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**Thermoplastics piping systems for  
fluids under pressure — Flange  
adapters and loose backing flanges —  
Mating dimensions**

*Systèmes de canalisations thermoplastiques pour fluides sous  
pression — Collets et brides folles plates — Dimensions de  
raccordement*

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## Foreword

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

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 2, *Plastics pipes and fittings for water supplies*.

This second edition cancels and replaces the first edition (ISO 9624:1997), which has been technically revised.

The main changes compared to the previous edition are:

- increase of dimensions up to 2 500 mm;
- technical consistency with industrial applications standards;
- addition of two informative annexes on gaskets and torque application.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

## Introduction

This document covers the dimensions of flange adapters and loose backing flanges which are commonly used in the connection of plastic piping systems to valves, pumping stations or other equipment, and to pipelines of the same or other material. Some equipment (e.g. butterfly valves) may require specific designs that are not covered by this document.

This revised version of this document covers dimensions allowing the connection of plastic piping systems up to DN 2500, to answer the increasing demand of large dimensions on the market.

Flanged joints should be able to transfer long-term axial forces with maintained tightness, which requires use of suitable components and a correct assembly. This revised version includes informative annexes addressing joint design and torque application and gives bibliographic references to installation guidelines which are available on the market.

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# Thermoplastics piping systems for fluids under pressure — Flange adapters and loose backing flanges — Mating dimensions

## 1 Scope

This document specifies the mating dimensions for thermoplastic flange adapters and corresponding loose backing flanges intended to be used in thermoplastic piping systems for the conveyance of fluids under pressure.

It applies to flange adapters and loose backing flanges for use with pipes with nominal outside diameters ( $d_n$ ) from 16 mm to 2 500 mm and nominal pressures up to 25 bar<sup>1)</sup> (PN 25).

This document specifies the dimensions of the flange adapters intended to be used for:

- butt fusion piping systems;
- socket fusion piping systems;
- adhesive jointed piping systems.

NOTE 1 For specific connections with dimensions (e.g.  $d_n$  450 or  $d_n$  630) not covered in this document, or specific equipment (butterfly valves), specific solutions are available on the market.

This document is applicable to loose backing flanges made from metal, thermoplastics, or a combination of metal and thermoplastics.

This document also provides information on gaskets and gives general recommendations on correct assembling practices.

NOTE 2 Industrial applications are not covered by this document. Products intended for industrial application are covered by ISO 15493<sup>[1]</sup>, ISO 15494 or ISO 10931<sup>[2]</sup>.

## 2 Normative references

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

ISO 261, *ISO general purpose metric screw threads — General plan*

ISO 727-1, *Fittings made from unplasticized poly(vinyl chloride) (PVC-U), chlorinated poly(vinyl chloride) (PVC-C) or acrylonitrile/butadiene/styrene (ABS) with plain sockets for pipes under pressure — Part 1: Metric series*

ISO 1452-3, *Plastics piping systems for water supply and for buried and above-ground drainage and sewerage under pressure — Unplasticized poly(vinyl chloride) (PVC-U) — Part 3: Fittings*

ISO 4427-3, *Plastics piping systems — Polyethylene (PE) pipes and fittings for water supply — Part 3: Fittings*

ISO 7005-1, *Pipe flanges — Part 1: Steel flanges for industrial and general service piping systems*

1) 1 bar = 0,1 MPa = 10<sup>5</sup> N/m<sup>2</sup>.

ISO 15494, *Plastics piping systems for industrial applications — Polybutene (PB), polyethylene (PE), polyethylene of raised temperature resistance (PE-RT), crosslinked polyethylene (PE-X), polypropylene (PP) — Metric series for specifications for components and the system*

ISO 15874-3, *Plastics piping systems for hot and cold water installations — Polypropylene (PP) — Part 3: Fittings*

EN 1092-1, *Flanges and their joints — Circular flanges for pipes, valves, fittings and accessories, PN designated — Part 1: steel flanges*

### 3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

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

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

#### 3.1 nominal outside diameter

$d_n$   
specified outside diameter, in millimetres, assigned to a nominal size DN/OD

Note 1 to entry: The nominal outside diameter  $d_n$  of pipes is given in ISO 161-1<sup>[3]</sup>.

#### 3.2 nominal size DN

numerical designation of the size of a flange for reference purposes and only loosely related to manufacturing dimensions

#### 3.3 nominal pressure PN

numerical designation used for reference purposes related to the mechanical characteristics of the component of a piping system

Note 1 to entry: For plastic piping systems conveying water (including flange adapters), the PN symbols correspond to the allowable operating pressure (PFA) in bar, which can be sustained with water at 20 °C with a design basis of 50 years, and based on the minimum design coefficient in accordance with ISO 12162<sup>[4]</sup>. For loose backing flanges, the PN symbol is used to indicate its geometrical characteristics.

