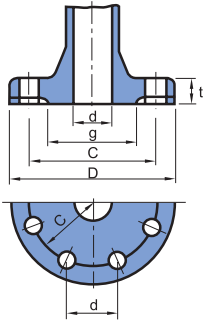


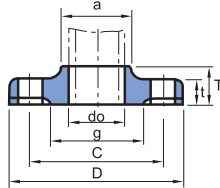
# JIS B2220 FLANGE STANDARD

## TOLERANCE FOR PIPE FLANGES

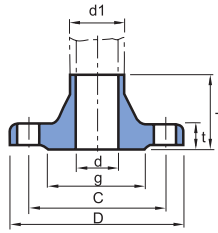
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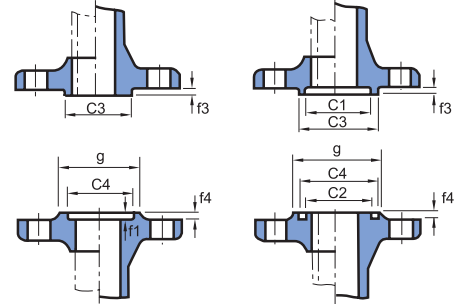
SLIP - ON



WELDING NECK



TYPE OF GASKET SURFACE



Unit : mm

Flange Section	Surface Condition	Basic Size	Dimensional Tolerance	
outside dia. d	as forged(1)	300&below	+not specified	
		over 300 thru 600	-2.0	
		over 600 thru 1000	+not specified	
		over 1000 thru 1500	-3.0	
		over 1500	+not specified	
	finish	300&below	±1	
		over 300 thru 600	±1.5	
		over 600 thru 1000	±2	
		over 1000 thru 1500	±2.5	
		over 1500	±3	
inside dia	solid flange d(2)	16&below	±1	
		over 16 thru 63	±1.5	
		over 63 thru 125	±2	
		over 125 thru 150	±2.5	
		over 250 thru 500	±3	
		over 500 thru 1000	±4	
	slip-on flange do	as forged(1)	100&below	+0.5, 0
			over 100 thru 400	+1, 0
			over 400 thru 600	+1.5, 0
			over 600 thru 800	+2.0, 0
			over 800 thru 1000	+2.5, 0
		finish	over 1000	+3, 0
			100&below	0, -0.5
			over 100 thru 400	0, -1
			over 400 thru 600	0, -1.5
welding neck flange d	finish	over 600 thru 800	0, -2	
		over 800 thru 1000	0, -2.5	
		over 1000	0, -3	
		250&below	±0.5	
		over 250 thru 550	±0.6	
over 550 thru 950	±0.8			
over 950 thru 1350	±1			
over 1350	±1.5			

Flange Section	Surface Condition	Basic Size	Dimensional Tolerance	
Dia. of hub	Slip-on flange (a) and welding neck flange(d 1)	-	±0.5	
		220&below	+2, 0	
		over 220 thru 450	+3, 0	
		over 450 thru 650	+4, 0	
		over 650 thru 850	+6, 0	
		over 850 thru 1000	+7, 0	
		over 1000	+8, 0	
		220&below	+1, 0	
		over 220 thru 450	+1.5, 0	
		over 450 thru 650	+2, 0	
	over 650 thru 850	+2.5, 0		
	over 850 thru 1000	+3, 0		
	over 1000	+3.5, 0		
	Gasket seat	c1,c2,c3, c4	500&below	±0.3
			over 500 thru 1000	±0.35
over1000 thru 1500			±0.4	
f4f3		8&below	±0.2	
		over 8	±0.25	
Thickness t	g	200&below	±0.8	
		over 200 thru 650	±0.9	
		over 650 thru 1000	±1	
		over 1000	±1.2	
		20&below	+1.5, 0	
	One-side finish	over 20 thru 50	+2, 0	
		over50 thru 100	+3, 0	
		Bolt-side finish	20&below	+1, 0
			over 20 thru 50	+1.5, 0
			over 50 thru 100	+2, 0
Hub Height T	Flange with Pipe Inserted	50&below	±1	
		over 50 thru 100	±1.5	
		over 100 thru 200	±2	
	Flange with Bolt-welded Pipe	over 200&below	+2, 0	
		over 200 thru 300	+3, 0	