
**Diesel engines — Fuel injection
pumps and fuel injector low-pressure
connections —**

**Part 1:
Threaded connections**

iTeh STANDARD PREVIEW
*Moteurs diesels — Raccords basse pression pour pompes d'injection
de combustible et porte-injecteurs de combustible complets —
Partie 1: Raccords filetés*
(standards.iteh.ai)

[ISO 13948-1:2015](https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b0e/iso-13948-1-2015)

[https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-
e0c19dae2b0e/iso-13948-1-2015](https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b0e/iso-13948-1-2015)



iTeh STANDARD PREVIEW
(standards.iteh.ai)

ISO 13948-1:2015

<https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b0e/iso-13948-1-2015>



COPYRIGHT PROTECTED DOCUMENT

© ISO 2015, Published in Switzerland

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

Contents

	Page
Foreword.....	iv
Introduction.....	v
1 Scope.....	1
2 Normative references.....	1
3 Terms, definitions and symbols.....	1
3.1 Terms and definitions.....	1
3.2 Symbols.....	2
4 Connection designs and applications.....	2
4.1 General.....	2
4.2 Types of connection.....	2
4.2.1 Type A: banjo connection (see Figure 1).....	2
4.2.2 Type B: O-ring seal connection (see Figure 2).....	2
4.2.3 Type C: compression seal connection (see Figure 3).....	2
4.2.4 Type D: internal rubber ring seal “flexible” connection (see Figure 4).....	3
4.2.5 Type E: external rubber ring seal “flexible” connection (see Figure 5).....	3
5 Dimensions and tolerances.....	3
6 Designation.....	3
Bibliography.....	9

iTeh STANDARD PREVIEW
(standards.iteh.ai)

[ISO 13948-1:2015](#)

<https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b0e/iso-13948-1-2015>

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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](http://www.iso.org/foreword)

The committee responsible for this document is ISO/TC 22, *Road vehicles*, Subcommittee SC 34, *Propulsion, powertrain, and powertrain fluids*.

This second edition cancels and replaces the first edition (ISO 13948-1:2000), which has been technically revised. The following changes have been made: the tables and figures have been revised.

ISO 13948 consists of the following parts, under the general title *Diesel engines — Fuel injection pumps and fuel injector low-pressure connections*:

- *Part 1: Threaded connections*
- *Part 2: Non-threaded (push-on) connections*

Introduction

It is recognized that a large variety of low-pressure connections for fuel injection pumps and injectors exist, using different sealing principles as well as designs. ISO 13948 attempts to provide the user with a common set of preferred types.

ISO 13948 is divided into two parts, covering threaded connections (ISO 13948-1) and non-threaded (push-on) connections (ISO 13948-2) for use with low-pressure fuel supply and return, boost air pressure and lubricating oil supply and return.

iTeh STANDARD PREVIEW (standards.iteh.ai)

[ISO 13948-1:2015](https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b0e/iso-13948-1-2015)

<https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b0e/iso-13948-1-2015>

iTeh STANDARD PREVIEW
(standards.iteh.ai)

ISO 13948-1:2015

<https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b0e/iso-13948-1-2015>

Diesel engines — Fuel injection pumps and fuel injector low-pressure connections —

Part 1: Threaded connections

1 Scope

This part of ISO 13948 specifies dimensions and requirements for mechanical, threaded connections used on diesel fuel injection pumps and fuel injectors for the connection of low-pressure fuel, lubrication oil or air supply.

Five types of threaded connections (types A to E) are described in this part of ISO 13948. Type A is commonly used for both pumps and injectors, while types B to E are for diesel fuel injection pumps only.

