

## 法兰的尺寸公差 DIMENSIONAL TOLERANCE OF FLANGE

项目 Item	法兰型式 Flange type	尺寸范围 Size range	尺寸公差 Size tolerance
法兰厚度C Flange height	双面加工的所有型式法兰 (包括镗孔) All types of flanges machined on both sides (including countersunk)	C ≤ 18	±1.0
		18 < C ≤ 50	±1.5
		C > 50	±2.0
法兰厚度H Flange height	带颈法兰对焊环 Neck flange butt weld ring	≤ DN80	±1.5
		DN100-DN250	±2.0
		≥ DN300	±3.0
法兰颈部大端直径N Flange neck big end diameter N	带颈对焊法兰 整体法兰 Neck butt welding flange Integral flange	≤ DN50	0 -2
		DN65-DN150	0 -4
		DN200-DN300	0 -6
		DN350-DN600	0 -8
	带颈平焊法兰 承插焊法兰 螺纹法兰 Flat Weld Neck Flange Socket Weld Flange Threaded Flange	≤ DN50	+1.0 0
		DN65~DN150	+2.0 0
		DN200~DN300	+4.0 0
		DN350~DN600	+8.0 0
对焊法兰或对焊环焊端外径A或A1 Butt Weld Flange or Butt Weld Ring Weld End Outer Diameter A or A1	带颈对焊法兰对焊环 Butt Weld Neck Flange Butt Weld Ring	≤ DN125	+3.0 0
		DN150-DN1200	+4.5 0
		≥ DN1300	+6.0 0
法兰内径和承插孔 内径B1\B2 Flange inner diameter and socket inner diameter B1\B2	所有型式 All types	≤ DN100	+0.5 0
		DN125-DN400	+1.0 0
		DN450-DN600	+1.5 0
法兰外径D Flange outside diameter	整体法兰 Integral Flange	≥ DN700	+3.0 0
		≤ DN250	±4.0
		DN300-DN500	±5.0
		DN600-DN800	±6.0
		DN900-DN1200	±7.0
	所有型式 All Types	DN1400-DN1600	±8.0
		> DN1600	±10.0
		≤ DN150	±2.0
		DN200-DN500	±3.0
		DN600-DN1200	±5.0
DN1400-DN1800	±7.0		
> DN1800	±10.0		

项目 Item	法兰型式 Flange type	尺寸范围 Size range	尺寸公差 Size tolerance
法兰突台外径d (环连接面除外) Flange raise face outside diameter (except connection surface)	所有型式 All types	≤DN250	+2.0 -1.0
		> DN250	+3.0 -1.0
法兰突台高度F1 (环连接面除外) Flange raise face height F1(except connection surface)	所有型式 All types	2	0 -1.0
环连接面法兰突台高度F Flange raise face height F	所有型式 All types	-	±1.0
凹面、凸面和锥面、槽面高度F2\F3 FM female face, M male face, T tongue face, G groove face height F2\F3	所有型式 All types	-	+0.5 0
凹面、凸面和榫面、槽面直径 FM female face, M male face, T tongue face, G groove face diameter	所有型式 All types	X、Z	0 -0.5
		W、Y	+0.5 0
螺栓孔中心圆直径K Bolt hole center circle diameter K	所有型式 All types	≤M24	±1.0
		> M24	±1.5
相邻两螺栓孔间距 Spacing between two bolt holes	所有型式 All types	≤M24	±1.0
		> M24	±1.5
螺栓孔直径L Bolt hole diameter L	所有型式 All types	-	±0.5
螺栓孔中心圆与加工密封面的同轴度偏差 Concentricity deviation between bolt hole center circle and machined sealing surface	所有型式 All types	≤DN100	1.0
		≥DN125	2.0
密封与螺栓承面的平行度 Parallelism of sealing surface and bolt bearing surface	所有型式 All types	-	1°
颈度厚度S Neck thickness S	带颈对焊法兰 整体法兰 Neck butt welding flange Integral flange	≤DN80	+1.0 0
		DN100~DN400	+1.5 0
		DN450~DN600	+2.0 0
		DN700~DN1000	+3.0 0
		≥DN1200	+4.0 0
对焊环焊端以及翻边壁厚 Butt Weld Ring End and Flange Wall Thickness	对焊环 Butt Weld Ring	-	+1.6 -12.5%钢管名义厚度 Nominal thickness of steel pipe

## 环连接面的尺寸公差

### DIMENSIONAL TOLERANCE OF RING CONNECTING SURFACE

项目 Item	尺寸公差 Size tolerance	
环槽深度E Ring groove depth E	+0.4 0	
环槽顶宽度F Ring groove top width F	±20.	
环槽中心圆直径P Ring groove center circle diameter P	±0.13	
环槽角度23° Ring groove angle 23°	±0.5°	
环槽圆角Rmax Ring groove fillet Rmax	Rmax ≤ 2	+0.8 0
	Rmax > 2	±0.8
密封面外径D Outer diameter of sealing surface D	±0.5	