

International Standard	• British Standard: ISO 5922 / ISO 49 / ISO 7-1								
Specifications	<ul style="list-style-type: none"> • Material: BS EN 1562, ASTM A197 • Dimensions: BS EN 10242, BS 143 & 1256 • Types of Threading: ISO 7-1, BS 21 • Galvanizing: BS EN 10242, BS 143 & 1256 								
Surface Treatment	Galvanized (Hot-dipped Zinc coated)								
Available Size	1/8" up to 6"								
Applicable	Water, Oil, Steam, Air and Gas								
Working Pressure	<table border="1"> <thead> <tr> <th>Condition of Fluid</th> <th>Max. Working Pressure</th> </tr> </thead> <tbody> <tr> <td>Steam, Air, Gas, & Oil not higher than 300°C</td> <td>1.0Mpa (10.2kgf / cm²)</td> </tr> <tr> <td>Steam, Air, Gas, Oil, Pulsating water not higher than 220°C</td> <td>1.4Mpa (14.3kgf / cm²)</td> </tr> <tr> <td>Nonpulsating water not higher than 120°C</td> <td>2.0Mpa (20.4kgf / cm²)</td> </tr> </tbody> </table>	Condition of Fluid	Max. Working Pressure	Steam, Air, Gas, & Oil not higher than 300°C	1.0Mpa (10.2kgf / cm ²)	Steam, Air, Gas, Oil, Pulsating water not higher than 220°C	1.4Mpa (14.3kgf / cm ²)	Nonpulsating water not higher than 120°C	2.0Mpa (20.4kgf / cm ²)
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Tested By	Setsco Services Pte Ltd (Singapore) SIRIM QAS International Sdn Bhd (Malaysia)								



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This warranty is void to any product which has been subject to misuse, negligence or accident, which has been repaired or altered in any manner outside of the factory or which has been used in a manner contrary to instructions or recommendations. Seng Choon shall not be responsible for design errors due to inaccurate or incomplete information supplied by the buyer or its representatives.

The manufacturer reserves the right to make changes without prior notification.

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Kinko Fittings

Quality Malleable Iron Pipe Fittings and Solutions



Thread Dimensions

1	2	3	4	Basic Diameters at Gauge Plane			Gauge Length (Distance of Gauge Plane from Pipe End)				
				Major (Gauge Diameter)	Pitch	Minor	Basic	Tolerance + and - T/2		Max.	Min.
								Turns of Thread			
		p	h	d	d2	d1					
1/16	28	0.007	0.581	7.723	7.142	6.561	4.0	0.9	1	4.9	3.1
1/8	28	0.007	0.581	9.728	9.147	8.566	4.0	0.9	1	4.9	3.1
1/4	19	1.337	0.856	13.157	12.301	11.445	6.0	1.3	1	7.3	4.7
3/8	19	1.337	0.856	16.662	15.806	14.950	6.4	1.3	1	7.7	5.1
1/2	14	1.814	1.162	20.995	19.793	18.631	8.2	1.8	1	10.0	6.4
3/4	14	1.814	1.162	26.441	25.279	24.117	9.5	1.8	1	11.3	7.7
1	11	2.303	1.479	33.249	31.770	30.291	10.4	2.3	1	12.7	8.1
1 1/4	11	2.303	1.479	41.910	40.431	38.952	12.7	2.3	1	15.0	10.4
1 1/2	11	2.303	1.479	47.803	46.324	44.845	12.7	2.3	1	15.0	10.4
2	11	2.303	1.479	59.614	58.135	56.656	15.9	2.3	1	18.2	13.6
2 1/2	11	2.303	1.479	75.184	73.705	72.226	17.5	3.5	1 1/2	21.0	14.0
3	11	2.303	1.479	87.894	86.405	84.926	20.6	3.5	1 1/2	24.1	17.1
4	11	2.303	1.479	113.030	111.551	110.072	25.4	3.5	1 1/2	28.9	21.9
5	11	2.303	1.479	139.430	136.951	135.472	28.6	3.5	1 1/2	32.1	25.1

