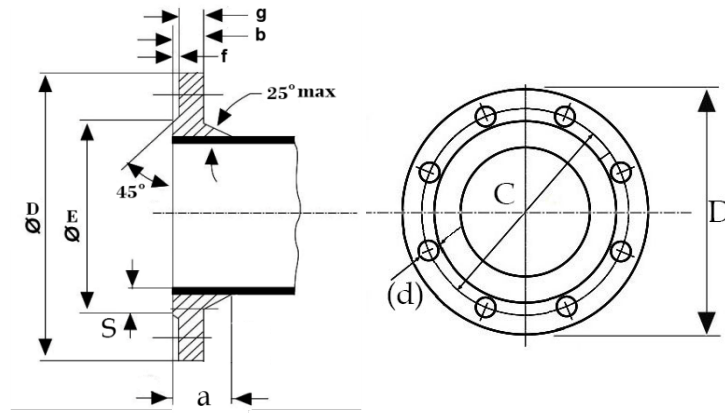


Standard Flange Drilling for Screwed / Welded Flange (PN 10)



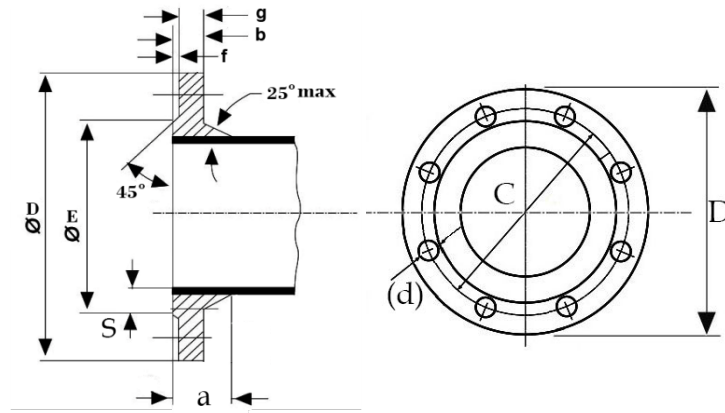
Nominal Diameter	PN – 10								Holes		Bolt		App Mass / Flange
	Dimensions										Size	Length	
DN	D	E	C	b	f	g	a	S	Number	Dia (d)	Metric	mm	
80	200	132	160	19.0	3.0	16.0	32	15.0	4	19	M16	100	3.0
100	220	156	180	19.0	3.0	16.0	32	15.0	8	19	M16	100	3.3
125	250	184	210	19.0	3.0	16.0	32	15.0	8	19	M16	100	4.0
150	285	211	240	19.0	3.0	16.0	32	15.0	8	23	M20	100	5.1
200	340	266	295	20.0	3.0	17.0	34	15.0	8	23	M20	100	7.1
250	395	319	350	22.0	3.0	19.0	48	16.0	12	23	M20	120	10.0
300	445	370	400	24.5	4.0	20.5	52	17.5	12	23	M20	120	13.0
350	505	429	460	24.5	4.0	20.5	52	19.5	16	23	M20	120	14.7
400	565	480	515	24.5	4.0	20.5	60	19.5	16	28	M24	130	17.7
450	615	530	565	25.5	4.0	21.5	63	20.0	20	28	M24	130	20.2
500	670	582	620	26.5	4.0	22.5	68	21.0	20	28	M24	130	24.3
600	780	682	725	30.0	5.0	25.0	75	24.0	20	31	M27	150	34.0
700	895	794	840	32.5	5.0	27.5	82	24.0	24	31	M27	150	46.0
750	960	857	900	34.0	5.0	29.0	87	24.0	24	31	M 27	150	55.0
800	1015	901	950	35.0	5.0	30.0	90	24.5	24	34	M30	170	62.0
900	1115	1001	1050	37.5	5.0	32.5	98	26.5	28	34	M30	170	73.0
1000	1230	1112	1160	40.0	5.0	35.0	105	28.0	28	37	M33	180	93.0
1100	1340	1231	1270	43.0	5.0	38.0	114	30.0	28	37	M33	180	113
1200	1455	1328	1380	45.0	5.0	40.0	120	31.5	32	40	M36	200	138

NOTE :-

1. The method of screwing and the exact form of thread shall be left to the discretion of manufacturer as the flange are never removed after screwing on the barrels of the pipe.
2. If so required the screwed flanges may be spot welded on the back side after screwing.
3. Dimensions 'A' and 'S' are for guidance only
4. Unless otherwise specified, flanges shall be of ductile iron.

