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**Exhaust Flanges -- Industrial  
Engines — SAE J624a**

**SAE RECOMMENDED PRACTICE  
EDITORIAL CHANGE JUNE 1975**

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**SOCIETY OF AUTOMOTIVE ENGINEERS, INC.**  
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096



Report of Construction and Industrial Machinery Technical Committee  
 June 1960 and last revised June 1968. Editorial change June 1975.

TABLE 1 - DIMENSIONS FOR EXHAUST FLANGES (mm) IN

NPT of Companion Flange	Manifold Flange Hole Dia.	Hole Dia or Thread	Hole Center Distance	Radius of Flange Side	Radius of Flange Corner	Figure Number
P	X	H	A	D	R	
1-1/4	(35.1) 1.38	(11.2) 0.44 or 3/8-16	(69.8) 2.75	(28.7) 1.13	(11.2) 0.44	1
1-1/2	(41.4) 1.63	(11.2) 0.44 or 3/8-16	(76.2) 3.00	(31.8) 1.25	(11.2) 0.44	1
2	(52.3) 2.06	(11.2) 0.44 or 3/8-16	(88.9) 3.50	(38.1) 1.50	(11.2) 0.44	1
2-1/2	(60.5) 2.38	(11.2) 0.44 or 3/8-16	(70.6) 2.78		(11.2) 0.44	2
3	(73.2) 2.88	(11.2) 0.44 or 3/8-16	(81.8) 3.22		(11.2) 0.44	2
3-1/2	(85.9) 3.38	(11.2) 0.44 or 3/8-16	(90.9) 3.58		(17.8) 0.70	2
4	(101.6) 4.00	(14.2) 0.56 or 1/2-13	(104.7) 4.12		(17.8) 0.70	2
5	(127.0) 5.00	(17.5) 0.69 or 5/8-11	(127.0) 5.00		(17.8) 0.70	2
6	(152.4) 6.00	(20.6) 0.81 or 3/4-10	(152.4) 6.00		(22.4) 0.88	2

**NOTE:**

For sizes larger than 152.4 mm (6 in) NPT, use American Standard Class 125 pipe flanges. In these cases the manifold flange hole diameter should be approximately (3.1) 0.120 under the nominal corresponding pipe I.D.

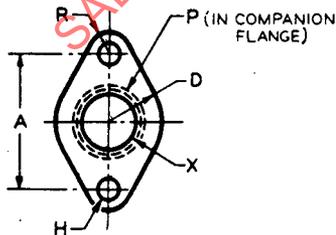


FIG. 1 - TWO HOLE FLANGE

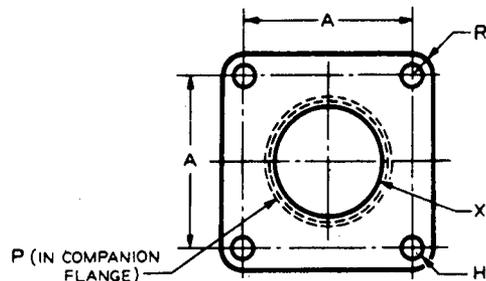


FIG. 2 - FOUR HOLE FLANGE