



ASME BPE 管件 ASME BPE fittings

国家高新技术企业 浙江省著名商标
www.cndonjoy.com

 DONJOY 东正

O.1	自控调节阀+控制器 Automatic control regulating valve + Control head
O.2	生物制药隔膜阀 Biopharmaceutical diaphragm valve
O.3	高洁净泵 High purity pumps
O.4	防混蝶阀+蝶阀 Mixing proof butterfly valve + Butterfly valve
O.5	球阀 Ball valve
O.6	截止换向阀+防混阀+罐底阀 Divert seat valve + Mixing proof valve + Tank bottom valve
O.7	角座阀+截止阀 Angle seat valve + Globe valve
O.8	止回阀+恒压阀+安全阀+减压阀 Check valve + constant pressure valve + safety valve + air release valve
O.9	清洁技术+取样阀+视镜+照明技术 Clean technology + sample valve + sight glass + lighting technology
O.10	过滤器+人孔 Filter + man hole cover (manway)
O.11	卫生管件 Sanitary fittings ASME BPE DIN11852 BS4825 SMS ISO IDF 3A



注意：
目录技术资料仅供设计参考。
设计更新和技术升级恕不另行通知！

东正始终坚持以不断革新的技术、日新月异的市场发展和客户需求是当今我们面临的最大挑战。面对这些挑战我们信心十足，因为东正高度专业化的產品和技术创新，是我们未来将以更高、更优的产品来满足不断增长的市场需求。

Technological innovation, rapid development of the market and customer needs are the greatest challenges facing us today. Facing with these challenges we are confident, because of highly professional products and technological innovation, we will meet the growing demand of market and customer with our better and better products.

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东正众多技术设计，都具有专利保护，如有抄袭，东正必将追究法律责任和经济赔偿。

领先源于创新 创新源于专业 东正的专业与品质的邂逅源于创新的精神



现代化工厂已经投产，期待您的光临！
温州空港经济园区生产基地
Wenzhou airport economic zone production base

占地面积29000m²，总投资1.2亿元，新引进工业机器人、5轴加工中心、机器人抛光设备。

Covering an area of 29000 m², with total investment after construction is expected to 120 million yuan, introduces new industrial robot, five axis machining center, machine Polishing equipment.

东正创立于1993年，注册资金5508万，是一家专注于研发高品质PID过程控制器、阀门定位器、流量控制器，阀门控制单元，高洁净过程控制阀、智能自控阀，高洁净泵、高洁净管材和管道配件。公司高度专业化的产品和技术专注于生物制药、食品饮料、酿酒、精细化工等工业领域。东正众多的创新解决方案，对满足全球，尤其是新兴市场不断增长生物制药和食品饮料行业的需求起到了积极作用。

东正制造的产品母材料、加工技术、焊接技术、表面处理等技术指标均已达到国内外先进水平。且符合ASME BPE、EHEDG、FDA、3A等一系列国际标准和规范要求，先后通过了由德国TÜV机构实施的欧盟承压设备指令(PED-97/23/EC)和(MD-06/42/EC)认证、美国3A机构实施的3-A卫生标准认证、中国安全阀特种制造设备(TS)许可证和中国质量认证中心CQC ISO9001:2008质量管理体系认证等多项国际权威认证。

东正凭借先进的技术、优异的品质和完善的售后服务体系，先后被评定为国家高新技术企业，省著名商标、省科技型企业、创新型企业、专利示范企业、研发中心企业，守合同重信用AAA企业等众多荣誉。



关于东正

About DONJOY

Donjoy was built up in 1993, with registered capital RMB 55,08 millions. We focus on developing high quality PID process controller, the valve positioner, the flow controller, the valve control unit, high purity process control valve, intelligent self-control valve, high purity pump, high purity tubing fitting and pipeline accessories. Donjoy's products and technologies are widely used in biopharmaceutical, food, drink, wine fine chemicals and other industrial fields. Donjoy's innovation solutions meet the growing demand of the industry of biopharmaceutical, food and beverage from the whole world, especially the emerging market.

Raw material, processing technology, welding technology, surface treatment from Donjoy have achieved advanced levels of domestic and foreign market. Donjoy productions according to ASME BPE, EHEDG, FDA and 3A standard, get certificate of PED-97/23/EC and MD-06/42/EC issued by TUV, 3A issued by 3A organization, TS licence and ISO9001:2008.

Donjoy with advanced technology, excellent quality and perfect after-sales service system, has been assessed as the national high-tech enterprises, the Provincial Famous Trademark, the Provincial Science and Technology Enterprises, Innovative Enterprises, Patent Model Enterprises, R & D Center, AAA Credit Enterprises.



创立于2005年现代化工厂
温州滨海经济开发区生产基地
Wenzhou binhai economic development zone production base

DONJOY high-purity valve, pump, control system, pipe and accessories, provide the most excellent solution for various business scopes.



Biopharmaceutical



Dairy



Food



Beverage



Water Processing



Brewing



Fine Chemical

制造与检验

Manufacturing and testing



机器人生产线 Robot production line

全自动弯管设备 Automatic pipe bending equipment

DONJOY以科学技术是第一生产力，
也是企业核心竞争力，只有不断投入核心技术研发和创新，
不断追求卓越，精益求精、以先进生产设备，
严格的质量管理体系，精密的生产检测流程，
保证每一款产品优良的性能。

Science and technology constitute a primary productive force, also the core competitive strength of the enterprise. Continuously intensifying the research, development and innovation of core technology, pursuing prominence and keeping improving, ensuring the excellent quality and performance of every single product by advanced production equipment, strict quality control and precise production and inspection procedures.

至精 至洁 历久弥新

20多年的经验是您值得信赖的品牌-DONJOY

东正管件系列产品已全部通过美国-3A-63-03认证；橡胶垫圈FDA 177.2600，PTFE垫圈FDA177.1550。

材质：304、316L、1.4301、1.4404、1.4435 NB2 Fe<0.5%

表面处理：机抛光 DIN 11866 HE3c HE4c HE5c, ASME BPE SFF1 SFF2 SFF3

电抛光 DIN 11866 HE3c HE4c HE5c, ASME BPE SFF4 SFF5 SFF6



异形管件系列
(定制品)