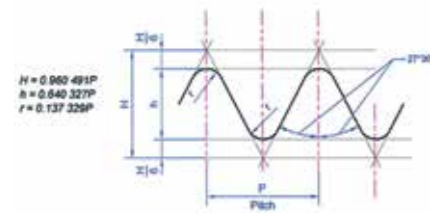


Figure 1 Parallel Thread

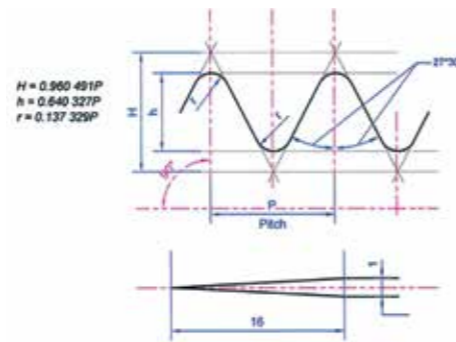


Figure 2 Taper Thread

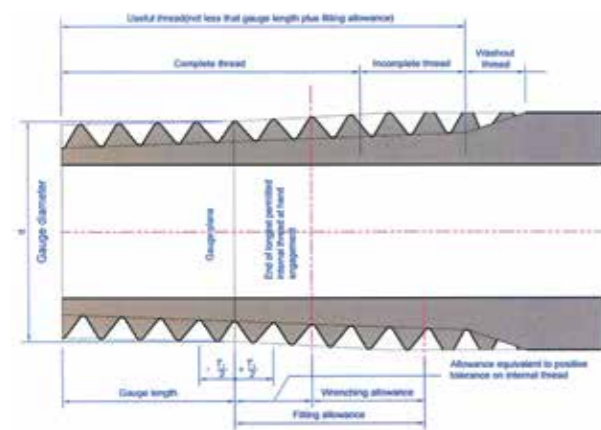


Figure 3 Terms/Clating to Pipe Threads

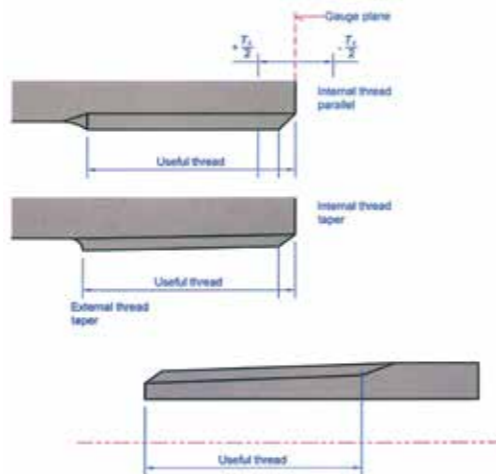


Figure 4 Position of Gauge Plane, Useful Thread

13		14		15		16		17		18		19	
Position of Gaugeplane on Internal Threads		Length of Useful Threads on Pipe End 2) Not Less Than		For Basic Gauge Length		For Max. Gauge Length		For Min. Gauge Length		Fitting Allowance		Turns of Thread	
Tolerance 3) + and - T/2		Turns of Thread										Turns of Thread	
1.1	1 1/4	6.5	7.4	5.6	2.5	2 3/4							
1.1	1 1/4	6.5	7.4	5.6	2.5	2 3/4							
1.7	1 1/4	9.7	11.0	8.4	3.7	2 3/4							
1.7	1 1/4	10.1	11.4	8.8	3.7	2 3/4							
2.3	1 1/4	13.2	15.0	11.4	5.0	2 3/4							
2.3	1 1/4	14.5	16.3	12.7	5.0	2 3/4							
2.9	1 1/4	16.8	19.1	14.5	6.4	2 3/4							
2.9	1 1/4	19.1	21.4	16.8	6.4	2 3/4							
2.9	1 1/4	19.1	21.4	16.8	6.4	2 3/4							
2.9	1 1/4	23.4	25.7	21.1	7.5	3 1/4							
3.5	1 1/2	26.7	30.2	23.2	9.2	4							
3.5	1 1/2	29.0	33.3	26.3	9.2	4							
3.5	1 1/2	35.8	39.3	32.3	10.4	4 1/2							
3.5	1 1/2	40.1	43.6	36.6	11.5	5							

Unit: mm



Qualities & Inspections

	Qualities	Inspections						
Leakage	The fittings, when subjected to a pneumatic pressure of 0.5Mpa (5.1kgf/cm ²), shall not suffer any leakage.	1. Type 2. Acceptance						
Pressure Resistance	The fittings, when subjected to a hydraulic pressure of 2.5Mpa (25.5kgf/cm ²), shall be free from breakage or other abnormalities.	1. Type						
Screw Threads	The screw threads for fittings shall be taper pipe threads specified in JIS B0203.	1. Type 2. Acceptance						
Deviation Axial Lines of Threads	The angular deviation between respective axial lines of threads shall be 2mm or less for a distance of 300mm.	1. Type 2. Acceptance						
Plating	Whereas the plating is to be processed, fittings shall be plated by hot zinc dipping prior to thread cutting, and layer of plating shall have a uniform adhesion to the plated surfaces.	1. Type						
Shapes and Dimension	<ul style="list-style-type: none"> The shapes and dimensions of fittings shall be in accordance with JIS B2301 (Tables 2-18). The shapes and dimensions may conform to ISO 49-1983 (Malleable cast iron fittings threaded to ISO 7/1) The tolerances on basic dimensions for lengths from one end face to the center or to another end face shall conform to Table 4, and other dimensions represent recommended values. 	1. Type 2. Acceptance						
Basic Dimension (Unit: mm)	30 & under	30-50	50-75	75-100	100-150	150-200	200-300	300-400
Tolerance	±1.5	±2.0	±2.5	±3.0	±3.5	±4.0	±5.0	±6.0

