
- (c) For dimensions of threaded ends, see ASME B16.15, Class 125. For sizes not listed in ASME B16.15, Class 125, refer to ASME B16.3, Class 150. For configuration of threaded ends, see section 10. For dimensions of solder joint ends, see Table 3.

NOTES:

- (1) Hi-ear fittings are designed for use with 9/16 in. maximum width strap.
- (2) For size designation of fitting, see section 4.

Table 13 Dimensions of Return Bends (Straight Sizes)



Return Bend
C × C

Standard Water Tube Size [Note (1)]	Center-to-Center, D
1/2	1.00
3/4	1.31
1	1.88
1 1/4	2.00
1 1/2	2.50
2	3.00
3	4.00
4	5.00

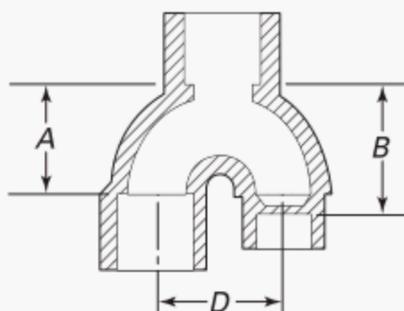
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.

NOTE:

- (1) For size designation of fitting, see section 4.

Table 14 Dimensions of Supply and Return Tees



Supply and Return Tee
C × C × C

Standard Water Tube Size [Note (1)]	Laying Lengths		Center-to-Center, D
	A	B	
1/2	0.81	0.81	1.00
3/4	1.09	1.09	1.31
3/4 × 3/4 × 1/2	1.09	1.09	1.31
3/4 × 1/2 × 1/2	1.09	1.28	1.31

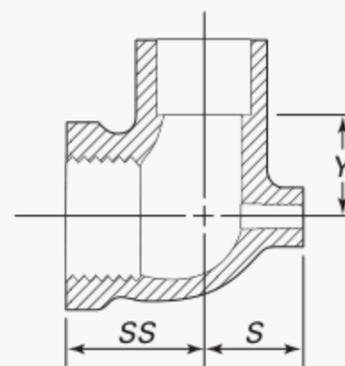
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

Table 15 Dimensions of Baseboard Tees (F × F × C)



Baseboard Tee
F × F × C

Standard Water Tube Size [Note (1)]	Laying Lengths		
	SS	S	Y
1/2 × 1/8 × 1	1.12	0.81	0.56
1/2 × 1/8 × 3/4	0.94	0.69	0.56
3/4 × 1/8 × 1	1.19	0.81	0.69
3/4 × 1/8 × 3/4	1.00	0.69	0.69
1 1/4 × 1/8 × 1 1/4	1.84	0.94	0.88

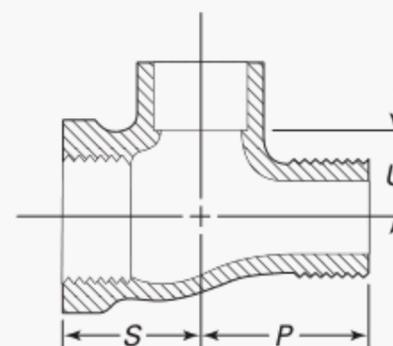
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

Table 16 Dimensions of Tees



Tee
F × M × C

Standard Water Tube Size [Note (1)]	Laying Lengths		
	U	P	S
1/2 × 3/4 × 1/2	0.69	1.22	0.97
3/4	0.69	1.34	1.00
3/4 × 3/4 × 1/2	0.69	1.22	0.97

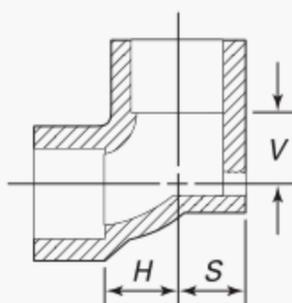
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

**Table 17 Dimensions of Baseboard Tees
(C × F × C)**



**Baseboard Tee
C × F × C**

Standard Water Tube Size [Note (1)]	Laying Lengths		
	H	S	V
$\frac{3}{8} \times \frac{1}{8} \times \frac{3}{8}$	0.59	0.97	0.59
$\frac{1}{2} \times \frac{1}{8} \times 1$	0.75	0.81	0.44
$\frac{1}{2} \times \frac{1}{8} \times \frac{3}{4}$	0.56	0.69	0.44
$\frac{1}{2} \times \frac{1}{8} \times \frac{1}{2}$	0.44	0.56	0.44
$\frac{3}{4} \times \frac{1}{8} \times 1\frac{1}{4}$	0.81	0.94	0.56
$\frac{3}{4} \times \frac{1}{8} \times 1$	0.75	0.81	0.62
$\frac{3}{4} \times \frac{1}{8} \times \frac{3}{4}$	0.56	0.69	0.56
$1 \times \frac{1}{8} \times 1$	0.72	0.75	0.72
$1\frac{1}{4} \times \frac{1}{8} \times 1\frac{1}{4}$	0.88	0.94	0.88

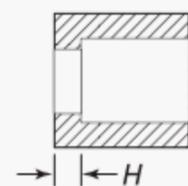
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

**Table 18 Dimensions of Flush Bushings
(FTG × C)**



**Flush Bushing
FTG × C**

Standard Water Tube Size [Note (1)]	Laying Length, H
$\frac{1}{4} \times \frac{1}{8}$	0.06
$\frac{3}{8} \times \frac{1}{4}$	0.06
$\frac{1}{2} \times \frac{3}{8}$	0.09
$\frac{1}{2} \times \frac{1}{4}$	0.25
$\frac{5}{8} \times \frac{1}{2}$	0.06
$\frac{3}{4} \times \frac{5}{8}$	0.19
$\frac{3}{4} \times \frac{1}{2}$	0.09
$\frac{3}{4} \times \frac{3}{8}$	0.44
$1 \times \frac{3}{4}$	0.12
$1 \times \frac{1}{2}$	0.47
$1\frac{1}{4} \times 1$	0.09
$1\frac{1}{2} \times 1\frac{1}{4}$	0.16
$2 \times 1\frac{1}{2}$	0.12

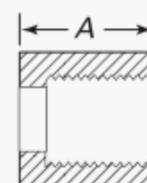
GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

Table 19 Dimensions of Flush Bushings (FTG × F)



**Flush Bushing
FTG × F**

Standard Water Tube Size [Note (1)]	Laying Length, A
$\frac{1}{2} \times \frac{1}{8}$	0.56
$\frac{3}{4} \times \frac{3}{8}$	0.81
$1 \times \frac{1}{2}$	0.97
$1\frac{1}{4} \times \frac{3}{4}$	1.03
$1\frac{1}{2} \times 1$	1.16
$2 \times 1\frac{1}{2}$	1.41

GENERAL NOTES:

- (a) Dimensions are in inches.
- (b) For dimensions not given in this table, see Table 3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

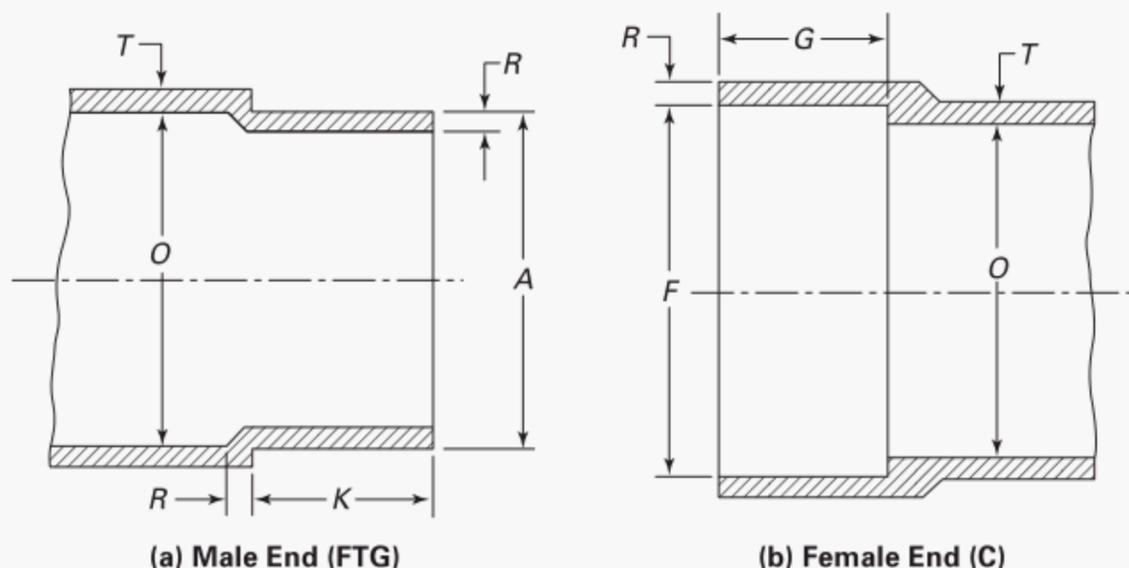
- (1) For size designation of fittings, see section 4.

MANDATORY APPENDIX I METRIC (SI) TABLES

Table designators with the prefix "I" correspond to the table numbers in the body of this Standard.

There are no corresponding tables to Tables 1 and 2 in the main text; therefore, tables in this Appendix begin with I-3.