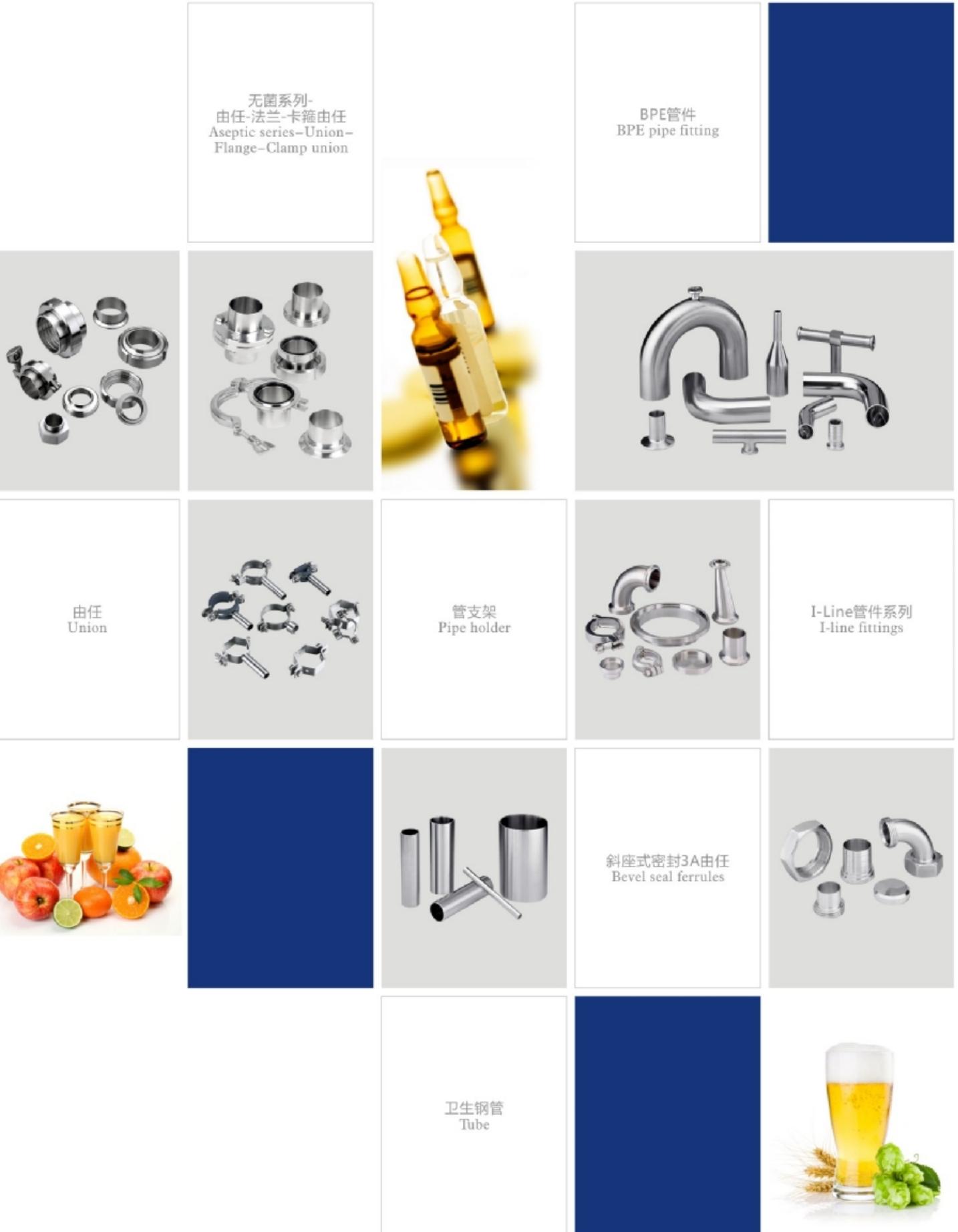


卡箍式管件
Clamp pipe fittings



管件系列
DIN SMS ISO
BS4825 3A





材质和连接标准

Material and connectivity standards

材质有多种选项

- ◆ 1.4435-BN2 (316L) Fe < 0.5% Forged
- ◆ ASME BPE 316L
- ◆ ASTM 304, 1.4301
- ◆ ASTM 316L 1.4404

不锈钢化学成分规范
Chemical composition for automatic weld ends, %

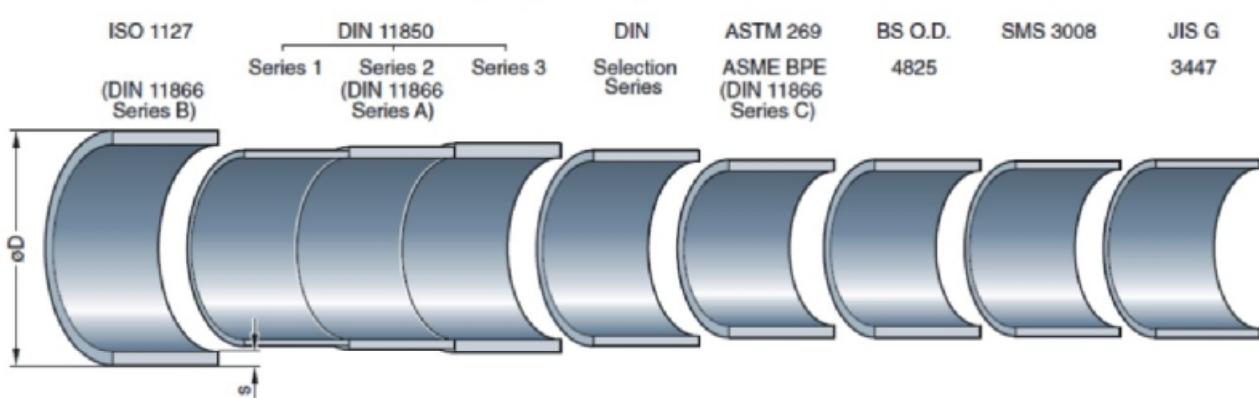
根据ASDME BPE Table DT-3		EN 10088-3 1.4435 NB2 Fe≤0.5%	
Carbon, max	0.035	Carbon, max	< 0.03
chromium	16.00–18.00	chromium	16.00–18.00
manganese, max	2.00	manganese, max	2.00
molybdenum	2.00–3.00	molybdenum	2.5–3.0
nickel	10.00–15.00	nickel	12.5–14.0
phosphorus, max	0.045	phosphorus, max	0.045
silicon, max	1.00	silicon, max	1.00
sulfur	0.005–0.017	sulfur	≤0.030
		nitrogen	< 0.11

管道接口标准 Pipeline end standard

下表格：以DN25为例的不同国际标准卫生级不锈钢管道直径的区别

Next form: Take DN25 for example to illustrate the stainless steel pipe OD difference in different International standard health grade

Tube End Standards:
The following chart of international standards of pipe diameters identifies the different diameters comparing the example of a nominal diameter of DN 25.



表面处理

Surface treatment

表面处理

Surface treatment

对高洁净的工艺管路系统来说，表面的粗糙度是极其重要的技术指标
For high clean process piping system, the roughness of the surface is an extremely important technique index



Surface finish: machined,
Ra 1.2 μ m



Surface finish: machined,
Ra 0.8 μ m



Surface finish: fine-machined,
and grinded, Ra 0.4 μ m



Surface finish: fine-machined,
and grinded, Ra 0.2 μ m



表面抛光 Surface polishing

Ra=粗糙度

平均粗糙度Ra值被作为衡量一个内表面光洁度的一个参数。

LT5.6mm 长度/测量Lc0.8mm进行5次测量粗糙度得出的平均值粗糙度Ra值。

根据ASME BPE和DIN 11866。

Ra = roughness

Average roughness Ra data is used as a measure of valve body surface finish of a parameter.

LT5.6 mm length/measurement Lc0.8 mm for five measuring roughness obtained average roughness Ra data.

According ASME BPE table to classified

Definition of the codes for Ra-Values

Allocation to the standard DIN 11866

Ra μ m	DIN 11866	α
	Hygiene class	E-polished
0.8		
0.8	HE3c	●
0.6		
0.6		●
0.4		
0.4	HE4c	●
0.25		
0.25	HE5c	●

Table SF-2.4-1 R_a Readings for Metallic Product Contact Surfaces

Surface Designation	Mechanically Polished [Note (1)]	
	R _a Max. μ in.	μ m
SF0	No finish requirement	No finish requirement
SF1	20	0.51
SF2	25	0.64
SF3	30	0.76

	Mechanically Polished [Note (1)] and electropolished	
	R _a Max. μ in.	μ m
SF4	15	0.38
SF5	20	0.51
SF6	25	0.64



BPE管件 Pipe Fitting

BPE系列管件是生物制药工程高洁净要求的最佳选择的管道配件，高质量的管道和管件，首先可缩短安装的准备工作，其次可避免在实际焊接操作中出现偏弧现象，易于自动焊机焊接，无需多次调整参数，节约焊接时间，最终缩短工期和满足FDA及GMP等要求。

ASME BPE standard is the best choice for hygienic requirement of pharmaceutical engineering. It has been recognized in over 30 countries, high-quality pipes and fitting will shorten the preparatory work of installing, and avoid arc phenomena in the welding operation, easy for automatic welding, no need to adjust several parameters, save welding time and ultimately shorten the construction period and comply with FDA & GMP.