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Standard Flange Drilling for Screwed / Welded Flange (PN 16)



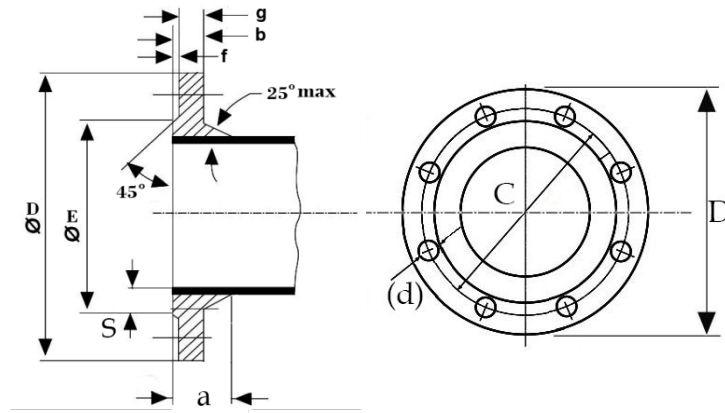
Nominal Diameter	PN – 16								Holes		Bolt		App Mass / Flange
	Dimensions										Size	Length	
DN	D	E	C	b	f	g	a	S	Number	Dia (d)	Metric	mm	
80	200	132	160	19.0	3	16.0	32	15.0	8	19	M16	100	3.0
100	220	156	180	19.0	3	16.0	32	15.0	8	19	M16	100	3.3
125	250	184	210	19.0	3	16.0	32	15.0	8	19	M16	100	4.0
150	285	211	240	19.0	3	16.0	32	15.0	8	23	M20	100	5.1
200	340	266	295	20.0	3	17.0	34	16.0	12	23	M20	100	7.1
250	400	319	355	22.0	3	19.0	48	17.5	12	28	M24	120	11.0
300	455	370	410	24.5	4	20.5	52	19.5	12	28	M24	120	14.0
350	520	429	470	26.5	4	22.5	68	21.0	16	28	M24	120	17.4
400	580	480	525	28.0	4	24.0	72	22.5	16	31	M27	140	22.2
450	640	548	585	30.0	4	26.0	78	24.0	20	31	M27	140	28.0
500	715	609	650	31.5	4	27.5	82	25.0	20	34	M30	160	38.0
600	840	720	770	36.0	5	31.0	93	27.5	20	37	M33	180	48.0
700	910	794	840	39.5	5	34.5	103	27.5	24	37	M33	180	58.0
750	970	857	900	41.0	5	36.0	108	28.0	24	37	M33	180	68.0
800	1025	901	950	43.0	5	38.0	114	30.0	24	40	M36	200	77.0
900	1125	1001	1050	46.0	5	41.0	124	32.5	28	40	M36	200	92.0
1000	1255	1112	1170	50.0	5	45.0	135	35.0	28	43	M39	220	128
1100	1355	1218	1270	53.5	5	48.5	144	37.5	32	43	M39	220	148
1200	1485	1328	1390	57.0	5	52.0	156	40.0	32	49	M45	240	193

NOTE :-

1. The method of screwing and the exact form of thread shall be left to the discretion of manufacturer as the flange are never removed after screwing on the barrels of the pipe.
2. If so required the screwed flanges may be spot welded on the back side after screwing.
3. Dimensions 'A' and 'S' are for guidance only
4. Unless otherwise specified, flanges shall be of ductile iron.

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Standard Flange Drilling for Screwed / Welded Flange (PN 25)