Table I-3 Dimensions of Solder Joint Ends



Standard Water Tube Size [Note (1)]	Male End			Female End			Metal Thickness [Note (3)]		Minimum Inside Diameter of Fitting, <i>O</i>
	Outside Diameter [Note (2)], <i>A</i>		Minimum Length, <i>K</i>	Inside Diameter, <i>F</i>		Minimum Depth, <i>G</i>	Body, <i>T</i>	Joint, <i>R</i>	
	Min.	Max.		Min.	Max.				
1/4	9.47	9.55	9.5	9.58	9.68	8.0	2.0	1.3	7.9
3/8	12.62	12.73	11.0	12.75	12.85	9.5	2.3	1.3	10.9
1/2	15.80	15.90	14.5	15.93	16.03	12.5	2.3	1.3	13.7
3/4	22.15	22.25	20.5	22.28	22.38	19.0	2.5	1.5	19.8
1	28.50	28.63	24.5	28.65	28.75	23.0	2.8	1.8	25.9
1 1/4	34.85	34.98	26.0	35.00	35.10	24.5	3.0	1.8	32.0
1 1/2	41.17	41.33	29.5	41.35	41.48	28.0	3.3	2.0	38.1
2	53.87	54.03	35.5	54.05	54.18	34.0	3.8	2.3	50.3
2 1/2	66.57	66.73	39.0	66.75	66.88	37.5	4.3	2.5	62.5
3	79.27	79.43	43.5	79.45	79.58	42.0	4.8	2.8	74.7
3 1/2	91.97	92.13	50.0	92.15	92.28	48.5	5.1	3.0	86.9
4	104.67	104.83	56.5	104.85	104.98	55.0	5.6	3.3	99.1
5	130.07	130.23	69.0	130.25	130.38	67.5	7.1	4.3	123.7
6	155.47	155.63	82.0	155.65	155.78	78.5	8.6	5.1	148.3
8	206.22	206.43	104.0	206.45	206.58	101.0	9.5	7.9	196.1
10	257.02	257.23	104.6	257.25	257.38	101.6	12.2	12.2	244.3
12	307.82	308.03	117.3	308.05	308.18	114.3	14.2	14.2	293.6

GENERAL NOTES:

(a) Dimensions are in millimeters.

(b) The sketches and designs of fittings are illustrative only. Dimensions herein shall govern in all cases.

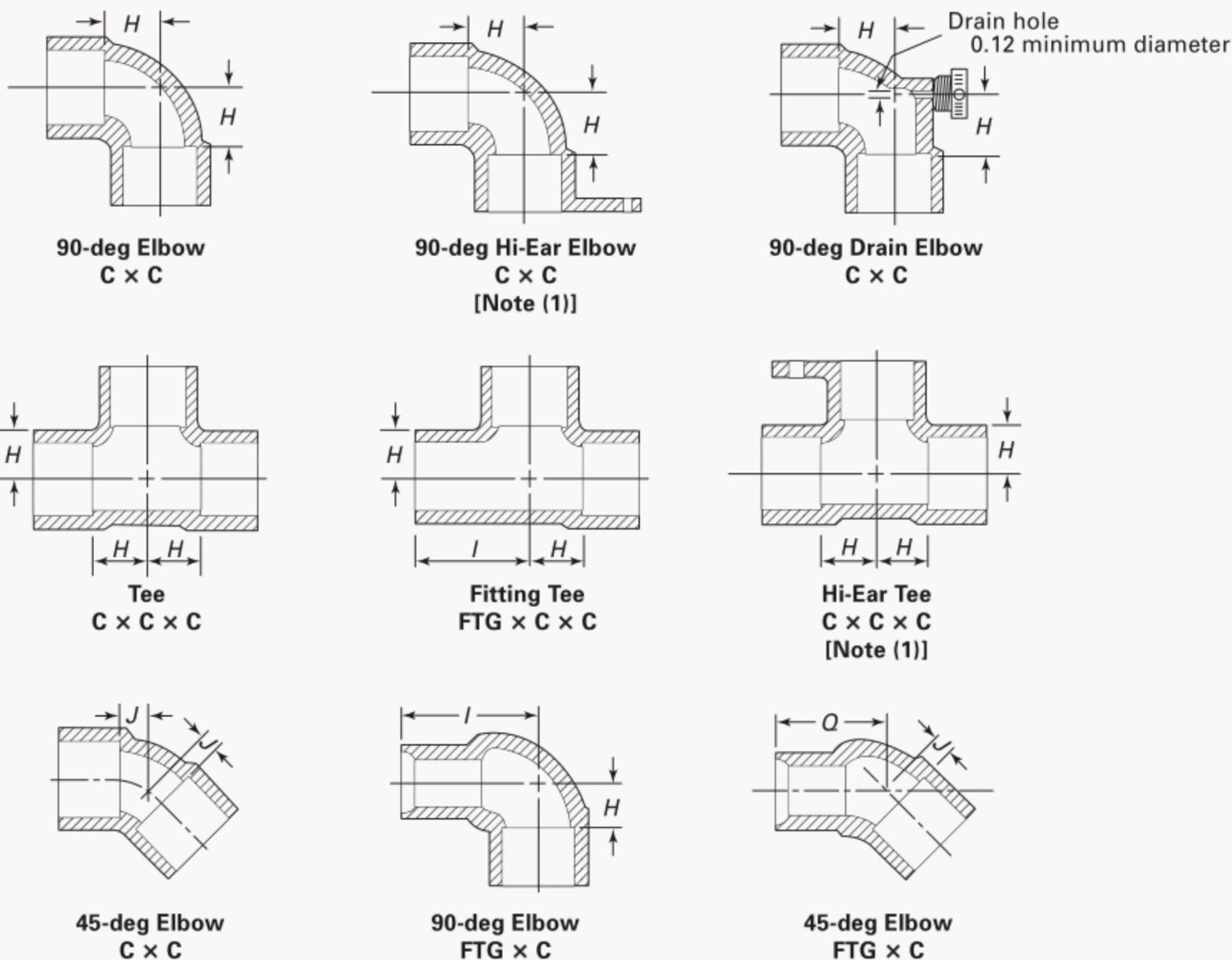
NOTES:

(1) For size designation of fitting, see section 4.

(2) For ovality and gaging tolerances, see section 8.

(3) For metal thickness, see section 7.

Table I-4 Dimensions of Elbows, Tees, and 45-deg Elbows



Standard Water Tube Size [Note (2)]	Laying Length Tee and 90-deg Elbow [Note (3)], H	Center-to-End 90-deg Elbow and Tee [Note (3)], I	Laying Length 45-deg Elbow [Note (3)], J	Center-to-End 45-deg Elbow [Note (3)], Q
1/4	6.5	19.0
3/8	8.0	22.0	5.0	19.0
1/2	11.0	28.5	5.0	22.0
3/4	14.5	38.0	6.5	30.0
1	19.0	47.0	8.0	33.5
1 1/4	22.0	51.5	11.0	39.5
1 1/2	25.5	58.0	12.5	44.5
2	32.0	70.5	14.5	54.0
2 1/2	38.0	80.0	16.0	...
3	44.5	91.5	19.0	...
3 1/2	51.0	...	22.0	...
4	57.0	116.5	24.0	...
5	79.5	...	36.5	...
6	92.0	...	41.5	...
8	124.0	...	54.0	...

Table I-4 Dimensions of Elbows, Tees, and 45-deg Elbows (Cont'd)

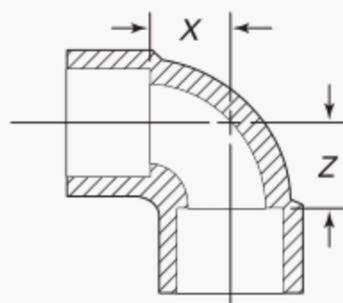
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.

NOTES:

- (1) Hi-ear fittings are designed for use with 14 mm maximum width strap.
- (2) For size designation of fitting, see section 4.
- (3) For inspection tolerances, see section 8 and Table 2.

Table I-5 Dimensions of Reducing 90-deg Elbows



**90-deg Elbow
C × C**

Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]	
	X	Z
$\frac{3}{8} \times \frac{1}{4}$	6.5	8.0
$\frac{1}{2} \times \frac{3}{8}$	9.5	11.0
$\frac{3}{4} \times \frac{1}{2}$	11.0	14.5
$1 \times \frac{3}{4}$	16.0	19.0
$1 \times \frac{1}{2}$	12.5	19.0
$1\frac{1}{4} \times 1$	19.0	22.0
$1\frac{1}{4} \times \frac{3}{4}$	16.0	22.0
$1\frac{1}{4} \times \frac{1}{2}$	12.5	22.0
$1\frac{1}{2} \times 1\frac{1}{4}$	22.0	25.5
$1\frac{1}{2} \times 1$	19.0	25.5
$1\frac{1}{2} \times \frac{3}{4}$	16.0	25.5
$2 \times 1\frac{1}{2}$	25.5	31.5
$2 \times 1\frac{1}{4}$	22.0	31.5
2×1	19.0	31.5
$2 \times \frac{3}{4}$	16.0	31.5
$2\frac{1}{2} \times 2$	31.5	38.0
$2\frac{1}{2} \times 1\frac{1}{2}$	25.5	38.0
$2\frac{1}{2} \times 1\frac{1}{4}$	22.0	38.0
$2\frac{1}{2} \times 1$	19.0	38.0
$3 \times 2\frac{1}{2}$	38.0	44.5
3×2	31.5	44.5
$3 \times 1\frac{1}{2}$	25.5	44.5
$3 \times 1\frac{1}{4}$	22.0	44.5
4×3	44.5	57.0
$4 \times 2\frac{1}{2}$	38.0	57.0
4×2	31.5	57.0
6×4	66.5	92.0
6×3	51.0	92.0
8×6	98.5	124.0

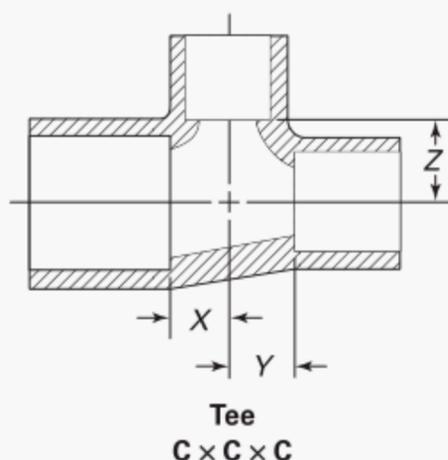
GENERAL NOTES:

- (a) Dimensions are in millimeters.
 (b) For dimensions not given in this table, see Table I-3.

NOTES:

- (1) For size designation of fitting, see section 4.
 (2) For inspection tolerances, see section 8 and Table 2.