Table DT-6 Final Tolerances for Electropolished Fittings and Process Components
BPE 管件壁厚公差范围

Nominal Size,in.	Wall Thickness	
	in.	mm
1/4	+0.003/-0.006	+0.08/-0.15
3/8	+0.003/-0.006	+0.08/-0.15
1/2	+0.005/-0.010	+0.13/-0.25
3/4	+0.005/-0.010	+0.13/-0.25
1	+0.005/-0.010	+0.13/-0.25
1 1/2	+0.005/-0.010	+0.13/-0.25
2	+0.005/-0.010	+0.13/-0.25
2 1/2	+0.005/-0.010	+0.13/-0.25
3	+0.005/-0.010	+0.13/-0.25
4	+0.008/-0.012	+0.20/-0.30
6	+0.015/-0.017	+0.38/-0.43

抛光等级 Polishing grade

Table SF-2.4-1 R_a Readings for Metallic Product Contact Surfaces

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Surface designation	Mechanically Polished [Note (1)] and Electropolished	
	μ in.	μ m
SF4	15	0.38
SF5	20	0.51
SF6	25	0.64



机械抛光等级
Mechanical polishing grade

默认Default SF1; R_a 20=0.51 μ m

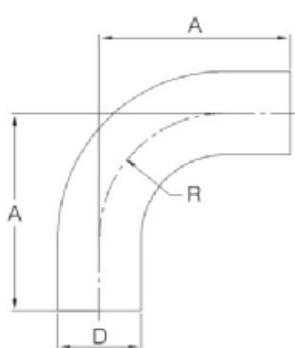


电解抛光等级
Electrolytic polishing grade

默认 SF4; R_a 15=0.38 μ m

长型-90° 对焊弯头-(选型系列) Long 90° weld elbow (selection series)

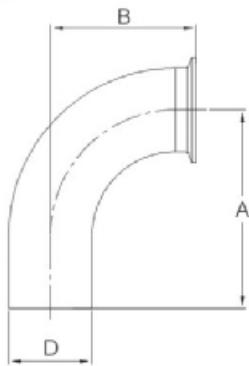
适用于Apply to: ASME BPE DT-4.1.1-1 Automatic Tube Weld: 90-deg Elbow



SIZE	尺寸 Dimension			壁厚 Thickness ASME BPE
	A	R	D	
1/2"	76.2	28.6	12.7	1.65
3/4"	76.2	28.6	19.1	1.65
1"	76.2	38.1	25.4	1.65
1-1/2"	95.3	57.2	38.1	1.65
2"	120.7	76.2	50.8	1.65
2-1/2"	139.7	95.3	63.5	1.65
3"	158.8	114.3	76.2	1.65
4"	203.2	152.4	101.6	2.10
6"	292.1	228.6	152.4	2.80

一头卡箍 – 一头对焊-90° 弯头 Clamped/welded 90° elbow

适用于Apply to: ASME BPE DT-4.1.1-2 Automatic Tube Weld: Hygienic Clamp Joint, 90-deg Elbow

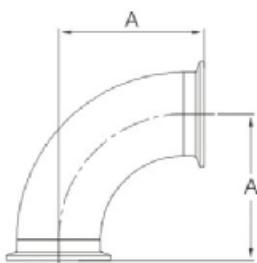


SIZE	尺寸 Dimension			
	A	B	D	卡盘 Clamp OD
1/2"	76.2	41.3	12.7	25.0
3/4"	76.2	41.3	19.1	25.0
1"	76.2	50.8	25.4	50.5
1 1/2"	95.3	69.9	38.1	50.5
2"	120.7	88.9	50.8	64.0
2 1/2"	139.7	108.0	63.5	77.5
3"	158.8	127.0	76.2	91.0
4"	203.2	168.3	101.6	119.0
6"	292.1	266.7	152.4	167.0

注意: 90° 弯头直端长度计算方法: A-B=直端长度(举例: 1"A (76.2)- B(38.1)=38.1
Notice: 90° elbow straight end length calculation way: a-b= straight end length

90° 卡箍弯头 90 ° clamp elbow

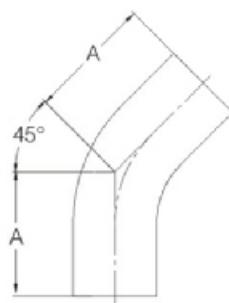
适用于Apply to: ASME BPE DT-4.1.1-3 Hygienic Clamp Joint: 90-deg Elbow



SIZE	尺寸 Dimension	
	A	卡盘 Clamp OD
1/2"	41.3	25.0
3/4"	41.3	25.0
1"	50.8	50.5
1 1/2"	69.9	50.5
2"	88.9	64.0
2 1/2"	108.0	77.5
3"	127.0	91.0
4"	168.3	119.0
6"	266.7	167.0

长型-45° 对焊弯头 Long type 45 ° weld elbow

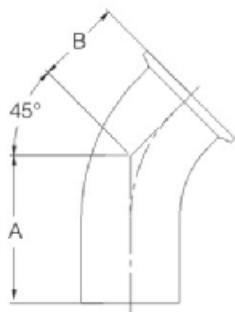
适用于Apply to: ASME BPE DT-4.1.1-4 Automatic Tube Weld: 45-deg Elbow



SIZE	尺寸 Dimension			壁厚 Thickness ASME BPE
	A	D	R	
1/2"	57.2	12.7	28.6	1.65
3/4"	57.2	19.1	28.6	1.65
1"	57.2	25.4	38.1	1.65
1 1/2"	63.5	38.1	57.2	1.65
2"	76.2	50.8	76.2	1.65
2 1/2"	85.7	63.5	95.3	1.65
3"	92.1	76.2	114.3	1.65
4"	114.3	101.6	152.4	2.10
6"	158.8	152.4	228.6	2.80

一头卡箍-一头对焊-45° 弯头 Clamped/welded 45° elbow

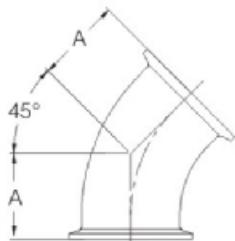
适用于Apply to: ASME BPE DT-4.1.1-5 Automatic Tube Weld: Hygienic Clamp Joint, 45-deg Elbow



SIZE	尺寸 Dimension			
	A	B	卡盘 Clamp OD	D
1/2"	57.2	25.4	25.0	12.7
3/4"	57.2	25.4	25.0	19.1
1"	57.2	28.6	50.5	25.4
1 1/2"	63.5	36.5	50.5	38.1
2"	76.2	44.5	64.0	50.8
2 1/2"	85.7	52.4	77.5	63.5
3"	92.1	60.3	91.0	76.2
4"	114.3	79.4	119.0	101.6
6"	158.8	133.4	167.0	152.4

45° 卡箍弯头 45 ° clamp elbow

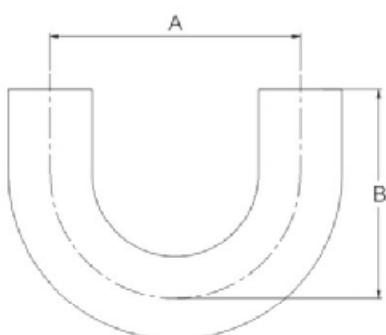
适用于Apply to: ASME BPE DT-4.1.1-6 Hygienic Clamp Joint: 45-deg Elbow



SIZE	尺寸 Dimension	
	A	卡盘 Clamp OD
1/2"	25.4	25.0
3/4"	25.4	25.0
1"	28.6	50.5
1 1/2"	36.5	50.5
2"	44.5	64.0
2 1/2"	52.4	77.5
3"	60.3	91.0
4"	79.4	119.0
6"	133.4	167.0