### 4 Symbols and abbreviated terms

$d_n$  nominal (outside) diameter of connecting pipe and flange adapters, and  
nominal (inside) diameter of the socket

D outside diameter of loose backing flange

DN size designation of loose backing flange

$D_1$  bolt hole diameter

$D_2$  inside diameter of loose backing flange

$D_3$  pitch circle diameter

|       |  |
|-------|--|
| $D_4$ | outside diameter of flange adapter head  |
| $D_5$ | outside diameter of flange adapter shank |
| $n$   | number of bolt holes                     |
| $r_f$ | radius of shoulder of flange adapter     |

## 5 Dimensions

### 5.1 General

Loose backing flanges shall be designated by the relevant PN symbol, in consistency with [Table 2](#) to [Table 4](#), [Table 6](#) or [Table 8](#) as appropriate.

NOTE 1 The values of the outside diameter  $D$  of the loose backing flange and the pitch circle diameter  $D_3$  of the bolts are taken from EN 1092-1.

NOTE 2 The values of the bolt hole diameter  $D_1$  are taken from series medium in ISO 273.

The inside diameter  $D_2$  of the loose backing flange shall conform to the design of the flange adapter.

Unless otherwise specified, the diameters of the flange adapters as specified in [Table 1](#), [Table 5](#) and [Table 7](#) shall be suitable with the corresponding loose backing flanges, and therefore comply with ISO 7005-1 using the appropriate tolerances as given in EN 1092-1.

Flange adapters shall be designed in order to prevent stress concentration at any changes in cross section. The thickness of the flange adapter face and loose backing flange shall be dependent on the material used in the manufacture of the adapter and on the nominal pressure (PN) of the piping system for which it is designed.

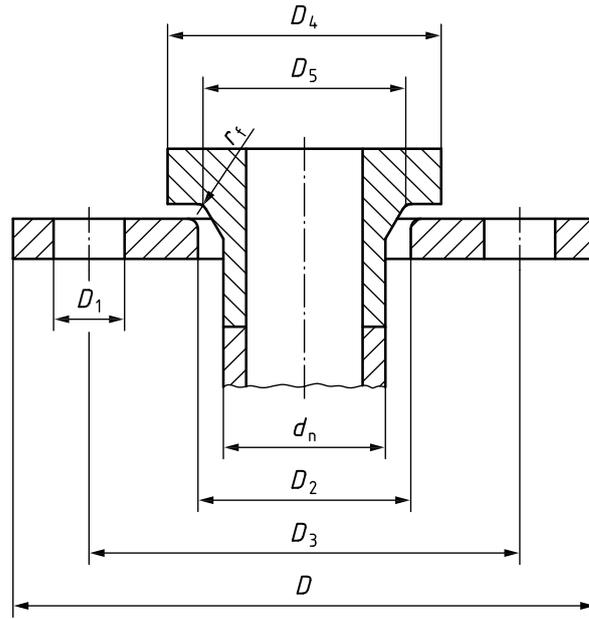
Flange adapters according to [Table 1](#) shall be associated with flanges of same  $d_n$ , from [Tables 2, 3](#) or [4](#) as relevant.

NOTE 3 The figures are schematic only, to indicate the relevant dimensions. They do not necessarily represent manufactured components, e.g. flange adapter with special geometry for connecting butterfly valves.

### 5.2 Butt fusion systems

The dimensions of the spigot ends shall comply with the relevant pipe system standard, e.g. ISO 4427-3.

All dimensions shall be measured in accordance with [Figure 1](#).



**Key**

- $d_n$  nominal (outside) diameter of connecting pipe and nominal (inside) diameter of the socket
- $D$  outside diameter of loose backing flange
- $D_1$  bolt hole diameter
- $D_2$  inside diameter of loose backing flange
- $D_3$  pitch circle diameter
- $D_4$  outside diameter of flange adapter head
- $D_5$  outside diameter of flange adapter shank
- $r_f$  radius of shoulder of flange adapter

**Figure 1 — Butt fusion systems**

For butt fusion systems, the dimensions of the flange adapters shall conform to those given in [Table 1](#).

**Table 1 — Flange adapters — Dimensions for butt fusion systems**

| Nominal outside diameter of pipe and spigot <sup>a</sup> | Outside diameter of flange adapter head <sup>b</sup> | Outside diameter of flange adapter shank <sup>c</sup> | Radius of shoulder of flange adapter |
|--|--|---|--------------------------------------|
| $d_n$  | $D_4 \text{ min}$                                    | $D_5 \text{ min}$                                     | $r_f$<br>(+0,5 / -0,5)               |
| 16   | 40   | 22  | 3                                    |
| 20   | 45   | 27  | 3                                    |
| 25   | 58   | 33  | 3                                    |
| 32   | 68   | 40  | 3                                    |
| 40   | 78   | 50  | 3                                    |
| 50   | 88   | 61  | 3                                    |
| 63   | 102  | 75  | 4                                    |
| 75   | 122  | 89  | 4                                    |

<sup>a</sup> The diameter of the spigot shall conform to the relevant product standard.

<sup>b</sup> The actual value of  $D_4$  should be as high as possible to ensure fitness for purpose of the assembly. See [Annex C](#) for higher recommended values of  $D_4$  for PE100 flange adapters.

<sup>c</sup>  $D_5$  shall be measured in the middle of the radius  $r_f$ .