Table I-6 Dimensions of Reducing Tees



Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]			Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]		
	X	Y	Z		X	Y	Z
$\frac{3}{8} \times \frac{3}{8} \times \frac{1}{2}$	11.0	11.0	9.5	$1\frac{1}{4} \times \frac{3}{4} \times \frac{3}{4}$	16.0	16.0	22.0
$\frac{3}{8} \times \frac{3}{8} \times \frac{1}{4}$	6.5	6.5	8.0	$1\frac{1}{4} \times \frac{1}{2} \times 1\frac{1}{4}$	22.0	22.0	22.0
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{4}$	14.5	14.5	11.0	$1\frac{1}{4} \times \frac{1}{2} \times 1$	19.0	19.0	22.0
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{8}$	9.5	9.5	11.0	$1\frac{1}{2} \times 1\frac{1}{2} \times 2\frac{1}{2}$	38.0	38.0	25.5
$\frac{1}{2} \times \frac{1}{2} \times \frac{1}{4}$	8.0	8.0	11.0	$1\frac{1}{2} \times 1\frac{1}{2} \times 2$	32.0	32.0	25.5
$\frac{1}{2} \times \frac{3}{8} \times \frac{1}{2}$	11.0	11.0	11.0	$1\frac{1}{2} \times 1\frac{1}{2} \times 1\frac{1}{4}$	22.0	22.0	25.5
$\frac{1}{2} \times \frac{3}{8} \times \frac{3}{8}$	9.5	9.5	11.0	$1\frac{1}{2} \times 1\frac{1}{2} \times 1$	19.0	19.0	25.5
$\frac{3}{4} \times \frac{3}{4} \times 1$	19.0	19.0	16.0	$1\frac{1}{2} \times 1\frac{1}{2} \times \frac{3}{4}$	16.0	16.0	25.5
$\frac{3}{4} \times \frac{3}{4} \times \frac{1}{2}$	11.0	11.0	14.5	$1\frac{1}{2} \times 1\frac{1}{2} \times \frac{1}{2}$	12.5	12.5	25.5
$\frac{3}{4} \times \frac{3}{4} \times \frac{3}{8}$	9.5	9.5	14.5	$1\frac{1}{2} \times 1\frac{1}{4} \times 1\frac{1}{2}$	25.5	25.5	25.5
$\frac{3}{4} \times \frac{1}{2} \times \frac{3}{4}$	14.5	14.5	14.5	$1\frac{1}{2} \times 1\frac{1}{4} \times 1\frac{1}{4}$	22.0	22.0	25.5
$\frac{3}{4} \times \frac{1}{2} \times \frac{1}{2}$	11.0	11.0	14.5	$1\frac{1}{2} \times 1\frac{1}{4} \times 1$	19.0	19.0	25.5
$\frac{3}{4} \times \frac{1}{2} \times \frac{3}{8}$	9.5	9.5	14.5	$1\frac{1}{2} \times 1\frac{1}{4} \times \frac{3}{4}$	16.0	16.0	25.0
$1 \times 1 \times \frac{1}{2}$	25.5	25.5	19.0	$1\frac{1}{2} \times 1\frac{1}{4} \times \frac{1}{2}$	12.5	12.5	25.5
$1 \times 1 \times 1\frac{1}{4}$	22.0	22.0	19.0	$1\frac{1}{2} \times 1 \times 1\frac{1}{2}$	25.5	25.5	25.5
$1 \times 1 \times \frac{3}{4}$	16.0	16.0	19.0	$1\frac{1}{2} \times 1 \times 1\frac{1}{4}$	22.0	22.0	25.5
$1 \times 1 \times \frac{1}{2}$	12.5	12.5	19.0	$1\frac{1}{2} \times 1 \times 1$	19.0	19.0	25.5
$1 \times 1 \times \frac{3}{8}$	11.0	11.0	19.0	$1\frac{1}{2} \times \frac{3}{4} \times 1\frac{1}{2}$	25.5	25.5	25.5
$1 \times \frac{3}{4} \times 1$	19.0	19.0	19.0	$1\frac{1}{2} \times \frac{1}{2} \times 1\frac{1}{2}$	25.5	25.0	25.5
$1 \times \frac{3}{4} \times \frac{3}{4}$	16.0	16.0	19.0	$2 \times 2 \times 4$	57.0	57.0	32.0
$1 \times \frac{3}{4} \times \frac{1}{2}$	12.5	12.5	19.0	$2 \times 2 \times 3$	44.5	44.5	32.0
$1 \times \frac{1}{2} \times 1$	19.0	19.0	19.0	$2 \times 2 \times 2\frac{1}{2}$	38.0	38.0	32.0
$1 \times \frac{1}{2} \times \frac{3}{4}$	16.0	16.0	19.0	$2 \times 2 \times 1\frac{1}{2}$	25.5	25.5	32.0
$1 \times \frac{1}{2} \times \frac{1}{2}$	12.5	12.5	19.0	$2 \times 2 \times 1\frac{1}{4}$	22.0	22.0	32.0
$1\frac{1}{4} \times 1\frac{1}{4} \times 2$	32.0	32.0	22.0	$2 \times 2 \times 1$	19.0	19.0	32.0
$1\frac{1}{4} \times 1\frac{1}{4} \times 1\frac{1}{2}$	25.5	25.5	22.0	$2 \times 2 \times \frac{3}{4}$	16.0	16.0	32.0
$1\frac{1}{4} \times 1\frac{1}{4} \times 1$	19.0	19.0	22.0	$2 \times 2 \times \frac{1}{2}$	12.5	12.5	32.0
$1\frac{1}{4} \times 1\frac{1}{4} \times \frac{3}{4}$	16.0	16.0	22.0	$2 \times 1\frac{1}{2} \times 2$	32.0	32.0	32.0
$1\frac{1}{4} \times 1\frac{1}{4} \times \frac{1}{2}$	12.5	12.5	22.0	$2 \times 1\frac{1}{2} \times 1\frac{1}{2}$	25.5	25.5	32.0
$1\frac{1}{4} \times 1 \times 1\frac{1}{4}$	22.0	22.0	22.0	$2 \times 1\frac{1}{2} \times 1\frac{1}{4}$	22.0	22.0	32.0
$1\frac{1}{4} \times 1 \times 1$	19.0	19.0	22.0	$2 \times 1\frac{1}{2} \times 1$	19.0	19.0	32.0
$1\frac{1}{4} \times 1 \times \frac{3}{4}$	16.0	16.0	22.0	$2 \times 1\frac{1}{2} \times \frac{3}{4}$	16.0	16.0	32.0
$1\frac{1}{4} \times 1 \times \frac{1}{2}$	12.5	12.5	22.0	$2 \times 1\frac{1}{2} \times \frac{1}{2}$	12.5	12.5	32.0
$1\frac{1}{4} \times \frac{3}{4} \times 1\frac{1}{4}$	22.0	22.0	22.0	$2 \times 1\frac{1}{4} \times 2$	32.0	32.0	32.0
$1\frac{1}{4} \times \frac{3}{4} \times 1$	19.0	19.0	22.0	$2 \times 1\frac{1}{4} \times 1\frac{1}{2}$	25.5	25.5	32.0

Table I-6 Dimensions of Reducing Tees (Cont'd)

Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]			Standard Water Tube Size [Note (1)]	Laying Length [Note (2)]		
	X	Y	Z		X	Y	Z
$2 \times 1\frac{1}{4} \times 1\frac{1}{4}$	22.0	22.0	32.0	$3 \times 2 \times 1\frac{1}{2}$	25.5	25.0	44.5
$2 \times 1 \times 2$	32.0	32.0	32.0	$3 \times 1\frac{1}{2} \times 3$	44.5	44.5	44.5
$2 \times \frac{3}{4} \times 2$	32.0	32.0	32.0	$3 \times 1\frac{1}{4} \times 3$	44.5	44.5	44.5
$2 \times \frac{1}{2} \times 2$	32.0	32.0	32.0	$3 \times 1 \times 3$	44.5	44.5	44.5
$2\frac{1}{2} \times 2\frac{1}{2} \times 4$	57.0	57.0	38.0	$3\frac{1}{2} \times 3\frac{1}{2} \times 3$	44.5	44.5	51.0
$2\frac{1}{2} \times 2\frac{1}{2} \times 3$	44.5	44.5	38.0	$3\frac{1}{2} \times 3 \times 3\frac{1}{2}$	51.0	51.0	51.0
$2\frac{1}{2} \times 2\frac{1}{2} \times 2$	32.0	32.0	38.0	$4 \times 4 \times 6$	92.0	92.0	66.0
$2\frac{1}{2} \times 2\frac{1}{2} \times 1\frac{1}{2}$	25.5	25.5	38.0	$4 \times 4 \times 3$	44.5	44.5	57.0
$2\frac{1}{2} \times 2\frac{1}{2} \times 1\frac{1}{4}$	22.0	22.0	38.0	$4 \times 4 \times 2\frac{1}{2}$	38.0	38.0	57.0
$2\frac{1}{2} \times 2\frac{1}{2} \times 1$	19.0	19.0	38.0	$4 \times 4 \times 2$	32.0	32.0	57.0
$2\frac{1}{2} \times 2\frac{1}{2} \times \frac{3}{4}$	16.0	16.0	38.0	$4 \times 4 \times 1\frac{1}{2}$	25.5	25.5	57.0
$2\frac{1}{2} \times 2\frac{1}{2} \times \frac{1}{2}$	12.5	12.5	38.0	$4 \times 4 \times 1\frac{1}{4}$	22.0	22.0	57.0
$2\frac{1}{2} \times 2 \times 2\frac{1}{2}$	38.0	38.0	38.0	$4 \times 4 \times 1$	19.0	19.0	57.0
$2\frac{1}{2} \times 2 \times 2$	32.0	32.0	38.0	$4 \times 4 \times \frac{3}{4}$	16.0	16.0	57.0
$2\frac{1}{2} \times 2 \times 1\frac{1}{2}$	25.5	25.5	38.0	$4 \times 3 \times 4$	57.0	57.0	57.0
$2\frac{1}{2} \times 2 \times 1\frac{1}{4}$	22.0	22.0	38.0	$4 \times 3 \times 3$	44.5	44.5	57.0
$2\frac{1}{2} \times 2 \times 1$	19.0	19.0	38.0	$4 \times 3 \times 2\frac{1}{2}$	38.0	38.0	57.0
$2\frac{1}{2} \times 2 \times \frac{3}{4}$	16.0	16.0	38.0	$4 \times 3 \times 2$	32.0	32.0	57.0
$2\frac{1}{2} \times 2 \times \frac{1}{2}$	12.5	12.5	38.0	$4 \times 2\frac{1}{2} \times 4$	57.0	57.0	57.0
$2\frac{1}{2} \times 1\frac{1}{2} \times 2\frac{1}{2}$	38.0	38.0	38.0	$4 \times 2 \times 4$	57.0	57.0	57.0
$2\frac{1}{2} \times 1\frac{1}{2} \times 2$	32.0	32.0	38.0	$4 \times 2 \times 3$	44.5	44.5	57.0
$2\frac{1}{2} \times 1\frac{1}{2} \times 1\frac{1}{2}$	25.5	25.5	38.0	$4 \times 2 \times 2$	32.0	32.0	57.0
$2\frac{1}{2} \times 1\frac{1}{4} \times 2\frac{1}{2}$	38.0	38.0	38.0	$4 \times 1\frac{1}{2} \times 4$	57.0	57.0	57.0
$2\frac{1}{2} \times 1 \times 2\frac{1}{2}$	38.0	38.0	38.0	$4 \times 1\frac{1}{4} \times 4$	57.0	57.0	57.0
$2\frac{1}{2} \times \frac{3}{4} \times 2\frac{1}{2}$	38.0	38.0	38.0	$4 \times 1 \times 4$	57.0	57.0	57.0
$2\frac{1}{2} \times \frac{1}{2} \times 2\frac{1}{2}$	38.0	38.0	38.0	$5 \times 5 \times 4$	66.0	66.0	79.5
$3 \times 3 \times 4$	57.0	57.0	44.5	$5 \times 4 \times 5$	79.5	79.5	79.5
$3 \times 3 \times 2\frac{1}{2}$	38.0	38.0	44.5	$6 \times 6 \times 8$	124.0	124.0	98.5
$3 \times 3 \times 2$	32.0	32.0	44.5	$6 \times 6 \times 4$	66.5	66.5	92.0
$3 \times 3 \times 1\frac{1}{2}$	25.5	25.5	44.5	$6 \times 6 \times 3$	50.5	50.5	92.0
$3 \times 3 \times 1\frac{1}{4}$	22.0	22.0	44.5	$6 \times 6 \times 2\frac{1}{2}$	47.5	47.5	92.0
$3 \times 3 \times 1$	19.0	19.0	44.5	$6 \times 6 \times 2$	41.5	41.5	92.0
$3 \times 3 \times \frac{3}{4}$	16.0	16.0	44.5	$6 \times 6 \times 1\frac{1}{2}$	35.0	35.0	92.0
$3 \times 3 \times \frac{1}{2}$	12.5	12.5	44.5	$6 \times 6 \times 1\frac{1}{4}$	32.0	32.0	92.0
$3 \times 2\frac{1}{2} \times 3$	44.5	44.5	44.5	$6 \times 6 \times 1$	28.5	28.5	92.0
$3 \times 2\frac{1}{2} \times 2\frac{1}{2}$	38.0	38.0	44.5	$6 \times 4 \times 6$	92.0	92.0	92.0
$3 \times 2\frac{1}{2} \times 2$	32.0	32.0	44.5	$6 \times 4 \times 4$	66.5	66.5	92.0
$3 \times 2\frac{1}{2} \times 1\frac{1}{2}$	25.5	25.5	44.5	$6 \times 3 \times 6$	92.0	92.0	92.0
$3 \times 2\frac{1}{2} \times 1\frac{1}{4}$	22.0	22.0	44.5	$6 \times 2\frac{1}{2} \times 6$	92.0	92.0	92.0
$3 \times 2\frac{1}{2} \times 1$	19.0	19.0	44.5	$6 \times 2 \times 6$	92.0	92.0	92.0
$3 \times 2 \times 3$	44.5	44.5	44.5	$8 \times 8 \times 6$	98.5	98.5	124.0
$3 \times 2 \times 2\frac{1}{2}$	38.0	38.0	44.5	$8 \times 8 \times 4$	73.0	73.0	124.0
$3 \times 2 \times 2$	32.0	32.0	44.5

Table I-6 Dimensions of Reducing Tees (Cont'd)

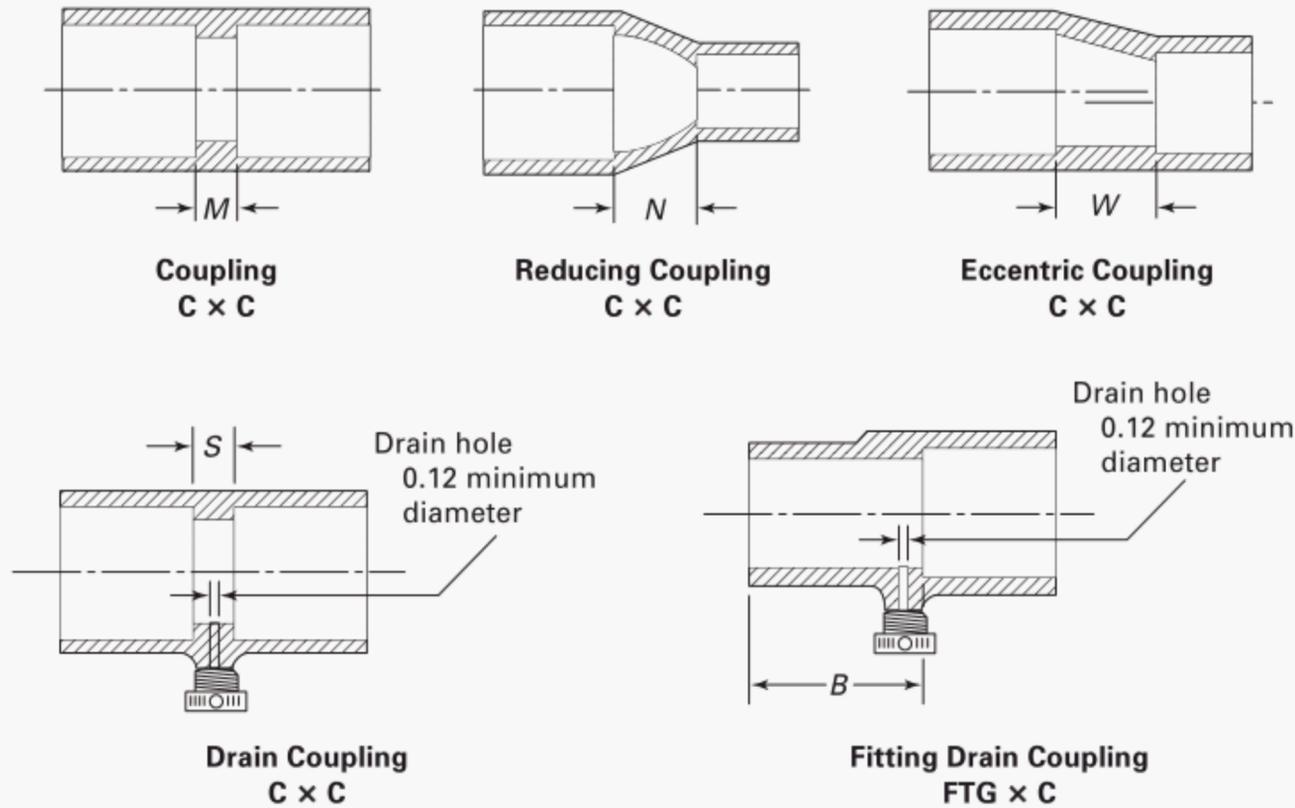
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.

NOTES:

- (1) For size designation of fitting, see section 4.
- (2) For inspection tolerances, see section 8 and Table 2.

Table I-7 Dimensions of Couplings



Straight		Reducing		Eccentric		Drain	
Standard Water Tube Size [Note (1)]	Laying Length [Note (2)], M	Standard Water Tube Size [Note (1)]	Laying Length [Note (2)], N	Standard Water Tube Size [Note (1)]	Laying Length [Note (2)], W	Laying Length [Note (2)], S	Laying Length [Note (2)], B
$1/4$	1.5	$3/4 \times 1/2$	8.0	$3/4 \times 1/2$	16.0	6.5	...
$3/8$	1.5	$1 \times 3/4$	9.5	$1 \times 3/4$	17.5	6.5	...
$1/2$	3.0	$1 1/4 \times 1$	9.5	$1 1/4 \times 1$	19.0	6.5	25.5
$3/4$	3.0	$1 1/4 \times 3/4$	9.5	$1 1/4 \times 3/4$	19.0	6.5	32.5
1	3.0	$1 1/2 \times 1 1/4$	9.5	$1 1/2 \times 1 1/4$	17.5	6.5	...
$1 1/4$	3.0	$1 1/2 \times 1$	9.5	$1 1/2 \times 1$	17.5	6.5	...
$1 1/2$	3.0	$1 1/2 \times 3/4$	11.0	$2 \times 1 1/2$	28.5	6.5	...
2	4.5	$2 \times 1 1/2$	12.5	$2 \times 1 1/4$	24.0	6.5	...
$2 1/2$	4.5	$2 \times 1 1/4$	12.5	$2 1/2 \times 2$	30.0
3	4.5	2×1	12.5	$3 \times 2 1/2$	32.0
$3 1/2$	6.5	$2 \times 3/4$	12.5	3×2	33.5
4	6.5	$2 1/2 \times 2$	14.5	4×3	51.0
5	6.5	$2 1/2 \times 1 1/2$	14.5
6	6.5	$2 1/2 \times 1 1/4$	16.0
8	16.0	$2 1/2 \times 1$	16.0
...	...	$3 \times 2 1/2$	16.0
...	...	3×2	16.0
...	...	4×3	17.5
...	...	$4 \times 2 1/2$	28.5
...	...	4×2	30.0
...	...	6×4	33.5
...	...	8×6	35.0

Table I-7 Dimensions of Couplings (Cont'd)

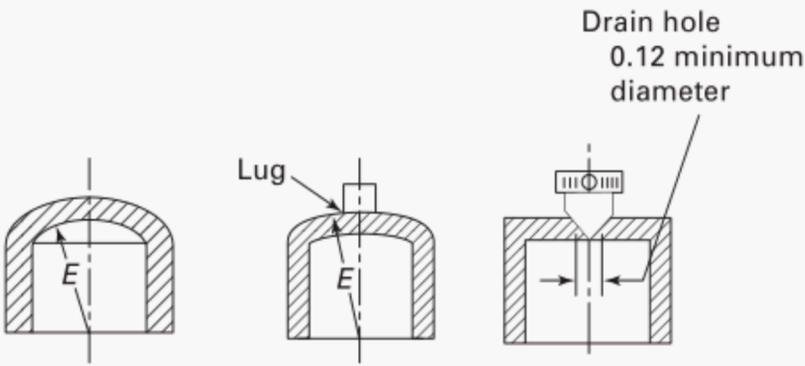
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.