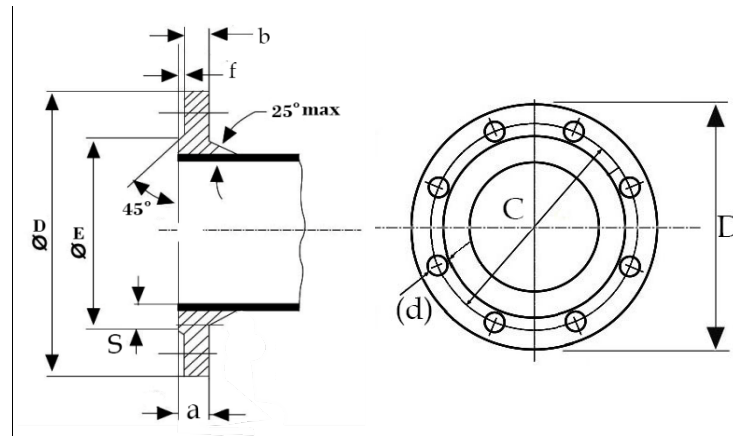
Nominal Diameter	PN – 25								Holes		Bolt		App Mass / Flange
	Dimensions										Size	Length	
DN	D	E	C	b	f	g	a	S	Number	Dia (d)	Metric	mm	
80	200	132	160	19.0	3	16.0	32	15.0	8	19	M16	100	4.6
100	235	156	190	19.0	3	16.0	33	15.0	8	23	M20	100	6.1
125	270	184	220	19.0	3	16.0	37	15.0	8	28	M24	100	7.8
150	300	211	250	20.0	3	17.0	40	16.0	8	28	M24	100	9.7
200	360	274	310	22.0	3	19.0	44	17.5	12	28	M24	110	14.1
250	425	330	370	24.5	3	21.5	49	19.5	12	31	M27	130	20.7
300	485	389	430	27.5	4	23.5	56	22.0	16	31	M27	130	28.6
350	555	448	490	30.0	4	26.0	57	24.0	16	34	M30	140	39.8
400	620	503	550	32.0	4	28.0	64	25.5	16	37	M33	150	51.3
450	670	548	600	34.5	4	30.5	69	27.5	20	37	M33	150	60.8
500	730	609	660	36.5	4	32.5	73	29.0	20	37	M33	160	73.8
600	845	720	770	42.0	5	37.0	83	33.5	20	40	M36	180	106.3
700	960	820	875	46.5	5	41.5	84	33.5	24	43	M39	200	112.6
750	1020	883	940	50.0	5	45.0	100	34.0	24	43	M39	200	170.8
800	1085	928	990	51.0	5	46.0	102	35.5	24	49	M45	220	195.9
900	1185	1028	1090	55.5	5	50.5	112	39.0	28	49	M45	220	235.8
1000	1320	1140	1210	60.0	5	55.0	118	42.0	28	56	M52	240	318.5
1100	1420	1240	1310	65.5	5	60.5	120	45.0	32	56	M52	260	---
1200	1530	1350	1420	69.0	5	64.0	138	48.5	32	56	M52	260	---

NOTE :-

1. The method of screwing and the exact form of thread shall be left to the discretion of manufacturer as the flange are never removed after screwing on the barrels of the pipe.
2. If so required the screwed flanges may be spot welded on the back side after screwing.
3. Dimensions 'A' and 'S' are for guidance only
4. Unless otherwise specified, flanges shall be of ductile iron.

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Standard Flange Drilling for Screwed / Welded Flange (PN 40)



Nominal Diameter	PN – 40							Holes		Bolt	App
	Dimensions							Number	Dia (d)	Size	Mass / Flange
DN	D	E	C	b	f	a	S			Metric	
80	200	132	160	16.0	3	19.0	15.0	8	19	M16	4.6
100	235	166	190	16.0	3	19.0	15.0	8	23	M20	6.1
125	270	184	220	20.5	3	23.5	16.5	8	28	M24	9.6
150	300	211	250	23.0	3	26.0	18.0	8	28	M24	12.5
200	375	284	320	27.0	3	30.0	21.0	12	31	M27	21.6
250	450	345	385	31.5	3	34.5	24.0	12	34	M30	34.5
300	515	409	450	35.5	4	39.5	27.5	16	34	M30	49.5
350	580	465	510	40.0	4	44.0	31.0	16	37	M33	67.3
400	660	535	585	44.0	4	48.0	33.5	16	40	M36	94.6
450	685	560	610	46.0	4	50.0	35.0	20	40	M36	95.4
500	755	615	670	48.0	4	52.0	36.5	20	43	M39	119.0
600	890	735	795	53.0	5	58.0	40.5	20	49	M45	179.2

NOTE :-

1. The method of screwing and the exact form of thread shall be left to the discretion of manufacturer as the flange are never removed after screwing on the barrels of the pipe.
2. If so required the screwed flanges may be spot welded on the back side after screwing.
3. Dimensions 'A' and 'S' are for guidance only
4. Unless otherwise specified, flanges shall be of ductile iron.

IS 8329:2000 # ISO 2531:2009 # BS EN 545 # BS EN 598