Table 1 (continued)

| Nominal outside diameter of pipe and spigot <sup>a</sup> | Outside diameter of flange adapter head <sup>b</sup> | Outside diameter of flange adapter shank <sup>c</sup> | Radius of shoulder of flange adapter<br>$r_f$<br>(+0,5 / -0,5) |
|--|--|---|--|
| $d_n$  | $D_{4 \text{ min}}$                                  | $D_{5 \text{ min}}$                                   |  |
| 90   | 138  | 105   | 4  |
| 110  | 158  | 125   | 4  |
| 125  | 158  | 132   | 4  |
| 140  | 188  | 155   | 4  |
| 160  | 212  | 175   | 4  |
| 180  | 212  | 183   | 4  |
| 200  | 268  | 232   | 4  |
| 225  | 268  | 235   | 4  |
| 250  | 320  | 285   | 4  |
| 280  | 320  | 291   | 4  |
| 315  | 370  | 335   | 4  |
| 355  | 430  | 373   | 6  |
| 400  | 482  | 427   | 6  |
| 450  | 585  | 514   | 6  |
| 500  | 585  | 530   | 6  |
| 560  | 685  | 615   | 6  |
| 630  | 685  | 642   | 6  |
| 710  | 800  | 737   | 8  |
| 800  | 905  | 840   | 8  |
| 900  | 1 005  | 944   | 8  |
| 1 000  | 1 110  | 1 047   | 8  |
| 1 200  | 1 330  | 1 245   | 8  |
| 1 400  | 1 540  | 1 450   | 8  |
| 1 600  | 1 760  | 1 650   | 10   |
| 1 800  | 1 960  | 1 860   | 10   |
| 2 000  | 2 170  | 2 070   | 10   |
| 2 250  | 2 435  | 2 320   | 10   |
| 2 500  | 2 730  | 2 550   | 10   |

<sup>a</sup> The diameter of the spigot shall conform to the relevant product standard.

<sup>b</sup> The actual value of  $D_4$  should be as high as possible to ensure fitness for purpose of the assembly. See [Annex C](#) for higher recommended values of  $D_4$  for PE100 flange adapters.

<sup>c</sup>  $D_5$  shall be measured in the middle of the radius  $r_f$ .

The dimensions of PN 10 designated loose backing flanges shall conform to those given in [Table 2](#).

Table 2 — PN 10 designated loose backing flange dimensions for butt fusion systems

| DN                 | Nominal<br>outside<br>diameter of<br>pipe<br>$d_n$ | PN 10 designated loose backing flanges |                             |                                   |                                |               |                              |
|--------------------|--|--|-----------------------------|-----------------------------------|--------------------------------|---------------|------------------------------|
|                    |  | Outside<br>diameter<br>$D_{min}$       | Inside<br>diameter<br>$D_2$ | Pitch circle<br>diameter<br>$D_3$ | Bolts                          |               |                              |
|                    |  |  |                             |                                   | Bolt hole<br>diameter<br>$D_1$ | Number<br>$n$ | Screw<br>thread <sup>a</sup> |
| 10                 | 16   | 90                                     | 23                          | 60                                | 14                             | 4             | M12                          |
| 15                 | 20   | 95                                     | 28                          | 65                                | 14                             | 4             | M12                          |
| 20                 | 25   | 105                                    | 34                          | 75                                | 14                             | 4             | M12                          |
| 25                 | 32   | 115                                    | 42                          | 85                                | 14                             | 4             | M12                          |
| 32                 | 40   | 140                                    | 51                          | 100                               | 18                             | 4             | M16                          |
| 40                 | 50   | 150                                    | 62                          | 110                               | 18                             | 4             | M16                          |
| 50                 | 63   | 165                                    | 78                          | 125                               | 18                             | 4             | M16                          |
| 65                 | 75   | 185                                    | 92                          | 145                               | 18                             | 4             | M16                          |
| 80                 | 90   | 200                                    | 108                         | 160                               | 18                             | 8             | M16                          |
| 100                | 110  | 220                                    | 128                         | 180                               | 18                             | 8             | M16                          |
| 100                | 125  | 220                                    | 135                         | 180                               | 18                             | 8             | M16                          |
| 125                | 140  | 250                                    | 158                         | 210                               | 18                             | 8             | M16                          |
| 150                | 160  | 285                                    | 178                         | 240                               | 22                             | 8             | M20                          |
| 150                | 180  | 285                                    | 188                         | 240                               | 22                             | 8             | M20                          |
| 200                | 200  | 340                                    | 235                         | 295                               | 22                             | 8             | M20                          |
| 200                | 225  | 340                                    | 238                         | 295                               | 22                             | 8             | M20                          |
| 250                | 250  | 395                                    | 288                         | 350                               | 22                             | 12            | M20                          |
| 250                | 280  | 395                                    | 294                         | 350                               | 22                             | 12            | M20                          |
| 300                | 315  | 445                                    | 338                         | 400                               | 22                             | 12            | M20                          |
| 350                | 355  | 505                                    | 376                         | 460                               | 22                             | 16            | M20                          |
| 400                | 400  | 565                                    | 430                         | 515                               | 26                             | 16            | M24                          |
| 500                | 450  | 670                                    | 517                         | 620                               | 26                             | 20            | M24                          |
| 500                | 500  | 670                                    | 533                         | 620                               | 26                             | 20            | M24                          |
| 600                | 560  | 780                                    | 618                         | 725                               | 30                             | 20            | M27                          |
| 700                | 630  | 895                                    | 645                         | 840                               | 30                             | 24            | M27                          |
| 700                | 710  | 895                                    | 740                         | 840                               | 30                             | 24            | M27                          |
| 800                | 800  | 1 015                                  | 843                         | 950                               | 33                             | 24            | M30                          |
| 900                | 900  | 1 115                                  | 947                         | 1 050                             | 33                             | 28            | M30                          |
| 1 000              | 1 000  | 1 230                                  | 1 050                       | 1 160                             | 36                             | 28            | M33                          |
| 1 200              | 1 200  | 1 455                                  | 1 260                       | 1 380                             | 39                             | 32            | M36                          |
| 1 400              | 1 400  | 1 675                                  | 1 470                       | 1 590                             | 42                             | 36            | M39                          |
| 1 600              | 1 600  | 1 915                                  | 1 670                       | 1 820                             | 48                             | 40            | M45                          |
| 1 800              | 1 800  | 2 115                                  | 1 875                       | 2 020                             | 48                             | 44            | M45                          |
| 2 000              | 2 000  | 2 325                                  | 2 085                       | 2 230                             | 48                             | 48            | M45                          |
| 2 250 <sup>b</sup> | 2 250  | 2 610                                  | 2 335                       | 2 495                             | 56                             | 52            | M52                          |
| 2 500 <sup>b</sup> | 2 500  | 2 960                                  | 2 570                       | 2 804                             | 56                             | 60            | M52                          |