长型-180° 对焊弯头 Long type 180 ° clamp elbow

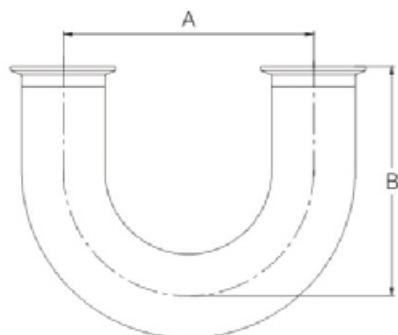
适用于Apply to: ASME BPE DT-4.1.1-7 Automatic Tube Weld: 180-deg Return Bend



SIZE	尺寸 Dimension			壁厚 Thickness ASME BPE
	A	B	D	
1/2"	114.3	76.2	12.7	1.65
3/4"	114.3	76.2	19.1	1.65
1"	76.2	76.2	25.4	1.65
1 1/2"	114.3	114.3	38.1	1.65
2"	152.4	127.0	50.8	1.65
2 1/2"	190.5	146.1	63.5	1.65
3"	228.6	165.1	76.2	1.65
4"	304.8	215.9	101.6	2.10
6"	457.2	292.1	152.4	2.80

180° 卡箍弯头 180° clamp elbow

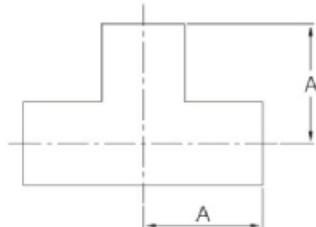
适用于Apply to: ASME BPE DT-4.1.1-8 Hygienic Clamp Joint: 180-deg Return Bend



SIZE	尺寸 Dimension			壁厚 Thickness ASME BPE
	A	B	卡盘	
1/2"	114.3	88.9	25.0	1.65
3/4"	114.3	88.9	25.0	1.65
1"	76.2	88.9	50.5	1.65
1 1/2"	114.3	127.0	50.5	1.65
2"	152.4	139.7	64.0	1.65
2 1/2"	190.5	158.8	77.5	1.65
3"	228.6	177.8	91.0	1.65
4"	304.8	231.8	119.0	2.10
6"	457.2	330.2	167.0	2.80

长型(中头等长)-对焊三通 Long type (middle length same with two sides) weld tee

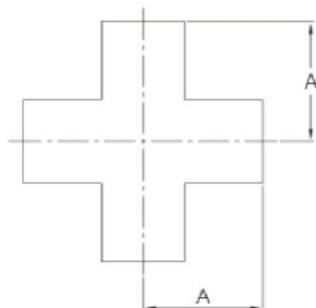
适用于Apply to: ASME BPE DT-4.1.2-1 Automatic Tube Weld: Straight Tee and Cross



SIZE	尺寸 Dimension		壁厚 Thickness BPE
	A	D	
0.5	47.6	12.7	1.65
0.75	50.8	19.1	1.65
1	54.0	25.4	1.65
1.5	60.3	38.1	1.65
2	73.0	50.8	1.65
2.5	79.4	63.5	1.65
3	85.7	76.2	1.65
4	104.8	101.6	2.1
6	142.9	152.4	2.8

长型(中头等长)-对焊四通 Long type (middle length same with two sides) weld cross

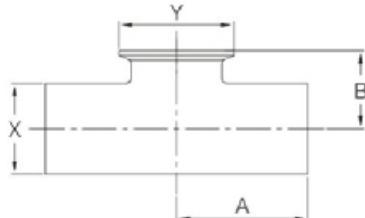
适用于Apply to: ASME BPE DT-4.1.2-1 Automatic Tube Weld: Straight Tee and Cross



SIZE	尺寸 Dimension		壁厚 Thickness BPE
	A	D	
0.5	47.6	12.7	1.65
0.75	50.8	19.1	1.65
1	54.0	25.4	1.65
1.5	60.3	38.1	1.65
2	73.0	50.8	1.65
2.5	79.4	63.5	1.65
3	85.7	76.2	1.65
4	104.8	101.6	2.1
6	142.9	152.4	2.8

两头对焊-中间卡箍(中头短)-三通 Tee main welded/clamped short 3rd port

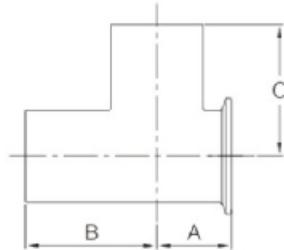
适用于Apply to: ASME BPE DT-4.1.2-2 Automatic Tube Weld: Short Outlet Hygienic Clamp Joint Tee



SIZE	尺寸 Dimension			
	A	B	X	Y
1/2"	47.6	25.4	12.7	25.0
3/4"	50.8	28.6	19.1	25.0
1"	54.0	28.6	25.4	50.5
1 1/2"	60.3	34.9	38.1	50.5
2"	73.0	41.3	50.8	64.0
2 1/2"	79.4	47.6	63.5	77.5
3"	85.7	54.0	76.2	91.0
4"	104.8	69.9	101.6	119.0
6"	142.9	117.5	152.4	167.0

中头对焊-单头直通对焊-单头直通短卡箍 Middle welded-welded-short clamp

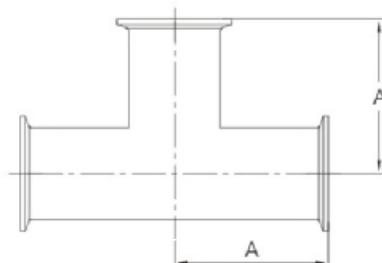
适用于Apply to: ASME BPE DT-4.1.2-3 Hygienic Mechanical Joint: Short Outlet Run Tee



SIZE	尺寸 Dimension			
	A	B	C	卡盘 Clamp OD
1/2"	22.2	47.6	47.6	25.0
3/4"	25.4	50.8	50.8	25.0
1"	28.6	54.0	54.0	50.5
1 1/2"	34.9	60.3	60.3	50.5
2"	41.3	73.0	73.0	64.0
2 1/2"	47.6	79.4	79.4	77.5
3"	54.0	85.7	85.7	91.0
4"	69.9	104.8	104.8	119.0
6"	117.5	142.9	142.9	167.0

卡箍三通 Clamp tee

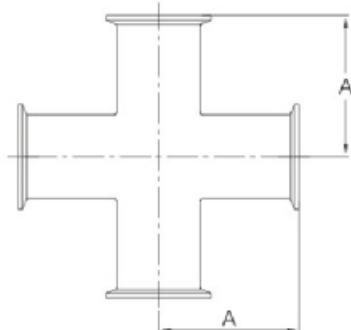
适用于Apply to: ASME BPE DT-4.1.2-4 Hygienic Clamp Joint: Straight Tee and Cross



SIZE	尺寸 Dimension	
	A	卡盘 Clamp OD
1/2"	57.2	25.0
3/4"	60.3	25.0
1"	66.7	50.5
1 1/2"	73.0	50.5
2"	85.7	64.0
2 1/2"	92.1	77.5
3"	98.4	91.0
4"	120.7	119.0
6"	181.0	167.0

卡箍四通 Clamp cross

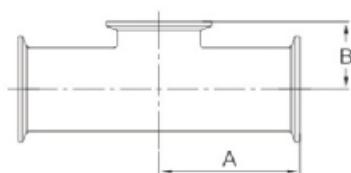
适用于Apply to: ASME BPE DT-4.1.2-4 Hygienic Clamp Joint: Straight Tee and Cross



SIZE	尺寸 Dimension	
	A	卡盘 Clamp OD
1/2"	57.2	25.0
3/4"	60.3	25.0
1"	66.7	50.5
1 1/2"	73.0	50.5
2"	85.7	64.0
2 1/2"	92.1	77.5
3"	98.4	91.0
4"	120.7	119.0
6"	181.0	167.0

卡箍三通 Clamp tee(middle end short)

