
**Vacuum technology — Mounting
dimensions of pipeline fittings —**

**Part 2:
Knife-edge flange type**

*Technique du vide — Dimensions de montage des raccords
de conduit —*

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 9803-2 was prepared by Technical Committee ISO/TC 112, *Vacuum technology*.

This first edition of ISO 9803-2, together with ISO 9803-1, cancels and replaces ISO 9803:1993, which has been technically revised.

ISO 9803 consists of the following parts, under the general title *Vacuum technology — Mounting dimensions of pipeline fittings*:

- ISO 9803-2:2007
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- Part 1: *Non knife-edge flange type*
 - Part 2: *Knife-edge flange type*

Introduction

ISO 9803:1993 defined only those pipeline fittings whose flanges are non-bakable, as defined in ISO 1609 and ISO 2861-1. This revision divides ISO 9803 into two parts:

- ISO 9803-1, in which fittings with non-bakable flanges are defined, and
- this part of ISO 9803, in which fittings with bakable flanges as specified in ISO 3669 are defined.

This part of ISO 9803 deals with dimensions of pipeline fittings whose flanges are of bakable type, as defined in ISO 3669.

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Vacuum technology — Mounting dimensions of pipeline fittings —

Part 2: Knife-edge flange type

1 Scope

This part of ISO 9803 specifies mounting dimensions for vacuum pipeline fittings (elbows, tees and crosses) of knife-edge flanges for nominal bores from 16 mm to 200 mm.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3669, *Vacuum technology — Bakable flanges — Dimensions*
[ISO 9803-2:2007](https://standards.iteh.ai/catalog/standards/sist/694e2075-a1ab-410b-88cc-d4f7e1b27ff8/iso-9803-2-2007)

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3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 3669 apply.

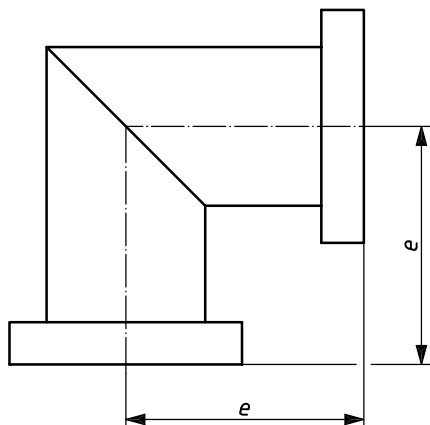
4 Requirements

4.1 Mounting dimensions of the vacuum pipeline fittings shall be as specified in Table 1. See Figures 1 to 3.

4.2 Flange dimensions shall be as specified in ISO 3669. One or more flange should be rotatable.

4.3 Bolt holes in the flanges specified in ISO 3669 shall be positioned as shown in Figure 4. Angle α is a function of the number of bolt holes.

Dimensions in millimetres



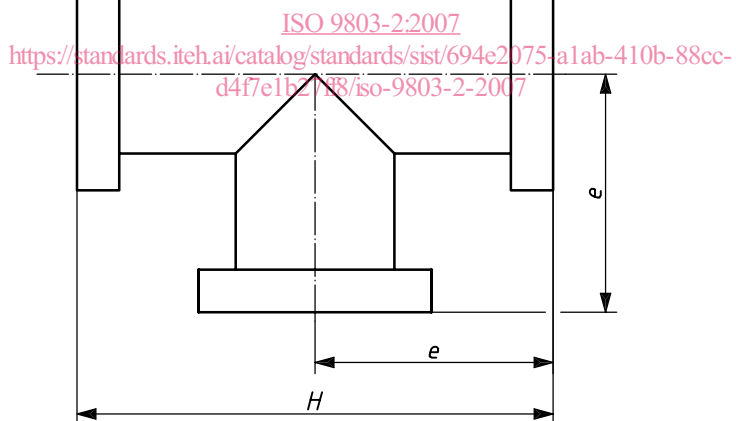
Key

e edge dimension

Figure 1 — Elbow

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Dimensions in millimetres



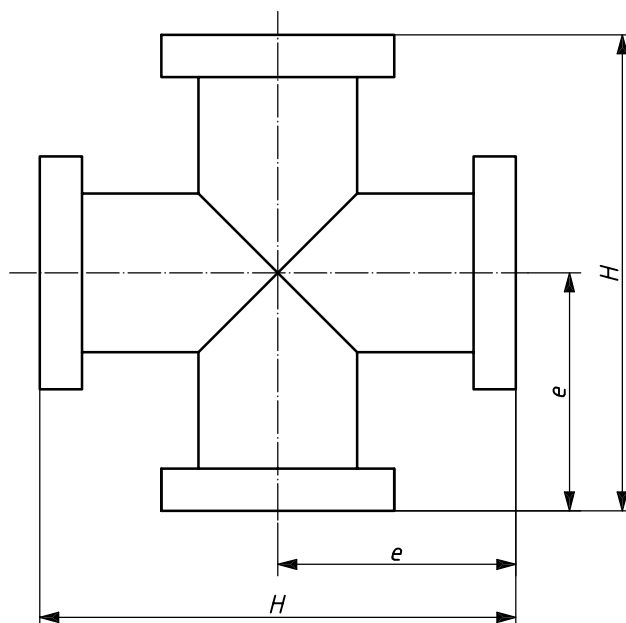
Key

e edge dimension

H length

Figure 2 — Tee

Dimensions in millimetres



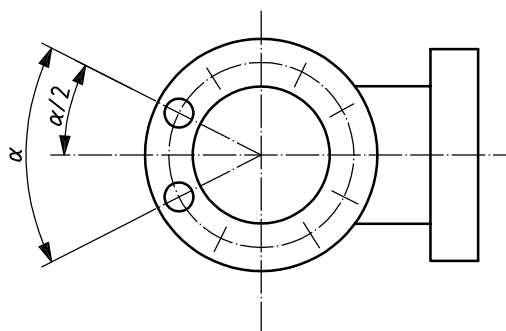
Key

- e edge dimension
- H length

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Figure 3 — Cross

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Key

$$\alpha = \frac{360^\circ}{\text{total number of bolt holes}}$$

Figure 4 — Position of bolt holes

Table 1 — Dimension of pipeline fittings

Dimensions in millimetres

Nominal bore	Edge dimension, e		Length, H		Perpendicularity or parallelism tolerance for the two mating faces
		tolerance		tolerance	
16	38	$\pm 1,5$	76	$\pm 1,5$	$\pm 1^\circ$
40	63		126		
63	105		210		
100	135		270		
160	167	± 2	334	± 2	$\pm 0^\circ 30'$
200	203		406		

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Bibliography

- [1] ISO 1609, *Vacuum technology — Flange dimensions*
- [2] ISO 2861-1, *Vacuum technology — Quick-release couplings — Dimensions — Part 1: Clamped type*
- [3] ISO 9803-1, *Vacuum technology — Mounting dimensions of pipeline fittings — Part 1: Non knife-edge flange type*

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