<sup>a</sup> Metric screw thread sizes in millimetres conforming to ISO 261.

<sup>b</sup> These dimensions are not specified in EN 1092-1.

The dimensions of PN 16 designated loose backing flanges shall conform to those given in [Table 3](#).

Table 3 — PN 16 designated loose backing flange dimensions for butt fusion systems

| DN <sup>a</sup> | Nominal outside diameter of pipe<br>$d_n$ | PN 16 designated loose backing flanges |                          |                                |                             |               |                           |
|-----------------|---|--|--------------------------|--------------------------------|-----------------------------|---------------|---------------------------|
|                 |   | Outside diameter<br>$D_{min}$          | Inside diameter<br>$D_2$ | Pitch circle diameter<br>$D_3$ | Bolts                       |               |                           |
|                 |   |  |                          |                                | Bolt hole diameter<br>$D_1$ | Number<br>$n$ | Screw thread <sup>b</sup> |
| 200             | 200                                       | 340                                    | 235                      | 295                            | 22                          | 12            | M20                       |
| 200             | 225                                       | 340                                    | 238                      | 295                            | 22                          | 12            | M20                       |
| 250             | 250                                       | 405                                    | 288                      | 355                            | 26                          | 12            | M24                       |
| 250             | 280                                       | 405                                    | 294                      | 355                            | 26                          | 12            | M24                       |
| 300             | 315                                       | 460                                    | 338                      | 410                            | 26                          | 12            | M24                       |
| 350             | 355                                       | 520                                    | 376                      | 470                            | 26                          | 16            | M24                       |
| 400             | 400                                       | 580                                    | 430                      | 525                            | 30                          | 16            | M27                       |
| 500             | 450                                       | 715                                    | 517                      | 650                            | 33                          | 20            | M30                       |
| 500             | 500                                       | 715                                    | 533                      | 650                            | 33                          | 20            | M30                       |
| 600             | 560                                       | 840                                    | 618                      | 770                            | 36                          | 20            | M33                       |
| 700             | 630                                       | 910                                    | 645                      | 840                            | 36                          | 24            | M33                       |
| 700             | 710                                       | 910                                    | 740                      | 840                            | 36                          | 24            | M33                       |
| 800             | 800                                       | 1 025                                  | 843                      | 950                            | 39                          | 24            | M36                       |
| 900             | 900                                       | 1 125                                  | 947                      | 1 050                          | 39                          | 28            | M36                       |
| 1 000           | 1 000                                     | 1 255                                  | 1 050                    | 1 170                          | 42                          | 28            | M39                       |
| 1 200           | 1 200                                     | 1 485                                  | 1 260                    | 1 390                          | 48                          | 32            | M45                       |
| 1 400           | 1 400                                     | 1 685                                  | 1 470                    | 1 590                          | 48                          | 36            | M45                       |
| 1 600           | 1 600                                     | 1 930                                  | 1 670                    | 1 820                          | 56                          | 40            | M52                       |

<sup>a</sup> For loose backing flanges up to and including size DN 150, dimensions shall be as given in [Table 2](#).

<sup>b</sup> Metric screw thread sizes in millimetres conforming to ISO 261.

The dimensions of PN 25 designated loose backing flanges shall conform to those given in [Table 4](#).