适用于Apply to: ASME BPE DT-4.1.2-5 Hygienic Clamp Joint: Short Outlet Tee

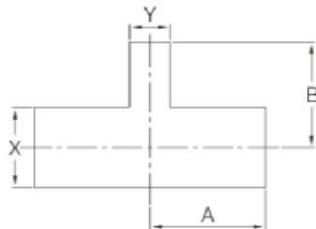


SIZE	尺寸 Dimension		
	A	B	卡盘 Clamp OD
1/2"	57.2	25.4	25.0
3/4"	60.3	28.6	25.0
1"	66.7	28.6	50.5
1 1/2"	73.0	34.9	50.5
2"	85.7	41.3	64.0
2 1/2"	92.1	47.6	77.5
3"	98.4	54.0	91.0
4"	120.7	69.9	119.0
6"	181.0	117.5	167.0



对焊异径三通(中头长) Weld reducing tee

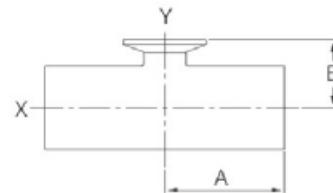
适用于Apply to: ASME BPE DT-4.1.2-6
Automatic Tube Weld: Reducing Tee



SIZE		尺寸 Dimension	
直通	异径通	A	B
1	0.50	54.0	54.0
1	0.75	54.0	54.0
1.5	0.50	60.3	60.3
1.5	0.75	60.3	60.3
1.5	1.0	60.3	60.3
2	0.50	73.0	66.7
2	0.75	73.0	66.7
2	1.0	73.0	66.7
2	1.5	73.0	66.7
2.5	0.50	79.4	73.0
2.5	0.75	79.4	73.0
2.5	1.0	79.4	73.0
2.5	1.5	79.4	73.0
2.5	2.0	79.4	73.0
3	0.50	85.7	79.4
3	0.75	85.7	79.4
3	1.0	85.7	79.4
3	1.5	85.7	79.4
3	2.0	85.7	79.4
3	2.5	85.7	79.4
4	0.50	104.8	92.1
4	0.75	104.8	92.1
4	1.0	104.8	92.1
4	1.5	104.8	92.1
4	2.0	104.8	98.4
4	2.5	104.8	98.4
4	3.0	104.8	98.4
6	3.0	142.9	123.8
6	4.0	142.9	130.2

两头对焊-中间卡箍(中头短)-三通 Tee main welded/clamped short 3rd port

适用于Apply to: ASME BPE(DT-4.1.2-7)
Automatic tube weld: short outlet hygienic clamp, joint reducing tee

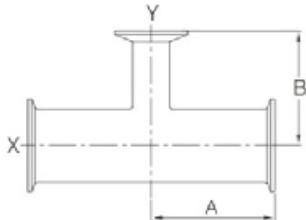


SIZE		尺寸 Dimension	
直通	异径通	A	B
1	0.50	54.0	28.6
1	0.75	54.0	28.6
1.5	0.50	60.3	34.9
1.5	0.75	60.3	34.9
1.5	1.0	60.3	34.9
2	0.50	73.0	41.3
2	0.75	73.0	41.3
2	1.0	73.0	41.3
2	1.5	73.0	41.3
2.5	0.50	79.4	47.6
2.5	0.75	79.4	47.6
2.5	1.0	79.4	47.6
2.5	1.5	79.4	47.6
2.5	2.0	79.4	47.6
3	0.50	85.7	54.0
3	0.75	85.7	54.0
3	1.0	85.7	54.0
3	1.5	85.7	54.0
3	2.0	85.7	54.0
3	2.5	85.7	54.0
4	0.50	104.8	66.7
4	0.75	104.8	66.7
4	1.0	104.8	66.7
4	1.5	104.8	66.7
4	2.0	104.8	66.7
4	2.5	104.8	66.7
4	3.0	104.8	66.7
6	0.50	142.9	92.1
6	0.75	142.9	92.1
6	1.0	142.9	92.1
6	1.5	142.9	92.1
6	2.0	142.9	92.1
6	2.5	142.9	92.1
6	3.0	142.9	92.1
6	4.0	142.9	95.3

卡箍异径(中头长)三通
Clamp reducing tee(middle end long)

适用于Apply to: ASME BPE(DT-4.1.2-8)

Hygienic Clamp Joint: Reducing Tee

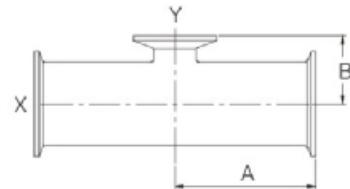


SIZE		尺寸 Dimension	
直通	异径通	A	B
1	0.50	66.7	66.7
1	0.75	66.7	66.7
1.5	0.50	73.0	73.0
1.5	0.75	73.0	73.0
1.5	1.0	73.0	73.0
2	0.50	85.7	79.4
2	0.75	85.7	79.4
2	1.0	85.7	79.4
2	1.5	85.7	79.4
2.5	0.50	92.1	85.7
2.5	0.75	92.1	85.7
2.5	1.0	92.1	85.7
2.5	1.5	92.1	85.7
2.5	2.0	92.1	85.7
3	0.50	98.4	92.1
3	0.75	98.4	92.1
3	1.0	98.4	92.1
3	1.5	98.4	92.1
3	2.0	98.4	92.1
3	2.5	98.4	92.1
4	0.50	120.7	104.8
4	0.75	120.7	104.8
4	1.0	120.7	104.8
4	1.5	120.7	104.8
4	2.0	120.7	111.1
4	2.5	120.7	111.1
4	3.0	120.7	111.1
6	3.0	181.0	136.5
6	4.0	181.0	146.1

卡箍异径(中头短)三通
Clamp reducing tee(middle end short)

适用于Apply to: ASME BPE(DT-4.1.2-9)

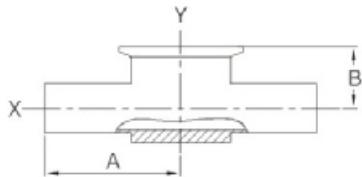
Hygienic Clamp Joint: Short Outlet Reducing Tee



SIZE		尺寸 Dimension	
直通	异径通	A	B
1	0.50	66.7	28.6
1	0.75	66.7	28.6
1.5	0.50	73.0	34.9
1.5	0.75	73.0	34.9
1.5	1.0	73.0	34.9
2	0.50	85.7	41.3
2	0.75	85.7	41.3
2	1.0	85.7	41.3
2	1.5	85.7	41.3
2.5	0.50	92.1	47.6
2.5	0.75	92.1	47.6
2.5	1.0	92.1	47.6
2.5	1.5	92.1	47.6
2.5	2.0	92.1	47.6
3	0.50	98.4	54.0
3	0.75	98.4	54.0
3	1.0	98.4	54.0
3	1.5	98.4	54.0
3	2.0	98.4	54.0
3	2.5	98.4	54.0
4	0.50	120.7	66.7
4	0.75	120.7	66.7
4	1.0	120.7	66.7
4	1.5	120.7	66.7
4	2.0	120.7	66.7
4	2.5	120.7	66.7
4	3.0	120.7	66.7
6	0.50	181.0	92.1
6	0.75	181.0	92.1
6	1.0	181.0	92.1
6	1.5	181.0	92.1
6	2.0	181.0	92.1
6	2.5	181.0	92.1
6	3.0	181.0	92.1
6	4.0	181.0	95.3

焊接仪器三通 Weld instrument tee

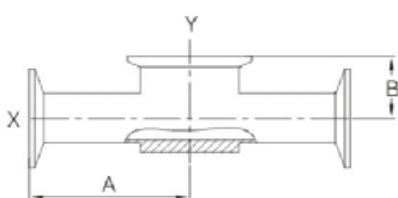
适用于Apply to: ASME BPE (DT-4.1.2-10) Automatic Tube Weld: Instrument Tee