NOTES:

- (1) For size designation of fitting, see section 4.
- (2) For inspection tolerances, see section 8 and Table 2.

Table I-8 Dimensions of Caps and Plugs



Standard Water Tube Size [Note (1)]	Caps and Plugs, Radius [Note (2)], E
1/4	9.5
3/8	12.5
1/2	16.0
3/4	22.0
1	28.5
1 1/4	35.0
1 1/2	41.5
2	54.0
2 1/2	66.5
3	79.5
3 1/2	92.0
4	105.0
5	130.0
6	155.5

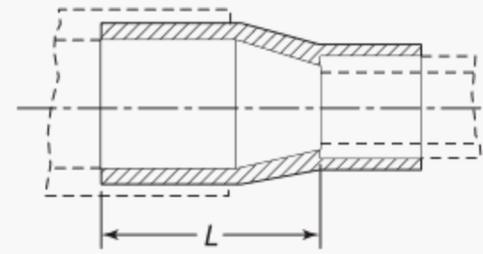
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.
- (c) Casting of lug or square on plugs shall be optional.

NOTES:

- (1) For size designation of fitting, see section 4.
- (2) Caps may have either flat or rounded top.

Table I-9 Dimensions of Fitting Reducers



Standard Water Tube Size [Note (1)]	Length, L
3/8 x 1/4	17.5
1/2 x 3/8	24.0
1/2 x 1/4	24.0
3/4 x 1/2	30.0
3/4 x 3/8	32.0
1 x 3/4	38.0
1 x 1/2	38.0
1 1/4 x 1	41.5
1 1/4 x 3/4	41.5
1 1/4 x 1/2	41.5
1 1/2 x 1 1/4	46.0
1 1/2 x 1	46.0
1 1/2 x 3/4	46.0
2 x 1 1/2	54.0
2 x 1 1/4	54.0
2 x 1	54.0
2 1/2 x 2	60.5
2 1/2 x 1 1/2	60.5
2 1/2 x 1 1/4	60.5
3 x 2 1/2	66.5
3 x 2	66.5
3 x 1 1/2	66.5
4 x 3	87.5
4 x 2 1/2	87.5
4 x 2	87.5

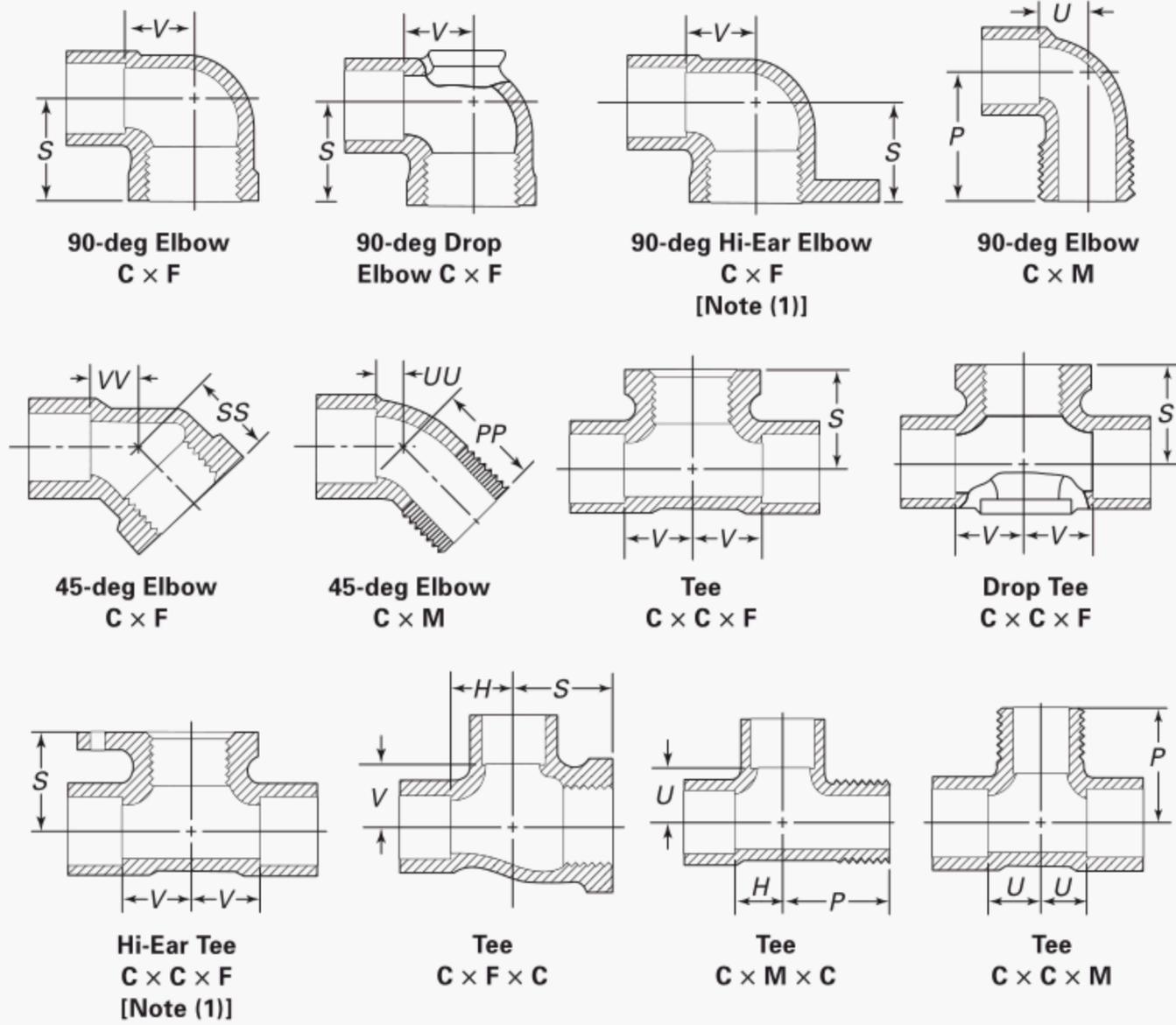
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.

NOTE:

- (1) For size designation of fitting, see section 4.

Table I-10 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Straight Sizes)



Standard Water Tube and Pipe Thread Size [Note (2)]	Internal Threads [Note (3)]					External Threads [Note (3)]				
	Center-to-End [Note (4)]		Laying Length [Note (4)]			Center-to-End [Note (4)]		Laying Length [Note (4)]		
	Ell and Tee, S	45-deg Ell, SS	Ell and Tee, V	Tee, H	45-deg Ell, VV	Ell and Tee, P	45-deg Ell, PP	Ell and Tee, U	Tee, H	45-deg Ell, UU
1/4	14.5	...	9.5	24.0	...	6.5
3/8	17.5	17.5	11.0	8.0	4.5	27.0	20.5	8.0	8.0	4.5
1/2	22.0	24.0	14.5	11.0	4.5	33.5	25.5	11.0	11.0	4.5
3/4	25.5	25.5	17.5	14.5	6.5	38.0	30.0	14.5	14.5	6.5
1	32.0	30.0	22.0	19.0	8.0	41.5	33.5	19.0	19.0	8.0
1 1/4	38.0	...	25.5	22.0	...	51.0	...	22.0
1 1/2	41.5	...	28.5	25.5	...	55.5	...	25.5
2	49.0	...	35.0	32.0	...	66.5	...	32.0
2 1/2	63.5	...	41.5
3	71.5	...	49.0
4	87.5	...	62.0
6	124.0	...	98.5

Table I-10 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Straight Sizes) (Cont'd)

