Exhaust Flanges -- Industrial Engines — SAE J624a

SAE RECOMMENDED PRACTICE

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SOCIETY OF AUTOMOTIVE ENGINEERS, INC.
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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.

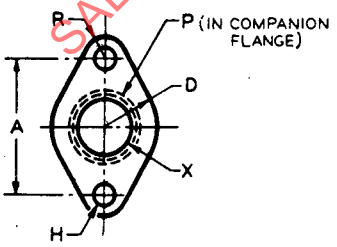

FIG. 1 - TWO HOLE FLANGE

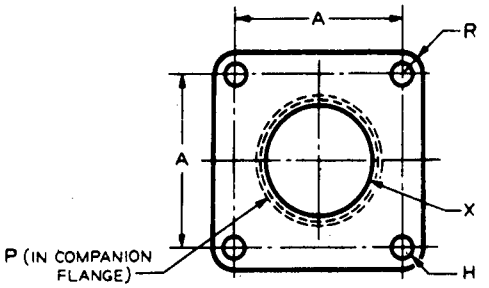

FIG. 2 - FOUR HOLE FLANGE