SIZE		尺寸 Dimension		
直通	中通	A	B	卡盘 Clamp OD
0.5	1.5	63.5	22.2	50.5
0.75	1.5	63.5	25.4	50.5
1.0	1.5	63.5	28.6	50.5
0.5	2.0	69.9	25.4	64.0
0.75	2.0	69.9	28.6	64.0
1.0	2.0	69.9	31.8	64.0
1.5	2.0	69.9	38.1	64.0

卡箍仪器三通 Clamp instrument tee

适用于Apply to: ASME BPE (DT-4.1.2-11) Hygienic Clamp Joint: Instrument Tee

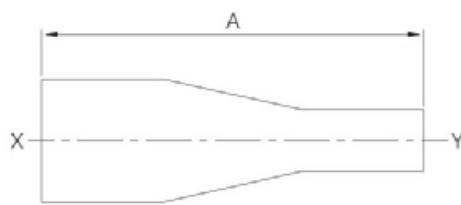


SIZE		尺寸 Dimension		中头 卡盘 Clamp OD
直通	中通	A	B	
0.5	1.5	76.2	22.2	50.5
0.75	1.5	76.2	25.4	50.5
1.0	1.5	76.2	28.6	50.5
0.5	2.0	82.6	25.4	64.0
0.75	2.0	82.6	28.6	64.0
1.0	2.0	82.6	31.8	64.0
1.5	2.0	82.6	38.1	64.0



对焊-同心大小头-A型 Welded concentric reducer A type

适用于Apply to: ASME BEP DT-4.1.3-1(a) Automatic Tube Weld: Concentric and Eccentric Reducer



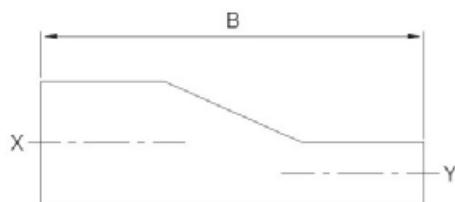
SIZE		尺寸 Dimension			卡盘 Clamp OD
大头	小头	A	X	Y	
0.75	0.5	101.6	19.1	12.7	1.65
1.0	0.5	114.3	25.4	12.7	
	0.75	101.6	25.4	19.1	
1.50	0.75	127.0	38.1	19.1	
	1.0	127.0	38.1	25.4	
2.0	1.0	184.2	50.8	25.4	
	1.50	133.4	50.8	38.1	
2.5	1.50	184.2	63.5	38.1	
	2.00	139.7	63.5	50.8	
3.0	1.50	235.0	76.2	38.1	
	2.00	190.5	76.2	50.8	2.1/1.65
4.0	2.50	139.7	76.2	63.5	
	2.00	298.5	101.6	50.8	
6.0	2.50	247.7	101.6	63.5	
	3.0	196.9	101.6	76.2	2.8-1.65
6.0	3.0	254.0	152.4	76.2	
	4.0	254.0	152.4	101.6	2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

对焊-偏心大小头-A型 Welded eccentric reducer A type

适用于Apply to: ASME BEP DT-4.1.3-1(a) Automatic Tube Weld: Concentric and Eccentric Reducer



SIZE		尺寸 Dimension			卡盘 Clamp OD
大头	小头	B	X	Y	
0.75	0.5	101.6	19.1	12.7	1.65
1.0	0.5	114.3	25.4	12.7	
	0.75	101.6	25.4	19.1	
1.50	0.75	127.0	38.1	19.1	
	1.0	127.0	38.1	25.4	
2.0	1.0	184.2	50.8	25.4	
	1.50	133.4	50.8	38.1	
2.5	1.50	184.2	63.5	38.1	
	2.00	139.7	63.5	50.8	
3.0	1.50	235.0	76.2	38.1	2.1/1.65
	2.00	190.5	76.2	50.8	
4.0	2.50	139.7	76.2	63.5	
	2.00	298.5	101.6	50.8	
6.0	2.50	247.7	101.6	63.5	2.8-1.65
	3.0	196.9	101.6	76.2	
6.0	3.0	247.7	152.4	76.2	2.8-2.1
	4.0	254.0	152.4	101.6	

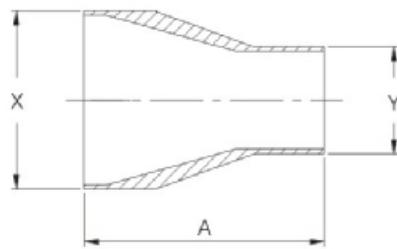
注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping



对焊-同心大小头-B型 Welded concentric reducer B type

适用于Apply to: ASME BEP DT-4.1.3-1(b) Automatic Tube Weld: Concentric and Eccentric Reducer



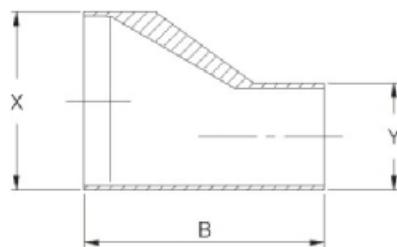
SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	A	X	Y	
0.75	0.5	54.0	19.1	12.7	1.65
1.0	0.5	64.0	25.4	12.7	
	0.75	54.0	25.4	19.1	
1.50	0.75	76.2	38.1	19.1	
	1.0	63.5	38.1	25.4	
2.0	1.0	85.7	50.8	25.4	
	1.50	63.5	50.8	38.1	
2.5	1.50	85.7	63.5	38.1	
	2.00	63.5	63.5	50.8	
3.0	1.50	108.0	76.2	38.1	
	2.00	85.7	76.2	50.8	
4.0	2.50	66.7	76.2	63.5	
	2.00	130.2	101.6	50.8	
6.0	2.50	108.0	101.6	63.5	2.1/1.65
	3.0	98.5	101.6	76.2	
6.0	3.0	184.2	152.4	76.2	2.8-1.65
	4.0	143.0	152.4	101.6	2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

对焊-偏心大小头-B型 Welded eccentric reducer B type

适用于Apply to: ASME BEP DT-4.1.3-1(b) Automatic Tube Weld: Concentric and Eccentric Reducer



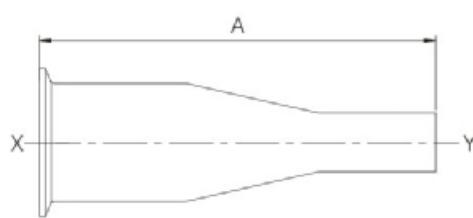
SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	B	X	Y	
0.75	0.5	54.0	19.1	12.7	1.65
1.0	0.5	64.0	25.4	12.7	
	0.75	54.0	25.4	19.1	
1.50	0.75	76.2	38.1	19.1	
	1.0	63.5	38.1	25.4	
2.0	1.0	85.7	50.8	25.4	
	1.50	63.5	50.8	38.1	
2.5	1.50	85.7	63.5	38.1	
	2.00	63.5	63.5	50.8	
3.0	1.50	108.0	76.2	38.1	
	2.00	85.7	76.2	50.8	
4.0	2.50	66.7	76.2	63.5	
	2.00	103.2	101.6	50.8	
6.0	2.50	108.0	101.6	63.5	2.1/1.65
	3.0	98.5	101.6	76.2	
6.0	3.0	184.2	152.4	76.2	2.8-1.65
	4.0	143.0	152.4	101.6	2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

大头卡箍-小头对焊-同心大小头-A型 Clamped/welded concentric reducer A type

适用于Apply to: ASME BEPDT-4.1.3-2(a) Hygienic Clamp Joint: Tube Weld Concentric and Eccentric Reducer



