



Kinko Fittings

Quality Malleable Iron Pipe Fittings and Solutions



Thread Dimensions

1	2	3	4	5	6	7	8	9	10	11	12
Designation of Thread	Number of Threads in 25.4mm	Pitch	Depth of Thread	Basic Diameters at Gauge Plane			Gauge Length (Distance of Gauge Plane from Pipe End)				
				Major (Gauge Diameter)	Pitch	Minor	Basic	Tolerance + and - T ₁ /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	30.952	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
6	11	2.303	1.479	163.830	162.351	160.872	28.6	3.5	1 1/2	32.1	25.1

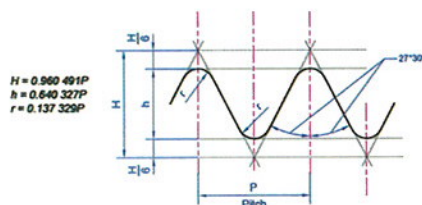


Figure 1
Parallel Thread

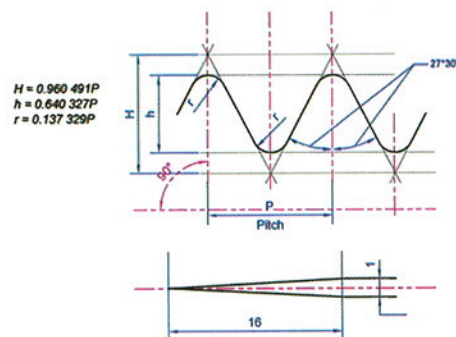


Figure 2
Taper Thread

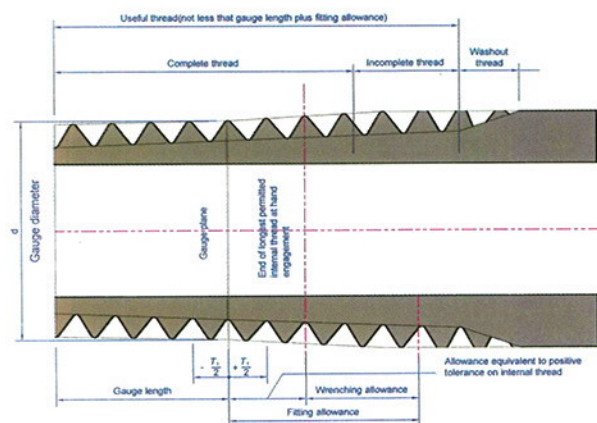


Figure 3
Terms/Clating to Pipe Threads

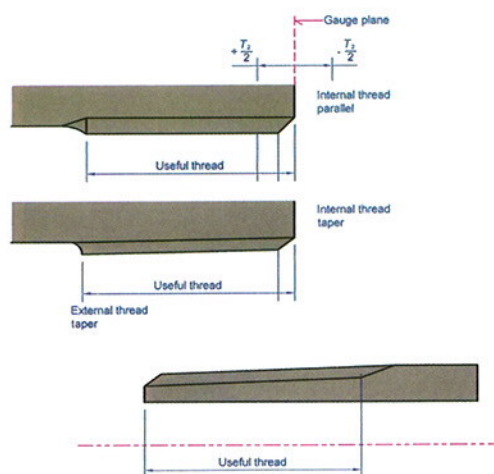


Figure 4
Position of Gauge Plane, Useful Thread

Unit: mm

13	14	15	16	17	18	19
Position of Gaugeplane on Internal Threads		Length of Useful Threads on Pipe End 2) Not Less Than			Fitting Allowance	
Tolerance 3) + and - $T_z/2$		For Basic Gauge Length	For Max. Gauge Length	For Min. Gauge Length		
	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
3.5	1 1/2	40.1	43.6	36.6	11.5	5



45° Elbow, Banded, Equal



90° Elbow, Banded, Equal



90° Street Elbow, Banded, Equal



90° Elbow, Banded, Reducing



90° Bend, M&F, Banded



Cross, Banded, Equal



Tee, Banded, Reducing



Tee, Banded, Unequal, Reducing



Tee, Banded, Equal



Plug



Cap, Banded



Bush, Reducing



Hexagon Nipple, Equal



Union, Standard, Flat Seat, without Gasket



Hexagon Nipple, Reducing



Socket, Banded, Reducing

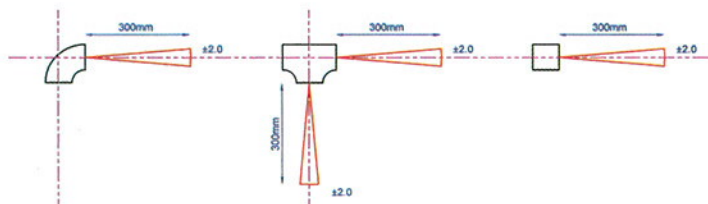


Socket, Banded, Equal



Round Flange, with Bolt Hole

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

International Standard

- British Standard: ISO 5922 / ISO 49 / ISO 7 / 1
- American Standard: ANSI/ASME A197-79 / B16.3-85 / B1.20.1-83
- DIN Standard: DIN 2950 / 1692 / 2999

Specifications

- Material: BS 310-1972, DIN 1692-1982, ASTM 197-1979, JIS G5702-1978
- Dimensions: BS 143 & 1256-1968, DIN 2950-1983, ANSI B16.3-1977, JIS B2301-1976
- Types of Threading: BS 21-1973, DIN 2999-1983, ANSI B2.1-1968, JIS B0203-1982
- Galvanizing: BS729-1971, DIN 2444-1987, ASTM A153-1982, JIS H8641-19

Surface Treatment

Galvanized (Hot-dipped Zinc coated)

Available Size

1/8" up to 6"

Applicable

Water, Oil, Steam, Air and Gas

Working Pressure**Condition of Fluid**

Steam, Air, Gas, & Oil not higher than 300°C
 Steam, Air, Gas, Oil, Pulsating water not higher than 220°C
 Nonpulsating water not higher than 120°C

Max. Working Pressure

1.0Mpa (10.2kgf / cm²)
 1.4Mpa (14.3kgf / cm²)
 2.0Mpa (20.4kgf / cm²)

Markings**Marking on the Product**

The fitting shall be marked with the following information by casting or by an equivalent method:

- Nominal size
- Manufacturer's name of its abbreviation or brand

Marking on the Package

The package shall be marked with the following information:

- Type
- Nominal size
- Manufacturer's name
- Quantity

Tested By

Setsco Services Pte Ltd (Singapore)
 SIRIM QAS International Sdn Bhd (Malaysia)



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www.sengchoon.com**WARRANTY**

Seng Choon Engineering Pte Ltd and Seng Choon Hardware (M) Sdn Bhd (herein referred to as Seng Choon or the Company) for a period of 12 months from date of delivery to original buyer will repair or replace, without charge, products which our examination proves to be defective in design, material and workmanship under normal conditions of use and service. If, after examination of the product, we are of the opinion that the product or alleged defects is not covered by the warranty for whatever reason, the buyer is liable for any labour, parts or transport costs incurred by Seng Choon.

This warranty is made expressly in lieu of any other warranties, expressed or implied. The buyer's sole and exclusive remedy shall be for the repair or replacement of defective products as provided herein. The Company is not responsible for any expenses (including shipping, installation and removal) or incidental or consequential damages caused by items of our manufacture or sale. Seng Choon neither assumes nor authorizes any person to assume for it any other liability in connection with the sale of such products.

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.