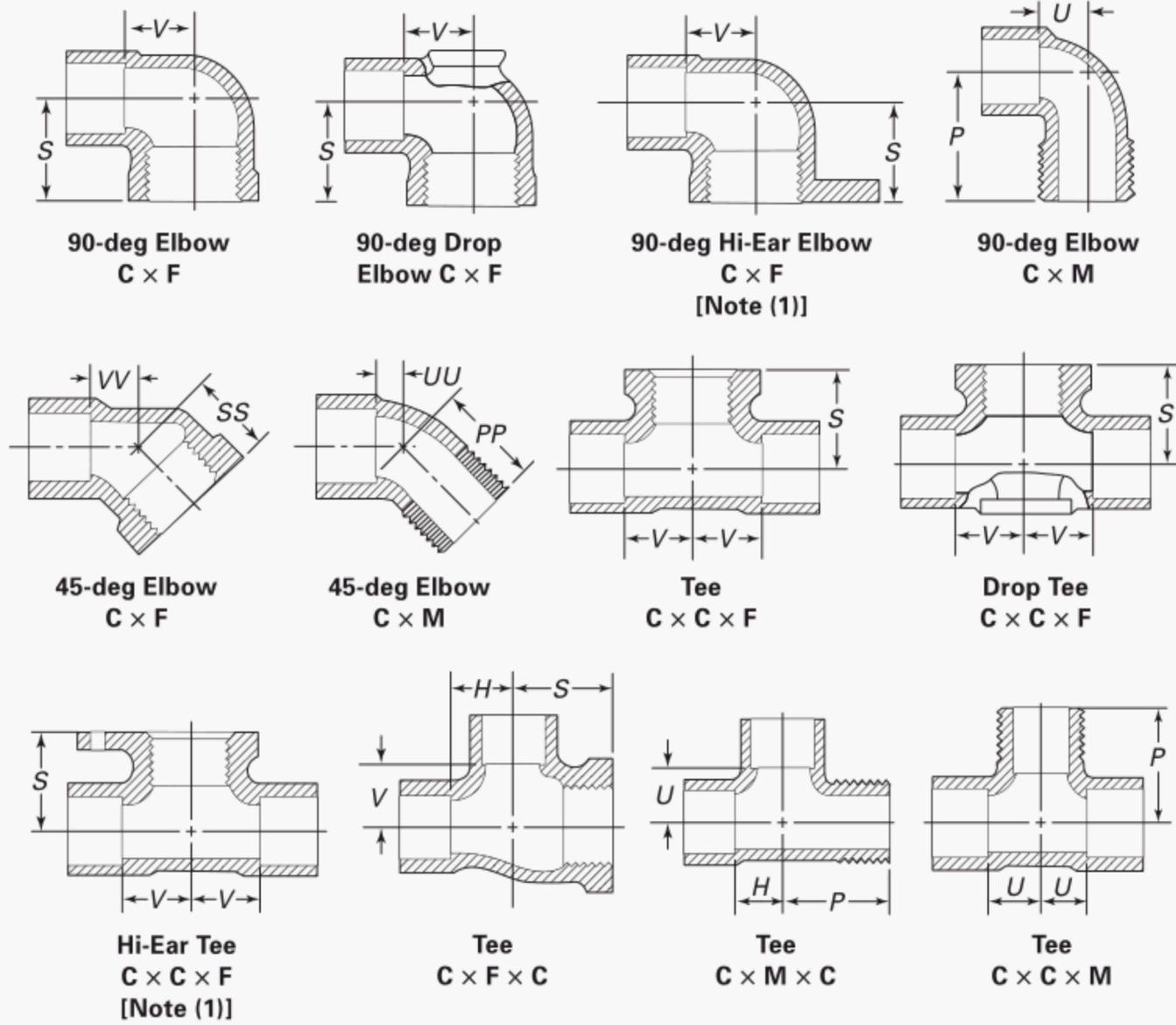
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions of threaded ends, see ASME B16.15. For configuration of threaded ends, see section 10. For dimensions of solder joint ends, see Table I-3.
- (c) For dimensions of reducing tees and ells, see Table I-11.

NOTES:

- (1) Hi-ear fittings are designed for use with 14 mm maximum width strap.
- (2) For size designation of fitting, see section 4.
- (3) For threads of threaded ends, see section 9.
- (4) For inspection tolerances, see section 8 and Table 2.

Table I-11 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Reducing Sizes)



Standard Water Tube and Pipe Thread Size [Note (2)]	Internal Threads [Note (3)]							External Threads [Note (3)]	
	Center-to-End, S			Laying Length [Note (4)]				Center-to-End, P	Laying Length, U [Note (4)]
	90-deg Ell C-F	Tee C-C-F	Tee C-F-C	90-deg Ell C-F	Tee C-C-F	Tee C-F-C	Tee C-F-C		
$\frac{3}{8} \times \frac{3}{8} \times \frac{1}{2}$...	20.5	14.5
$\frac{3}{8} \times \frac{1}{2}$	20.5	14.5	32.0	11.0
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{4}$...	23.5	17.5
$\frac{1}{2} \times \frac{3}{4}$	24.0	17.5	35.0	14.5
$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{8}$...	20.5	12.5
$\frac{1}{2} \times \frac{3}{8}$	20.5	12.5	28.5	8.0
$\frac{3}{4} \times \frac{3}{4} \times 1$...	28.5	22.0
$\frac{3}{4} \times 1$	28.5	22.0	43.0	19.0
$\frac{3}{4} \times \frac{3}{4} \times \frac{1}{2}$...	24.0	24.0	...	14.5	17.5	11.0
$\frac{3}{4} \times \frac{1}{2}$	24.0	14.5	36.5	11.0
$\frac{3}{4} \times \frac{3}{4} \times \frac{3}{8}$...	22.0	12.5
$\frac{3}{4} \times \frac{3}{8}$	22.0	12.5
$\frac{3}{4} \times \frac{1}{2} \times \frac{3}{4}$	24.0	14.5	14.5
$\frac{3}{4} \times \frac{1}{2} \times \frac{1}{2}$...	24.0	22.0	...	14.5	14.5	11.0

Table I-11 Dimensions of Solder Joint Elbows and Tees With Pipe Thread Ends (Reducing Sizes) (Cont'd)

Standard Water Tube and Pipe Thread Size [Note (2)]	Internal Threads [Note (3)]							External Threads [Note (3)]	
	Center-to-End, <i>S</i>			Laying Length [Note (4)]				Center-to- End, <i>P</i>	Laying Length, <i>U</i> [Note (4)]
	90-deg Ell C-F	Tee C-C-F	Tee C-F-C	<i>V</i>			<i>H</i>		
				90-deg Ell C-F	Tee C-C-F	Tee C-F-C	Tee C-F-C	90-deg Ell C-M	90-deg Ell C-M
1 × 1 ^{1/4}	35.0	25.5
1 × 1 × 3/4	...	30.0	17.5
1 × 3/4	30.0	17.5	41.5	14.5
1 × 1 × 1/2	...	28.5	14.5
1 × 1 × 3/8	...	27.0	12.5
1 × 3/4 × 1	...	32.0	30.0	...	22.0	19.0	19.0
1 × 3/4 × 3/4	...	30.0	17.5
1 × 3/4 × 1/2	...	28.5	14.5
1 × 1/2 × 1	28.5	19.0	19.0
1 × 1/2	28.5	14.5
1 1/4 × 1 1/4 × 1	...	36.5	22.0
1 1/4 × 1	36.5	22.0
1 1/4 × 1 1/4 × 3/4	...	33.5	17.5
1 1/4 × 1 1/4 × 1/2	...	32.0	14.5
1 1/4 × 1 1/4 × 3/8	...	30.0	12.5
1 1/4 × 3/4 × 1	30.0	22.0	19.0
1 1/2 × 1 1/2 × 1	...	38.0	35.0	...	22.0	28.5	19.0
1 1/2 × 1 1/2 × 3/4	...	36.5	17.5
1 1/2 × 1 1/2 × 1/2	...	35.0	14.5
1 1/2 × 3/4 × 1	30.0	25.5	19.0
2 × 2 × 1 1/2	...	47.5	28.5
2 × 2 × 1	...	44.5	22.0
2 × 2 × 3/4	...	43.0	17.5
2 × 2 × 1/2	...	41.5	14.5
2 1/2 × 2 1/2 × 3/4	...	52.5	17.5

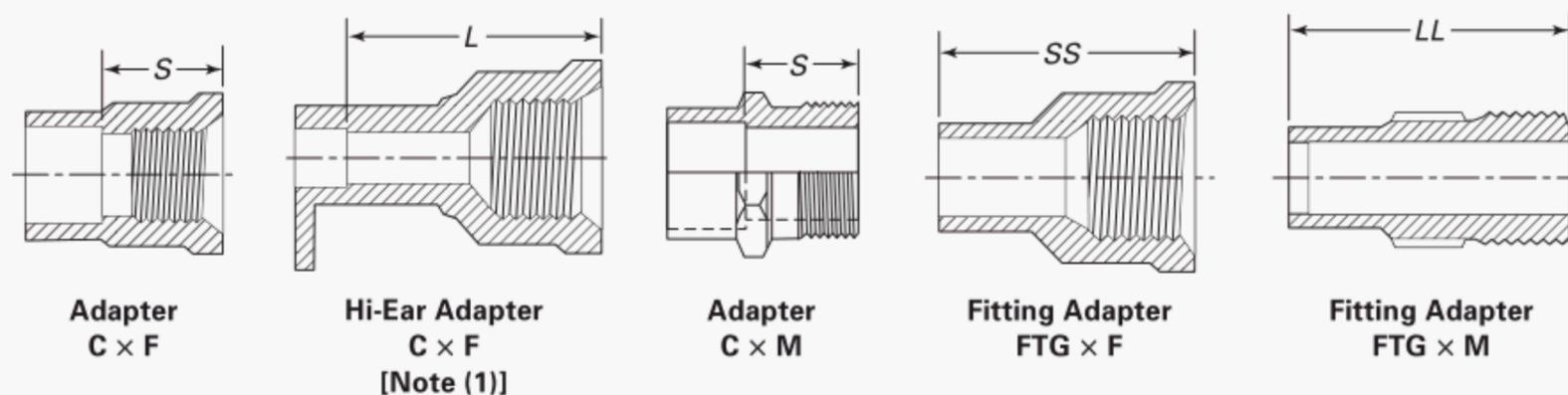
GENERAL NOTES:

- (a) Dimensions are in millimeters.
 (b) For dimensions of threaded ends, see ASME B16.15. For configuration of threaded ends, see section 10. For dimensions of solder joint ends, see Table I-3.

NOTES:

- (1) Hi-ear fittings are designed for use with 14 mm maximum width strap.
 (2) For size designation of fitting, see section 4.
 (3) For threads of threaded ends, see section 9.
 (4) For inspection tolerance, see section 8 and Table 2.

