

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 1944 *withdrawing 1979*

PIPE COUPLINGS FOR HYDRAULIC PIPING (PIPE THREADS)

1st EDITION

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BRIEF HISTORY

The ISO Recommendation R 1944, *Pipe couplings for hydraulic piping (Pipe threads)*, was drawn up by Technical Committee ISO/TC 39, *Machine tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question led to the adoption of Draft ISO Recommendation No. 1944, which was circulated to all the ISO Member Bodies for enquiry in September 1969. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Australia	Japan	Sweden
Belgium	Korea, Rep. of	Switzerland
Chile	New Zealand	Thailand
Czechoslovakia	Portugal	Turkey
France	Romania	U.A.R.
Germany	South Africa, Rep. of	United Kingdom
Greece	Spain	

The following Member Bodies opposed the approval of the Draft :

Hungary
U.S.A.
U.S.S.R.

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided to accept it as an ISO RECOMMENDATION.

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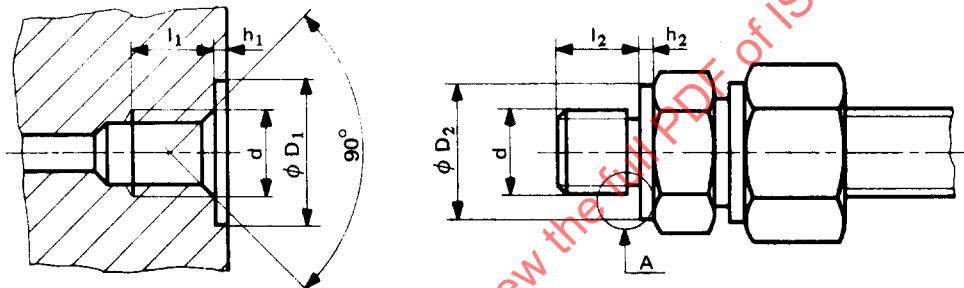
1. SCOPE

This ISO Recommendation gives the dimensions of pipe couplings for hydraulic piping on machines and equipment, in relation to the nominal dimensions of the threads retained for these applications.

2. THREADS

The threads should conform to ISO Recommendation R 228, *Pipe threads where pressure-tight joints are not made on the threads (1/8 inch to 6 inches)*, tolerance class A.

3. DIMENSIONS



The joint surface should be perpendicular to the axis of the thread.

For detail A of the joint surface for use with flat seal, see ISO Recommendation R 1941, *Flat seal for hydraulic couplings*. For use with an O-ring connection, a further ISO Recommendation is being prepared.

Dimensions in millimetres

Nominal dimension of thread	Internal thread			External thread		
	l_1 min.	D_1 min.	h_1 max.	l_2 max.	D_2 h14	h_2 min.
$\frac{1}{8}$	7.4	15	1	7.4	14	1
$\frac{1}{4}$	11.0	19	1.5	11.0	18	1.5
$\frac{3}{8}$	11.4	23	2	11.4	22	2
$\frac{1}{2}$	15.0	27	2.5	15.0	26	2.5
$\frac{3}{4}$	16.3	33	2.5	16.3	32	2.5
1	19.1	40	2.5	19.1	39	2.5
$1 \frac{1}{4}$	21.4	50	2.5	21.4	49	2.5
$1 \frac{1}{2}$	21.4	56	2.5	21.4	55	2.5
2	25.7	69	3	25.7	68	3

NOTE. — The widths across flats should be taken from those in ISO Recommendation R 272* , *Hexagon bolts and nuts — Widths across flats, heights of heads, thicknesses of nuts — Metric series*.

* 2nd Edition, 1968.