Table 4 — PN 25 designated loose backing flange dimensions for butt fusion systems

| DN <sup>a</sup> | Nominal outside diameter of pipe<br>$d_n$ | PN 25 designated loose backing flanges |                          |                                |                             |               |                           |
|-----------------|---|--|--------------------------|--------------------------------|-----------------------------|---------------|---------------------------|
|                 |   | Outside diameter<br>$D_{min}$          | Inside diameter<br>$D_2$ | Pitch circle diameter<br>$D_3$ | Bolts                       |               |                           |
|                 |   |  |                          |                                | Bolt hole diameter<br>$D_1$ | Number<br>$n$ | Screw thread <sup>b</sup> |
| 100             | 110                                       | 235                                    | 128                      | 190                            | 22                          | 8             | M20                       |
| 100             | 125                                       | 235                                    | 135                      | 190                            | 22                          | 8             | M20                       |
| 125             | 140                                       | 270                                    | 158                      | 220                            | 26                          | 8             | M24                       |
| 150             | 160                                       | 300                                    | 178                      | 250                            | 26                          | 8             | M24                       |
| 150             | 180                                       | 300                                    | 188                      | 250                            | 26                          | 8             | M24                       |
| 200             | 200                                       | 360                                    | 235                      | 310                            | 26                          | 12            | M24                       |
| 200             | 225                                       | 360                                    | 238                      | 310                            | 26                          | 12            | M24                       |
| 250             | 250                                       | 425                                    | 288                      | 370                            | 30                          | 12            | M27                       |
| 250             | 280                                       | 425                                    | 294                      | 370                            | 30                          | 12            | M27                       |
| 300             | 315                                       | 485                                    | 338                      | 430                            | 30                          | 16            | M27                       |

<sup>a</sup> For loose backing flanges up to and including size DN 80, dimensions shall be as given in [Table 2](#).

<sup>b</sup> Metric screw thread sizes in millimetres conforming to ISO 261.

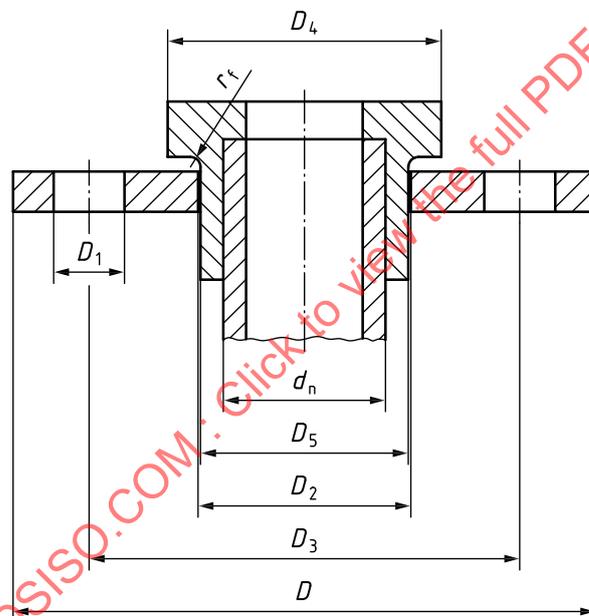
Table 4 (continued)

| DN <sup>a</sup> | Nominal outside diameter of pipe<br>$d_n$ | PN 25 designated loose backing flanges |                          |                                |                             |               |                           |
|-----------------|---|--|--------------------------|--------------------------------|-----------------------------|---------------|---------------------------|
|                 |   | Outside diameter<br>$D_{min}$          | Inside diameter<br>$D_2$ | Pitch circle diameter<br>$D_3$ | Bolts                       |               |                           |
|                 |   |  |                          |                                | Bolt hole diameter<br>$D_1$ | Number<br>$n$ | Screw thread <sup>b</sup> |
| 350             | 355                                       | 555                                    | 376                      | 490                            | 33                          | 16            | M30                       |
| 400             | 400                                       | 620                                    | 430                      | 550                            | 36                          | 16            | M33                       |
| 500             | 450                                       | 730                                    | 517                      | 660                            | 36                          | 20            | M33                       |
| 500             | 500                                       | 730                                    | 533                      | 660                            | 36                          | 20            | M33                       |

<sup>a</sup> For loose backing flanges up to and including size DN 80, dimensions shall be as given in Table 2.  
<sup>b</sup> Metric screw thread sizes in millimetres conforming to ISO 261.

### 5.3 Socket fusion systems

All dimensions shall be measured in accordance with Figure 2.



**Key**

- $d_n$  nominal (outside) diameter of connecting pipe and nominal (inside) diameter of the socket
- $D$  outside diameter of loose backing flange
- $D_1$  bolt hole diameter
- $D_2$  inside diameter of loose backing flange
- $D_3$  pitch circle diameter
- $D_4$  outside diameter of flange adapter head
- $D_5$  outside diameter of flange adapter shank
- $r_f$  radius of shoulder of flange adapter

Figure 2 — Socket fusion systems

For socket fusion systems, the dimensions of the flange adapter shall conform to those given in Table 5.