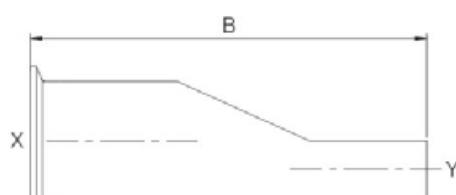
SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	A	X	Y	
0.75	0.5	76.2	19.1	12.7	1.65
1.0	0.5	88.9	25.4	12.7	
	0.75	76.2	25.4	19.1	
1.50	0.75	101.6	38.1	19.1	
	1.0	101.6	38.1	25.4	
2.0	1.0	152.4	50.8	25.4	
	1.50	101.6	50.8	38.1	
2.5	1.50	152.4	63.5	38.1	
	2.00	107.9	63.5	50.8	
3.0	1.50	203.2	76.2	38.1	
	2.00	158.8	76.2	50.8	
4.0	2.50	108.0	76.2	63.5	
	2.00	263.5	101.6	50.8	
6.0	2.50	212.7	101.6	63.5	2.1/1.65
	3.0	161.9	101.6	76.2	
6.0	3.0	228.6	152.4	76.2	2.8-1.65
	4.0	228.6	152.4	101.6	2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

大头卡箍-小头对焊-偏心大小头-A型 Clamped/welded eccentric reducer A type

适用于Apply to: ASME BEPDT-4.1.3-2(a) Hygienic Clamp Joint: Tube Weld Concentric and Eccentric Reducer



SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	B	X	Y	
0.75	0.5	76.2	19.1	12.7	1.65
1.0	0.5	88.9	25.4	12.7	
	0.75	76.2	25.4	19.1	
1.50	0.75	101.6	38.1	19.1	
	1.0	101.6	38.1	25.4	
2.0	1.0	152.4	50.8	25.4	
	1.50	101.6	50.8	38.1	
2.5	1.50	152.4	63.5	38.1	
	2.00	107.9	63.5	50.8	
3.0	1.50	203.2	76.2	38.1	
	2.00	158.8	76.2	50.8	
4.0	2.50	108.0	76.2	63.5	
	2.00	263.5	101.6	50.8	
6.0	2.50	212.7	101.6	63.5	2.1/1.65
	3.0	161.9	101.6	76.2	
6.0	3.0	222.3	152.4	76.2	2.8-1.65
	4.0	228.6	152.4	101.6	2.8-2.1

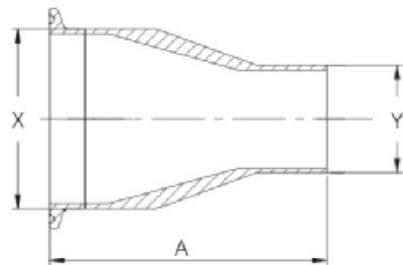
注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping



大头卡箍-小头对焊-同心大小头-B型 Clamped/welded concentric reducer B type

适用于Apply to: ASME BEP DT-4.1.3-2(b) Hygienic Clamp Joint: Tube Weld Concentric and Eccentric Reducer



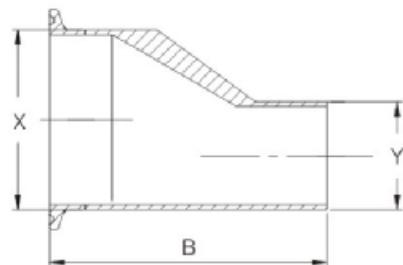
SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	A	X	Y	
0.75	0.5	66.7	19.1	12.7	1.65
1.0	0.5	76.2	25.4	12.7	
	0.75	66.7	25.4	19.1	
1.50	0.75	88.9	38.1	19.1	
	1.0	76.2	38.1	25.4	
2.0	1.0	98.4	50.8	25.4	
	1.50	76.2	50.8	38.1	
2.5	1.50	98.4	63.5	38.1	
	2.00	76.2	63.5	50.8	
3.0	1.50	120.7	76.2	38.1	
	2.00	98.4	76.2	50.8	
4.0	2.50	79.4	76.2	63.5	2.1/1.65
	3.0	114.3	101.6	76.2	
6.0	3.0	203.2	152.4	76.2	2.8-1.65
	4.0	161.9	152.4	101.6	
					2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

大头卡箍-小头对焊-偏心大小头-B型 Clamped/welded eccentric reducer B type

适用于Apply to: ASME BEP DT-4.1.3-2(b) Hygienic Clamp Joint: Tube Weld Concentric and Eccentric Reducer



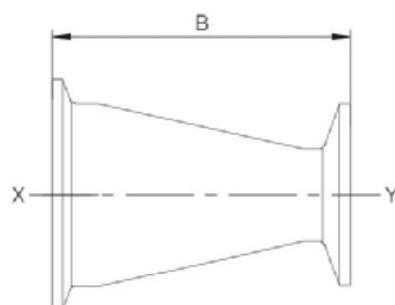
SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	A	X	Y	
0.75	0.5	66.7	19.1	12.7	1.65
1.0	0.5	76.2	25.4	12.7	
	0.75	66.7	25.4	19.1	
1.50	0.75	88.9	38.1	19.1	
	1.0	76.2	38.1	25.4	
2.0	1.0	98.4	50.8	25.4	
	1.50	76.2	50.8	38.1	
2.5	1.50	98.4	63.5	38.1	
	2.00	76.2	63.5	50.8	
3.0	1.50	120.7	76.2	38.1	
	2.00	98.4	76.2	50.8	
4.0	2.50	79.4	76.2	63.5	2.1/1.65
	3.0	114.3	101.6	76.2	
6.0	3.0	203.2	152.4	76.2	2.8-1.65
	4.0	161.9	152.4	101.6	
					2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

卡箍-同心大小头-A型 Clamped concentric reducer A type

适用于Apply to: ASME BEP (DT-4-1.3-3(A) Hygienic Clamp Joint: Concentric and Eccentric Reducer



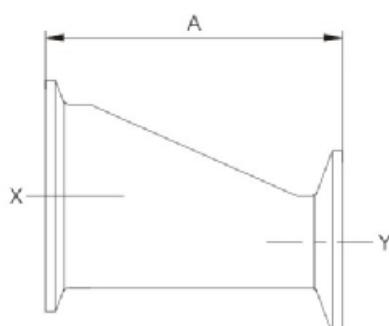
SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	B	X	Y	
0.75	0.5	50.8	25.0	25.0	1.65
1.0	0.5	63.5	50.5	25.0	
	0.75	50.8	50.5	25.0	
1.50	0.75	76.2	50.5	25.0	1.65
	1.0	76.2	50.5	50.5	
2.0	1.0	127.0	64.0	50.5	
	1.50	76.2	64.0	50.5	
2.5	1.50	127.0	77.5	50.5	
	2.00	76.2	77.5	64.0	
3.0	1.50	177.8	91.0	50.5	2.1/1.65
	2.00	127.0	91.0	64.0	
	2.50	76.2	91.0	77.5	
4.0	2.00	231.8	119.0	64.0	
	2.50	181.0	119.0	77.5	
	3.0	130.2	119.0	91.0	
6.0	3.0	190.5	167.0	91.0	2.8-1.65
	4.0	193.7	167.0	119.0	2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

卡箍-偏心大小头-A型 Clamped eccentric reducer A type

适用于Apply to: ASME BEP (DT-4-1.3-3(A) Hygienic Clamp Joint: Concentric and Eccentric Reducer



SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	B	X	Y	
0.75	0.5	50.8	25.0	25.0	1.65
1.0	0.5	63.5	50.5	25.0	
	0.75	50.8	50.5	25.0	
1.50	0.75	76.2	50.5	25.0	1.65
	1.0	76.2	50.5	50.5	
2.0	1.0	127.0	64.0	50.5	
	1.50	76.2	64.0	50.5	
2.5	1.50	127.0	77.5	50.5	
	2.00	76.2	77.5	64.0	
3.0	1.50	177.8	91.0	50.5	2.1/1.65
	2.00	127.0	91.0	64.0	
	2.50	76.2	91.0	77.5	
4.0	2.00	231.8	119.0	64.0	
	2.50	181.0	119.0	77.5	
	3.0	130.2	119.0	91.0	
6.0	3.0	190.5	167.0	91.0	2.8-1.65
	4.0	193.7	167.0	119.0	2.8-2.1