Table I-12 Dimensions of Solder Joint Adapters and Fitting Adapters With Pipe Thread Ends (Straight and Reducing Sizes)



Standard Water Tube and Pipe Thread Size [Note (2)]						
Solder Joint	Pipe Thread	Shoulder-to-End, S	End-to-End		End-to-Tube Stop, L	
			SS	LL		
1/4	3/8	16.0	
1/4	1/4	16.0	...	25.5	...	
3/8	1/2	19.0	...	32.0	...	
3/8	3/8	16.0	27.0	28.5	...	
1/2	1	25.5	
1/2	3/4	22.0	36.5	37.5	...	
1/2	1/2	18.0	35.0	35.0	32.0	
1/2	3/8	16.0	31.0	32.0	...	
3/4	1	25.5	46.0	48.5	...	
3/4	3/4	22.0	42.0	43.5	...	
3/4	1/2	19.0	41.5	41.5	...	
1	1 1/4	27.0	53.0	55.0	...	
1	1	25.5	50.0	53.0	...	
1	3/4	22.0	46.0	48.5	...	
1 1/4	2	28.5	...	60.5	...	
1 1/4	1 1/2	27.0	56.5	58.0	...	
1 1/4	1 1/4	27.0	51.5	56.5	...	
1 1/4	1	27.0	51.5	54.0	...	
1 1/2	2	28.5	...	63.5	...	
1 1/2	1 1/2	27.0	56.5	61.0	...	
1 1/2	1 1/4	27.0	56.5	59.5	...	
1 1/2	1	25.5	...	57.0	...	
2	2	28.5	64.5	70.0	...	
2	1 1/2	28.5	...	67.5	...	
2 1/2	2 1/2	35.0	78.5	79.5	...	
3	3	38.0	82.0	86.5	...	
4	4	43.0	97.0	105.0	...	
6	6	50.5	135.5	146.0	...	
8	8	57.0	

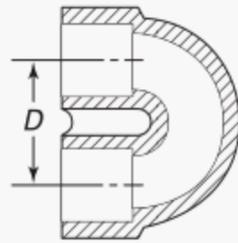
GENERAL NOTES:

- (a) Dimensions are in millimeters.
 (b) For threaded ends, see section 9.
 (c) For dimensions of threaded ends, see ASME B16.15, Class 125. For sizes not listed in ASME B16.15, Class 125, refer to ASME B16.3, Class 150. For configuration of threaded ends, see section 10. For dimensions of solder joint ends, see Table I-3.

NOTES:

- (1) Hi-ear fittings are designed for use with 14 mm maximum width strap.
 (2) For size designation of fitting, see section 4.

Table I-13 Dimensions of Return Bends (Straight Sizes)



**Return Bend
C × C**

Standard Water Tube Size [Note (1)]	Center-to-Center, D
1/2	25.5
3/4	33.5
1	47.5
1 1/4	51.0
1 1/2	63.5
2	76.0
3	101.5
4	127.0

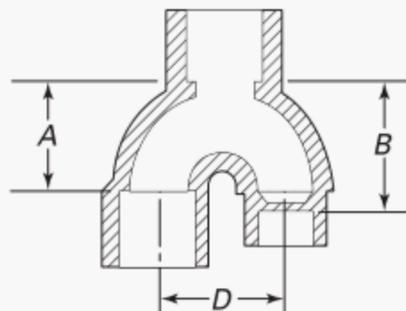
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.

NOTE:

- (1) For size designation of fitting, see section 4.

Table I-14 Dimensions of Supply and Return Tees



**Supply and Return Tee
C × C × C**

Standard Water Tube Size [Note (1)]	Laying Lengths		Center-to-Center, D
	A	B	
1/2	20.5	20.5	25.5
3/4	28.0	28.0	33.5
3/4 × 3/4 × 1/2	28.0	28.0	33.5
3/4 × 1/2 × 1/2	28.0	32.5	33.5

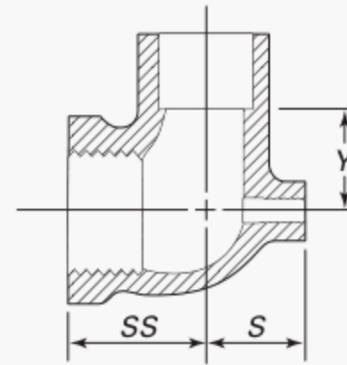
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

Table I-15 Dimensions of Baseboard Tees (F × F × C)



**Baseboard Tee
F × F × C**

Standard Water Tube Size [Note (1)]	Laying Lengths		
	SS	S	Y
1/2 × 1/8 × 1	28.5	20.5	14.5
1/2 × 1/8 × 3/4	24.0	17.5	14.5
3/4 × 1/8 × 1	30.0	20.5	17.5
3/4 × 1/8 × 3/4	25.5	17.5	17.5
1 1/4 × 1/8 × 1 1/4	47.0	24.0	22.0

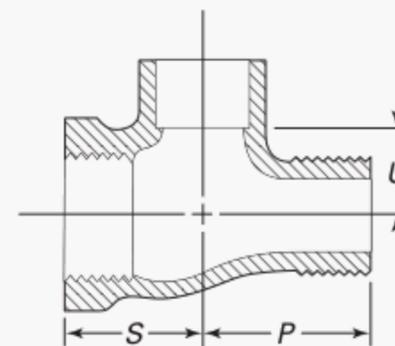
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

Table I-16 Dimensions of Tees



**Tee
F × M × C**

Standard Water Tube Size [Note (1)]	Laying Lengths		
	U	P	S
1/2 × 3/4 × 1/2	17.5	31.0	24.5
3/4	17.5	34.0	25.5
3/4 × 3/4 × 1/2	17.5	31.0	24.5

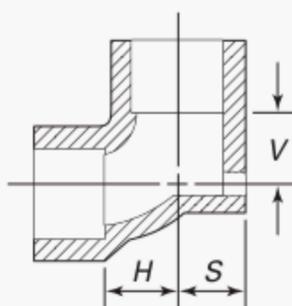
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

**Table I-17 Dimensions of Baseboard Tees
(C × F × C)**



**Baseboard Tee
C × F × C**

Standard Water Tube Size [Note (1)]	Laying Lengths		
	H	S	V
$\frac{3}{8} \times \frac{1}{8} \times \frac{3}{8}$	15.0	24.5	15.0
$\frac{1}{2} \times \frac{1}{8} \times 1$	19.0	20.5	11.0
$\frac{1}{2} \times \frac{1}{8} \times \frac{3}{4}$	14.5	17.5	11.0
$\frac{1}{2} \times \frac{1}{8} \times \frac{1}{2}$	11.0	14.5	11.0
$\frac{3}{4} \times \frac{1}{8} \times 1\frac{1}{4}$	20.5	24.0	14.5
$\frac{3}{4} \times \frac{1}{8} \times 1$	19.0	20.5	16.0
$\frac{3}{4} \times \frac{1}{8} \times \frac{3}{4}$	11.0	17.5	11.0
$1 \times \frac{1}{8} \times 1$	18.0	19.0	15.0
$1\frac{1}{4} \times \frac{1}{8} \times 1\frac{1}{4}$	22.0	24.0	22.0

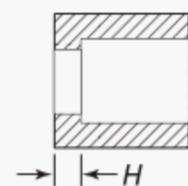
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

**Table I-18 Dimensions of Flush Bushings
(FTG × C)**



**Flush Bushing
FTG × C**

Standard Water Tube Size [Note (1)]	Laying Length, H
$\frac{1}{4} \times \frac{1}{8}$	2.0
$\frac{3}{8} \times \frac{1}{4}$	2.0
$\frac{1}{2} \times \frac{3}{8}$	2.5
$\frac{1}{2} \times \frac{1}{4}$	6.5
$\frac{5}{8} \times \frac{1}{2}$	2.0
$\frac{3}{4} \times \frac{5}{8}$	5.0
$\frac{3}{4} \times \frac{1}{2}$	2.5
$\frac{3}{4} \times \frac{3}{8}$	11.0
$1 \times \frac{3}{4}$	3.0
$1 \times \frac{1}{2}$	12.0
$1\frac{1}{4} \times 1$	2.5
$1\frac{1}{2} \times 1\frac{1}{4}$	4.0
$2 \times 1\frac{1}{2}$	3.0

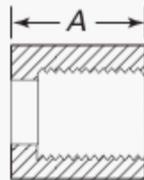
GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

**Table I-19 Dimensions of Flush Bushings
(FTG × F)**



**Flush Bushing
FTG × F**

Standard Water Tube Size [Note (1)]	Laying Length, A
$\frac{1}{2} \times \frac{1}{8}$	14.0
$\frac{3}{4} \times \frac{3}{8}$	20.5
$1 \times \frac{1}{2}$	24.5
$1\frac{1}{4} \times \frac{3}{4}$	26.0
$1\frac{1}{2} \times 1$	29.5
$2 \times 1\frac{1}{2}$	35.5

GENERAL NOTES:

- (a) Dimensions are in millimeters.
- (b) For dimensions not given in this table, see Table I-3.
- (c) For inspection tolerances, see section 8 and Table 2.

NOTE:

- (1) For size designation of fittings, see section 4.

MANDATORY APPENDIX II REFERENCES

(12)

The following is a list of publications referenced in this Standard. Unless otherwise specified, the latest edition of ASME publications shall apply. Materials manufactured to other editions of the referenced ASTM standard shall be permitted to be used to manufacture fittings meeting the requirements of this Standard as long as the fitting manufacturer verifies the material meets the requirements of the referenced edition

- ANSI/ASME B1.20.1, Pipe Threads, General Purpose (Inch)
- ASME B16.3, Malleable Iron Threaded Fittings, Classes 150 and 300
- ASME B16.15, Cast Copper Alloy Threaded Fittings, Classes 125 and 250
- Publisher: The American Society of Mechanical Engineers (ASME), Three Park Avenue, New York, NY 10016-5990; Order Department: 22 Law Drive, P.O. Box 2900, Fairfield, NJ 07007-2900 (www.asme.org)
- ASTM B32-08, Solder Metal
- ASTM B62-09, Composition Bronze or Ounce Metal Castings
- ASTM B88-09, Standard Specification for Seamless Copper Water Tube
- ASTM B584-09a, Copper Alloy Sand Castings for General Applications
- ASTM B828-02, Standard Practice for Making Capillary Joints by Soldering of Copper and Copper Alloy Tube and Fittings
- ASTM E29-08, Standard Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- Publisher: ASTM International (ASTM), 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959 (www.astm.org)
- ISO 9000:2005, Quality management systems — Fundamentals and vocabulary¹
- ISO 9001:2008, Quality management systems — Requirements¹
- ISO 9004:2009, Managing for the sustained success of an organization — A quality management approach¹
- Publisher: International Organization for Standardization (ISO), Central Secretariat, 1, ch. de la Voie-Creuse, Case postale 56, CH-1211 Genève 20, Switzerland/Suisse (www.iso.org)
- MSS SP-25-2008, Standard Practice Marking System for Valves, Fittings, Flanges and Unions
- Publisher: Manufacturers Standardization Society of the Valve and Fittings Industry, Inc. (MSS), 127 Park Street, NE, Vienna, VA 22180 (www.mss-hq.org)

¹ May also be obtained from the American National Standards Institute (ANSI), 25 West 43rd Street, New York, NY 10036.