**Table 5 — Flange adapters — Dimensions for socket fusion systems**

| Nominal diameter of socket <sup>a</sup><br>$d_n$ | Outside diameter of flange adapter head<br>$D_{4 \text{ min}}$ | Outside diameter of flange adapter shank<br>$D_{5 \text{ min}}$ |
|--|--|---|
| 16   | 40   | 22  |
| 20   | 45   | 27  |
| 25   | 58   | 33  |
| 32   | 68   | 41  |
| 40   | 78   | 50  |
| 50   | 88   | 61  |
| 63   | 102  | 76  |
| 75   | 122  | 90  |
| 90   | 138  | 108   |
| 110  | 158  | 131   |

<sup>a</sup> Socket dimensions shall conform to the following standards as applicable:  
— ISO 4427-3 for PE;  
— ISO 15874-3 or ISO 15494 for PP.

For socket fusion systems, the dimensions of the loose backing flanges shall conform to those given in [Table 6](#).

**Table 6 — PN 10 and PN 16 designated loose backing flanges — Dimensions for socket fusion systems**

| DN  | Nominal outside diameter of pipe<br>$d_n$ | Outside diameter<br>$D_{\text{min}}$ | Inside diameter <sup>a,b</sup><br>$D_2$ | Pitch circle diameter<br>$D_3$ | Bolts                       |               |                           |
|-----|---|--------------------------------------|---|--------------------------------|-----------------------------|---------------|---------------------------|
|     |   |                                      |   |                                | Bolt hole diameter<br>$D_1$ | Number<br>$n$ | Screw thread <sup>c</sup> |
| 10  | 16  | 90                                   | 23                                      | 60                             | 14                          | 4             | M12                       |
| 15  | 20  | 95                                   | 28                                      | 65                             | 14                          | 4             | M12                       |
| 20  | 25  | 105                                  | 34                                      | 75                             | 14                          | 4             | M12                       |
| 25  | 32  | 115                                  | 42                                      | 85                             | 14                          | 4             | M12                       |
| 32  | 40  | 140                                  | 51                                      | 100                            | 18                          | 4             | M16                       |
| 40  | 50  | 150                                  | 62                                      | 110                            | 18                          | 4             | M16                       |
| 50  | 63  | 165                                  | 78                                      | 125                            | 18                          | 4             | M16                       |
| 65  | 75  | 185                                  | 92                                      | 145                            | 18                          | 4             | M16                       |
| 80  | 90  | 200                                  | 110                                     | 160                            | 18                          | 8             | M16                       |
| 100 | 110                                       | 220                                  | 133                                     | 180                            | 18                          | 8             | M16                       |

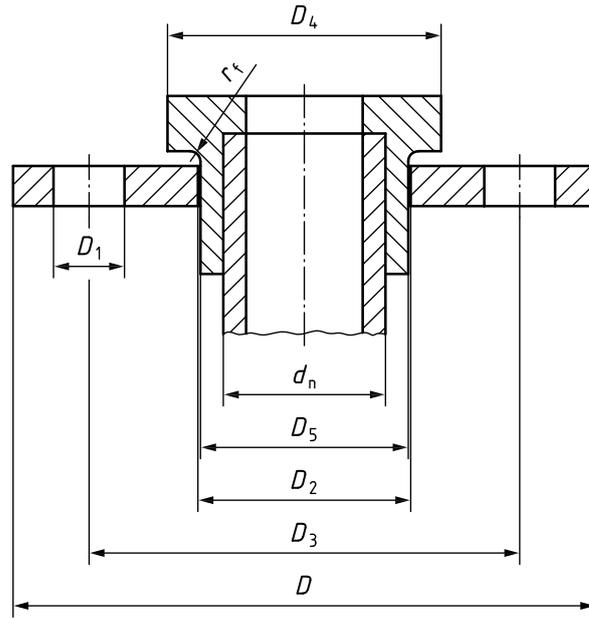
<sup>a</sup> These are standard steel flange dimensions. In some cases, different values may be used for  $D_2$ .

<sup>b</sup> Recommended permissible deviation for  $D_2$ :  
 $\Delta D_2 = +0 / -0,5$  when  $D_2 \leq 62$  mm  
 $\Delta D_2 = +0 / -1$  when  $D_2 > 62$  mm

<sup>c</sup> Metric screw thread sizes in millimetres conforming to ISO 261.

#### 5.4 Adhesive bonded systems

All dimensions shall be measured in accordance with [Figure 3](#).



**Key**

- $d_n$  nominal (outside) diameter of connecting pipe and nominal (inside) diameter of the socket
- $D$  outside diameter of loose backing flange
- $D_1$  bolt hole diameter
- $D_2$  inside diameter of loose backing flange
- $D_3$  pitch circle diameter
- $D_4$  outside diameter of flange adapter head
- $D_5$  outside diameter of flange adapter shank
- $r_f$  radius of shoulder of flange adapter

**Figure 3 — Adhesive bonded systems**

For adhesive bonded systems, the dimensions of the flange adapter shall conform to those given in [Table 7](#).