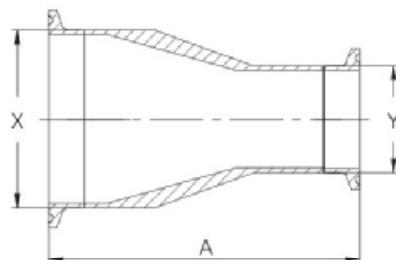
注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping



卡箍-同心大小头-B型 Clamped concentric reducer B type

适用于Apply to: ASME BEP DT-4.1.3-3(b) Hygienic Clamp Joint: Concentric and Eccentric Reducer



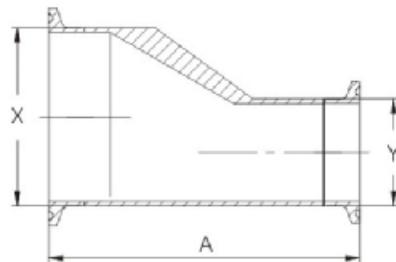
SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	A	X	Y	
0.75	0.5	79.4	25.0	25.0	1.65
1.0	0.5	88.9	50.5	25.0	
	0.75	79.4	50.5	25.0	
1.50	0.75	101.6	50.5	25.0	
	1.0	88.9	50.5	50.5	
2.0	1.0	111.1	64.0	50.5	
	1.50	88.9	64.0	50.5	
2.5	1.50	111.1	77.5	50.5	
	2.00	88.9	77.5	64.0	
3.0	1.50	133.4	91.0	50.5	
	2.00	111.1	91.0	64.0	
4.0	2.50	92.1	91.0	77.5	
	3.0	127.0	119.0	91.0	
6.0	3.0	215.9	167.0	91.0	2.8-1.65
	4.0	177.8	167.0	119.0	2.8-2.1

注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping

卡箍-偏心大小头-B型 Clamped eccentric reducer B type

适用于Apply to: ASME BEP DT-4.1.3-3(b) Hygienic Clamp Joint: Concentric and Eccentric Reducer



SIZE		尺寸 Dimension			壁厚 Thickness
大头	小头	A	X	Y	
0.75	0.5	79.4	25.0	25.0	1.65
1.0	0.5	88.9	50.5	25.0	
	0.75	79.4	50.5	25.0	
1.50	0.75	101.6	50.5	25.0	
	1.0	88.9	50.5	50.5	
2.0	1.0	111.1	64.0	50.5	
	1.50	88.9	64.0	50.5	
2.5	1.50	111.1	77.5	50.5	
	2.00	88.9	77.5	64.0	
3.0	1.50	133.4	91.0	50.5	
	2.00	111.1	91.0	64.0	
4.0	2.50	92.1	91.0	77.5	
	3.0	127.0	119.0	91.0	
6.0	3.0	215.9	167.0	91.0	2.8-1.65
	4.0	177.8	167.0	119.0	2.8-2.1

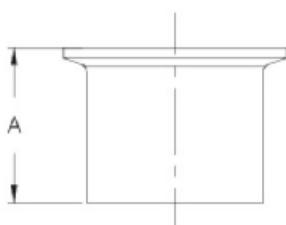
注意: ASME BPE大头系列产品有两种设计, A型=挤压成型方式; B型=机加工成型方式;

Notice: ASME BPE bigger side series have two designs, A type=extrusion forming; B type= machine-shaping



卡箍接头(长型) Clamp ferrule(long type)

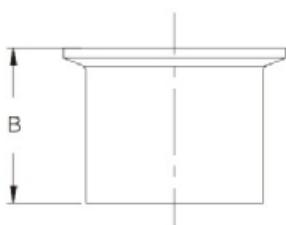
适用于Apply to: ASME BPE DT-4.1.4-1 Automatic Tube Weld: Ferrule



SIZE	卡盘 Clamp OD		
	A	D	卡盘 Clamp OD
1/4"	44.5	6.35	25.0
3/8"	44.5	9.53	25.0
1/2"	44.5	12.7	25.0
3/4"	44.5	19.1	25.0
1"	44.5	25.4	34.0
1 1/2"	44.5	38.1	50.5
2"	57.2	50.8	64.0
2 1/2"	57.2	63.5	77.5
3"	57.2	76.2	91.0
4"	57.2	101.6	119.0
6"	76.2	152.4	167.0

卡箍接头(中长型) Clamp ferrule(medium length type type)

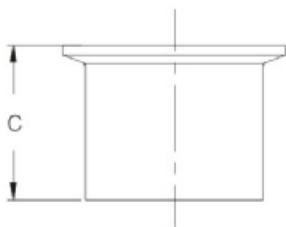
适用于Apply to: ASME BPE DT-4.1.4-1 Automatic Tube Weld: Ferrule



SIZE	尺寸 Dimension		
	B	D	卡盘 Clamp OD
1/4"	28.7	6.35	25.0
3/8"	28.7	9.53	25.0
1/2"	28.7	12.7	25.0
3/4"	28.7	19.1	25.0
1"	28.7	25.4	34.0
1 1/2"	28.7	38.1	50.5
2"	28.7	50.8	64.0
2 1/2"	28.7	63.5	77.5
3"	28.7	76.2	91.0
4"	28.7	101.6	119.0
6"	38.1	152.4	167.0

卡箍接头(短型) Clamp ferrule(short type)

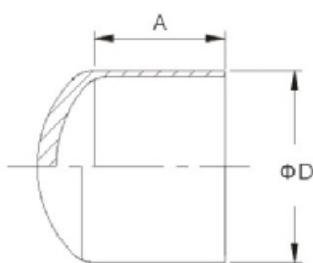
适用于Apply to: ASME BPE DT-4.1.4-1 Automatic Tube Weld: Ferrule



SIZE	尺寸 Dimension		
	C	D	卡盘 Clamp OD
1/4"	12.7	6.35	25.0
3/8"	12.7	9.53	25.0
1/2"	12.7	12.7	25.0
3/4"	12.7	19.1	25.0
1"	12.7	25.4	34.0
1 1/2"	12.7	38.1	50.5
2"	12.7	50.8	64.0
2 1/2"	12.7	63.5	77.5
3"	12.7	76.2	91.0
4"	15.9	101.6	119.0
6"	19.1	152.4	167.0

卡箍封头 Clamp cap

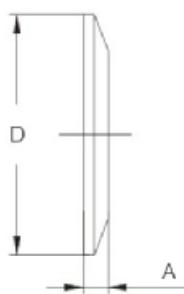
适用于Apply to: ASME BPE DT-4.1.5-1 Automatic Tube Weld: Cap



SIZE	尺寸 Dimension		卡盘 Clamp OD
	A	D	
1/2"	38.1	12.7	1.65
3/4"	38.1	19.1	1.65
1"	38.1	25.4	1.65
1 1/2"	38.1	38.1	1.65
2"	38.1	50.8	1.65
2 1/2"	38.1	63.5	1.65
3"	44.5	76.2	1.65
4"	50.8	101.6	2.10
6"	63.5	152.4	2.80

卡箍堵头 Clamp end cap

适用于Apply to: ASME BPE DT-4.1.5-2 Hygienic Clamp Joint: Solid End Cap



SIZE	尺寸 Dimension	
	A	卡盘 Clamp OD
1/2"	4.7	25.0
3/4"	4.7	25.0
1"	6.4	50.5
1 1/2"	6.4	50.5
2"	6.4	64.0
2 1/2"	6.4	77.5
3"	6.4	91.0
4"	7.9	119.0
6"	11.1	167.0



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