NONMANDATORY APPENDIX A STRENGTH OF SOLDER JOINTS

The maximum recommended pressure–temperature ratings for solder joints made with copper tube and cast copper alloy pressure fittings, using representative commercial solders, are listed in Table A-1. These pressure/temperature ratings are based on solder joints made in accordance with the requirements of ASTM B828.

Table A-1 Pressure-Temperature Ratings

Joining Material		Maximum Working Gage Pressure, for Standard Water Tube Sizes (1)											
		Working Temp.		1/8 Through 1		1/4 Through 2		2 1/2 Through 4		5 Through 8		10 Through 12	
		°F	°C	psi	kPa	psi	kPa	psi	kPa	psi	kPa	psi	kPa
Alloy Sn50 50-50 tin-lead solder (2)(3)	100	38	200	1 375	175	1 205	1 030	150	1 030	135	930	100	685
	150	66	150	1 030	125	860	685	100	685	90	620	70	480
	200	93	100	685	90	620	515	75	515	70	480	50	340
	250	120	85	585	75	515	340	50	340	45	310	40	275
Alloy Sb5 95-5 tin-antimony solder (4)	100	38	1,090 (8)	7 540 (8)	850 (9)	5 880 (9)	4 880 (9)	705 (9)	4 880 (9)	660 (9)	4 555 (9)	500 (8)	3 460 (8)
	150	66	625 (10)	4 315 (10)	485 (10)	3 365 (10)	2 790 (10)	405 (10)	2 790 (10)	375 (10)	2 605 (10)	285 (11)	1 975 (11)
	200	93	505 (11)	3 500 (11)	395 (10)	2 730 (10)	2 265 (10)	325 (10)	2 265 (10)	305 (10)	2 115 (10)	230 (11)	1 605 (11)
	250	120	270	1 885	210	1 475	1 220	175	1 220	165	1 135	125	865
Alloy E (5)	100	38	710 (10)	4 905 (10)	555 (10)	3 825 (10)	3 175 (10)	460 (10)	3 175 (10)	430 (10)	2 965 (10)	325 (11)	2 255 (11)
	150	66	475 (11)	3 275 (11)	370 (10)	2 550 (10)	2 115 (10)	305 (10)	2 115 (10)	285 (11)	1 975 (11)	215 (11)	1 500 (11)
	200	93	375	2 595	290	2 025	1 680 (11)	240 (11)	1 680 (11)	225 (11)	1 570 (11)	170	1 190
	250	120	320	2 230	250	1 735	1 440	205	1 440	195	1 340	145	1 020
Alloy HB (6)	100	38	1,035 (8)	7 135 (8)	805 (9)	5 560 (9)	4 615 (9)	670 (9)	4 615 (9)	625 (8)	4 305 (8)	475 (8)	3 275 (8)
	150	66	710 (10)	4 905 (10)	555 (10)	3 825 (10)	3 175 (10)	460 (10)	3 175 (10)	430 (10)	2 965 (10)	325 (10)	2 255 (10)
	200	93	440 (11)	3 045 (11)	345 (11)	2 375 (11)	1 970 (11)	285 (11)	1 970 (11)	265 (11)	1 840 (11)	200	1 400
	250	120	430 (11)	2 970 (11)	335 (11)	2 315 (11)	1 920 (11)	275 (11)	1 920 (11)	260 (11)	1 800 (11)	195	1 365

Joining materials melting at or above 1,100°F (593°C) (7)

Pressure-temperature ratings consistent with the materials and procedures employed.

GENERAL NOTE: For extremely low working temperatures in the 0°F to -200°F (-18°C to -93°C) range, it is recommended that a joint material melting at or above 1,100°F (593°C) be employed [see Note (7)].

NOTES:

- (1) Standard water tube sizes per ASTM B88.
- (2) ASTM B32 Alloy Grade Sn50.
- (3) The Safe Drinking Water Act Amendment of 1986 prohibits the use in potable water systems of any solder having a lead content in excess of 0.2%.
- (4) ASTM B32 Alloy Grade Sb5.
- (5) ASTM B32 Alloy Grade E.
- (6) ASTM B32 Alloy Grade HB.
- (7) These joining materials are defined as *brazing alloys* by the American Welding Society.
- (8) The solder joint exceeds the strength of Types L and M tube in drawn temper and Type K tube in annealed temper.
- (9) The solder joint exceeds the strength of Types K, L, and M tube in drawn and annealed tempers.
- (10) The solder joint exceeds the strength of Type M tube in drawn temper and Types K and L tube in annealed temper.
- (11) The solder joint exceeds the strength of Type L tube in annealed temper.

NONMANDATORY APPENDIX B FITTING RATING

The rated internal working pressures of the fitting are shown in Table 1. These values are the same as those calculated for annealed temper ASTM B88 Type L copper water tube. The rated internal working pressures for annealed temper ASTM B88 Type L copper water tube are calculated as follows:

where

$$P = \frac{2St}{D - 0.8t}$$

- D = maximum outside diameter, in. from annealed temper ASTM B88 for Type L copper water tube
- P = rated working pressure at temperature, psi
- S = allowable stress at temperature, psi from ASME B31.1 or ASME B31.9 for annealed temper ASTM B88 Type L copper water tube
- t = minimum wall thickness, in. from annealed temper ASTM B88 for Type L copper water tube

NONMANDATORY APPENDIX C QUALITY SYSTEM PROGRAM

The products manufactured in accordance with this Standard shall be produced under a quality system program following the principles of an appropriate standard from the ISO 9000 series.¹ A determination of the need for registration and/or certification of the product

¹ The series is also available from the American National Standards Institute (ANSI) and the American Society for Quality (ASQ) as American National Standards that are identified by the prefix "Q," replacing the prefix "ISO." Each standard of the series is listed under References in Mandatory Appendix II.

manufacturer's quality system program by an independent organization shall be the responsibility of the manufacturer. The detailed documentation demonstrating program compliance shall be available to the purchaser at the manufacturer's facility. A written summary description of the program utilized by the product manufacturer shall be available to the purchaser upon request. The product manufacturer is defined as the entity whose name, or trademark, appears on the product in accordance with the marking or identification requirements of this Standard.

B16 AMERICAN NATIONAL STANDARDS FOR PIPING, PIPE FLANGES, FITTINGS, AND VALVES

Gray Iron Pipe Flanges and Flanged Fittings (Classes 25, 125, and 250)	B16.1-2010
Malleable Iron Threaded Fittings: Classes 150 and 300	B16.3-2011
Gray Iron Threaded Fittings: Classes 125 and 250	B16.4-2011
Pipe Flanges and Flanged Fittings NPS 1/2 Through NPS 24 Metric/Inch Standard	B16.5-2009
Factory-Made Wrought Butt Welding Fittings	B16.9-2007
Face-to-Face and End-to-End Dimensions of Valves	B16.10-2009
Forged Fittings, Socket-Welding and Threaded	B16.11-2011
Cast Iron Threaded Drainage Fittings	B16.12-2009
Ferrous Pipe Plugs, Bushings, and Locknuts with Pipe Threads	B16.14-2010
Cast Copper Alloy Threaded Fittings	B16.15-2011
Cast Copper Alloy Solder Joint Pressure Fittings	B16.18-2012
Metallic Gaskets for Pipe Flanges: Ring-Joint, Spiral-Wound, and Jacketed	B16.20-2007
Nonmetallic Flat Gaskets for Pipe Flanges	B16.21-2005
Wrought Copper and Copper Alloy Solder Joint Pressure Fittings	B16.22-2001 (R2010)
Cast Copper Alloy Solder Joint Drainage Fittings: DWV	B16.23-2011
Cast Copper Alloy Pipe Flanges and Flanged Fittings: Classes 150, 300, 600, 900, 1500, and 2500	B16.24-2011
Butt Welding Ends	B16.25-2007
Cast Copper Alloy Fittings for Flared Copper Tubes	B16.26-2011
Wrought Copper and Wrought Copper Alloy Solder Joint Drainage Fittings — DWV	B16.29-2007
Manually Operated Metallic Gas Valves for Use in Gas Piping Systems Up to 125 psi (Sizes NPS 1/2 Through NPS 2)	B16.33-2002 (R2007)
Valves — Flanged, Threaded, and Welding End	B16.34-2004
Orifice Flanges	B16.36-2009
Large Metallic Valves for Gas Distribution Manually Operated, NPS 2 1/2 (DN 65) to NPS 12 (DN 300), 125 psig (8.6 bar) Maximum	B16.38-2007
Malleable Iron Threaded Pipe Unions: Classes 150, 250, and 300	B16.39-2009
Manually Operated Thermoplastic Gas Shutoffs and Valves in Gas Distribution Systems	B16.40-2008
Ductile Iron Pipe Flanges and Flanged Fittings: Classes 150 and 300	B16.42-2011
Manually Operated Metallic Gas Valves for Use in Aboveground Piping Systems Up to 5 psi	B16.44-2002 (R2007)
Cast Iron Fittings for Solvent® Drainage Systems	B16.45-1998 (R2006)
Large Diameter Steel Flanges NPS 26 Through NPS 60 Metric/Inch Standard	B16.47-2011
Line Blanks	B16.48-2010
Factory-Made Wrought Steel Butt Welding Induction Bends for Transportation and Distribution Systems	B16.49-2007
Wrought Copper and Copper Alloy Braze-Joint Pressure Fittings	B16.50-2001 (R2008)
Copper and Copper Alloy Press-Connect Pressure Fittings	B16.51-2011

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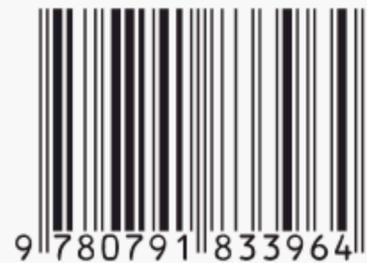
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