**Table 7 — Flange adapters — Dimensions for adhesive bonded systems**

| Nominal diameter of socket <sup>a</sup> | Outside diameter of flange adapter head | Outside diameter of flange adapter shank |
|---|---|--|
| $d_n$                                   | $D_{4 \text{ min}}$                     | $D_{5 \text{ min}}$                      |
| 16                                      | 29                                      | 22                                       |
| 20                                      | 34                                      | 27                                       |
| 25                                      | 41                                      | 33                                       |
| 32                                      | 50                                      | 41                                       |
| 40                                      | 61                                      | 50                                       |
| 50                                      | 73                                      | 61                                       |
| 63                                      | 90                                      | 76                                       |
| 75                                      | 105                                     | 90                                       |
| 90                                      | 125                                     | 108                                      |
| 110                                     | 150                                     | 131                                      |
| 125                                     | 168                                     | 148                                      |

<sup>a</sup> Socket dimensions shall conform to ISO 727-1, ISO 1452-3 or ISO 15493.

Table 7 (continued)

| Nominal diameter of socket <sup>a</sup><br>$d_n$ | Outside diameter of flange adapter head<br>$D_{4\min}$ | Outside diameter of flange adapter shank<br>$D_{5\min}$ |
|--|--|---|
| 140  | 188  | 165   |
| 160  | 212  | 188   |
| 180  | 247  | 201   |
| 200  | 250  | 224   |
| 225  | 273  | 245   |
| 250  | 303  | 270   |
| 280  | 327  | 307   |
| 315  | 377  | 346   |
| 355  | 430  | 384   |
| 400  | 482  | 438   |

<sup>a</sup> Socket dimensions shall conform to ISO 727-1, ISO 1452-3 or ISO 15493.

For adhesive bonded systems, the dimensions of the loose backing flanges shall conform to those given in Table 8.

Table 8 — PN 10 designated loose backing flanges — Dimensions for adhesive bonded systems

| DN  | Nominal outside diameter of pipe<br>$d_n$ | PN 10 designated loose backing flanges <sup>a</sup> |   |                                |                             |               |                           |
|-----|---|---|---|--------------------------------|-----------------------------|---------------|---------------------------|
|     |   | Outside diameter<br>$D_{\min}$                      | Inside diameter <sup>b,c</sup><br>$D_2$ | Pitch circle diameter<br>$D_3$ | Bolts                       |               |                           |
|     |   |   |   |                                | Bolt hole diameter<br>$D_1$ | Number<br>$n$ | Screw thread <sup>d</sup> |
| 10  | 16  | 90  | 23                                      | 60                             | 14                          | 4             | M12                       |
| 15  | 20  | 95  | 28                                      | 65                             | 14                          | 4             | M12                       |
| 20  | 25  | 105   | 34                                      | 75                             | 14                          | 4             | M12                       |
| 25  | 32  | 115   | 42                                      | 85                             | 14                          | 4             | M12                       |
| 32  | 40  | 140   | 51                                      | 100                            | 18                          | 4             | M16                       |
| 40  | 50  | 150   | 62                                      | 110                            | 18                          | 4             | M16                       |
| 50  | 63  | 165   | 78                                      | 125                            | 18                          | 4             | M16                       |
| 65  | 75  | 185   | 92                                      | 145                            | 18                          | 4             | M16                       |
| 80  | 90  | 200   | 110                                     | 160                            | 18                          | 8             | M16                       |
| 100 | 110                                       | 220   | 133                                     | 180                            | 18                          | 8             | M16                       |
| 125 | 125                                       | 250   | 150                                     | 210                            | 18                          | 8             | M16                       |
| 125 | 140                                       | 250   | 167                                     | 210                            | 18                          | 8             | M16                       |
| 150 | 160                                       | 285   | 190                                     | 240                            | 22                          | 8             | M20                       |
| 175 | 180                                       | 315   | 203                                     | 240                            | 22                          | 8             | M20                       |
| 200 | 200                                       | 340   | 226                                     | 295                            | 22                          | 8             | M20                       |
| 200 | 225                                       | 340   | 250                                     | 295                            | 22                          | 8             | M20                       |

<sup>a</sup> Up to and including DN150, the dimensions of the flanges are also applicable to PN 16 designated flanges.

<sup>b</sup> These are standard steel flange dimensions. In some cases, different values may be used for  $D_2$ .

<sup>c</sup> Recommended permissible deviation for  $D_2$ :

$$\Delta D_2 = +0 / -0,5 \text{ when } D_2 \leq 62 \text{ mm}$$

$$\Delta D_2 = +0 / -1 \text{ when } D_2 > 62 \text{ mm}$$

<sup>d</sup> Metric screw thread sizes in millimetres conforming to ISO 261.

Table 8 (continued)

| DN  | Nominal outside diameter of pipe<br>$d_n$ | PN 10 designated loose backing flanges <sup>a</sup> |   |                                |                             |               |                           |
|-----|---|---|---|--------------------------------|-----------------------------|---------------|---------------------------|
|     |   | Outside diameter<br>$D_{min}$                       | Inside diameter <sup>b,c</sup><br>$D_2$ | Pitch circle diameter<br>$D_3$ | Bolts                       |               |                           |
|     |   |   |   |                                | Bolt hole diameter<br>$D_1$ | Number<br>$n$ | Screw thread <sup>d</sup> |
| 250 | 250                                       | 370   | 277                                     | 325                            | 22                          | 8             | M20                       |
| 250 | 280                                       | 395   | 310                                     | 350                            | 22                          | 12            | M20                       |
| 300 | 315                                       | 445   | 348                                     | 400                            | 22                          | 12            | M20                       |
| 355 | 355                                       | 505   | 388                                     | 460                            | 22                          | 16            | M20                       |
| 400 | 400                                       | 565   | 442                                     | 515                            | 26                          | 16            | M24                       |

<sup>a</sup> Up to and including DN150, the dimensions of the flanges are also applicable to PN 16 designated flanges.

<sup>b</sup> These are standard steel flange dimensions. In some cases, different values may be used for  $D_2$ .

<sup>c</sup> Recommended permissible deviation for  $D_2$ :  
 $\Delta D_2 = +0 / -0,5$  when  $D_2 \leq 62$  mm  
 $\Delta D_2 = +0 / -1$  when  $D_2 > 62$  mm

<sup>d</sup> Metric screw thread sizes in millimetres conforming to ISO 261.

## 6 Gaskets

The gasket material shall be chemically and thermally compatible with the fluid in the pipe, and have an appropriate hardness. Gaskets are often made of rubber materials, but some other materials are also approved for use.

Attention is drawn to the joint design in order to allow the gasket to maintain its elastic behaviour.

## 7 Marking

### 7.1 Minimum required marking of flange adapters

Flange adapters shall be legibly marked in such a way that the marking does not initiate cracks or other types of failure. If ink printing is used, the colour of the printed information shall differ from the basic colour of the product.

The marking shall be such that it is legible without magnification.

NOTE The manufacturer is not responsible for marking that is illegible owing to actions caused during installation and use such as painting, scratching, covering of components or using detergents, etc. on the components unless agreed or specified by the manufacturer.

There shall be no marking over the minimum spigot length of the fitting.

The minimum required marking shall be in accordance with [Table 9](#).

**Table 9 — Minimum required marking of flange adapters**

| Aspect  | Marking        |
|---|----------------|
| Standard number <sup>a</sup>  | ISO 9624       |
| Size designation of flange adapter, $d_n$   | e.g. $d_n$ 250 |
| SDR series <sup>b</sup>   | e.g. SDR17     |
| Material and designation <sup>a</sup>   | e.g. PE 100    |
| Manufacturer identification   | Name or symbol |
| Traceability element (production date or code) <sup>a</sup>   | e.g. 0216      |
| <sup>a</sup> Marking may be affixed on a label, or on the packaging, or in the technical documentation. |                |
| <sup>b</sup> Not applicable for PVC material.   |                |

## 7.2 Minimum required marking of loose backing flanges

Loose backing flanges shall be legibly marked in such a way that the marking does not initiate cracks or other types of failure. If ink printing is used, the colour of the printed information shall differ from the basic colour of the product.

The marking shall be such that it is legible without magnification.

**NOTE** The manufacturer is not responsible for marking that is illegible owing to actions caused during installation and use such as painting, scratching, covering of components or using detergents, etc. on the components unless agreed or specified by the manufacturer.

The minimum required marking shall be in accordance with [Table 10](#).

**Table 10 — Minimum required marking of loose backing flanges**

| Aspect  | Marking        |
|---|----------------|
| Standard number <sup>a</sup>  | ISO 9624       |
| Size designation of loose backing flange, DN <sup>a</sup>   | e.g. DN250     |
| Pressure rating, PN   | e.g. PN 16     |
| Manufacturer identification   | Name or symbol |
| Traceability element (production date or code) <sup>a</sup>   | e.g. 0216      |
| <sup>a</sup> Marking may be affixed on a label, or on the packaging, or in the technical documentation. |                |

## Annex A (informative)

### Gaskets

Different types of gaskets may require different sealing pressures to ensure joint tightness.

The necessary sealing pressure for the gasket is normally proportional to the internal pressure in the pipe. As a rough rule of thumb, the sealing pressure should be at least twice the maximum internal pressure in the pipe.

Re-tightening during the installation or during the service regularly will normally decrease the risk for leakage. However, the selection of gasket type is important and will influence the performance of the joint. Drop-in steel core gaskets with or without integrated O-ring ([Figure A.1](#)) have been shown to have better performance than other types of gaskets.

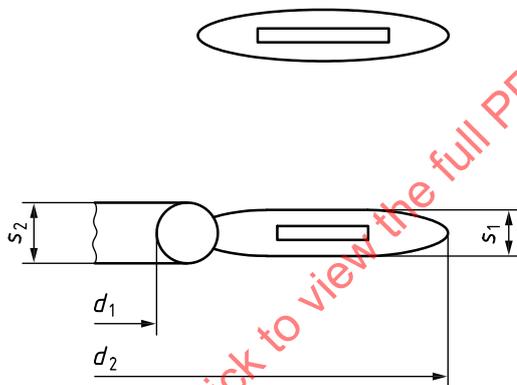


Figure A.1 — Typical steel core gasket design