NOTE Low-pressure connections to fuel filters are covered in other International Standards; see the Bibliography. High-pressure end-connections for pumps and injectors are covered in ISO 2974

2 Normative references

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

ISO 261, *ISO general purpose metric screw threads — General plan*

ISO 4288, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Rules and procedures for the assessment of surface texture*

ISO 6149-1, *Connections for hydraulic fluid power and general use — Ports and stud ends with ISO 261 metric threads and O-ring sealing — Part 1: Ports with truncated housing for O-ring seal*

ISO 7876-1, *Fuel injection equipment — Vocabulary — Part 1: Fuel injection pumps*

ISO 7876-2, *Fuel injection equipment — Vocabulary — Part 2: Fuel injectors*

ISO 7876-3, *Fuel injection equipment — Vocabulary — Part 3: Unit injectors*

ISO 7876-4, *Fuel injection equipment — Vocabulary — Part 4: High-pressure pipes and end-connections*

ISO 7876-5, *Fuel injection equipment — Vocabulary — Part 5: Common rail fuel injection system*

3 Terms, definitions and symbols

3.1 Terms and definitions

For the purposes of this part of ISO 13948, the terms and definitions given in ISO 7876-1 to ISO 7876-5 apply.

3.2 Symbols

D_T	Thread size
D_1	Clearance diameter for mating connection
D_2	Major diameter for washer sealing face
D_3	Minor diameter for washer sealing face / cone diameter
D_4	Pipe/seal bore diameter
D_5	Connecting hole diameter
T_1	Minimum depth of full thread form
T_2	Tapping drill depth
T_3	Pipe seat depth

4 Connection designs and applications

4.1 General

Tables 1 to 5 indicate the preferred designs, sizes and key dimensions for three different low-pressure connection applications for fuel injection pumps and injectors:

- fuel: inlet, back-leakage and any other fuel connection on pumps;
- lubrication oil: for use mainly with inline pumps that have a separate lubrication supply to the fuel feeding system;
- air: for the connection of an engine inlet pressure signal.

Five different design principles are shown in Figures 1 to 5 (combined with typical mating pipe end-connections) as types A to E. Types C and D have features in common with type A and therefore can be used as type A connections.

4.2 Types of connection

4.2.1 Type A: banjo connection (see Figure 1)

This design uses external sealing washers each side of a “banjo” end-connection on the mating low-pressure pipe, the flow from which is usually directed at right angles to the plane of flow of the connection. The pipe end-connection is secured to the pump connection by means of a “banjo” bolt.

The specified configuration on the housing site may be used for the adaption of a straight connector also.

4.2.2 Type B: O-ring seal connection (see Figure 2)

This design is based on a similar design contained in SAE J2244/1 (ISO 6149-1) and utilizes an O-ring seal on a cone provided on the pump connection, outboard of the connection thread.

4.2.3 Type C: compression seal connection (see Figure 3)

The principle used in this design is compression sealing on a cone provided on the pump connection inboard of the connection thread.

4.2.4 Type D: internal rubber ring seal “flexible” connection (see [Figure 4](#))

This type of connection provides an internal sealing diameter, inboard of the connection thread, which is used in conjunction with a rubber sealing ring that is compressed by applying a torque to the pipe end-connection and is sealed by radial compression.

4.2.5 Type E: external rubber ring seal “flexible” connection (see [Figure 5](#))

This type of connection provides a sealing face (radius and internal bore) external to the main body of the connection. This sealing face is used in conjunction with a rubber sealing ring (fitted around the mating pipe) that is axially compressed a fixed amount by the connecting nut.

Type E is preferred to type B for flexible pipe fittings.

5 Dimensions and tolerances

For dimensions and tolerances for each of the five types of low-pressure connection, see [Tables 1 to 5](#).

The preferred size for each type of application is indicated by a cross (×).

Connection sizes shall be determined by the fuel injection system designer taking account of system flow rate requirements, standardization, cost and other factors.

All threads are recommended to be of tolerance grade 6H / 6g (medium).

iTeh STANDARD PREVIEW
(standards.iteh.ai)

6 Designation

Connections in accordance with this part of ISO 13948 shall be designated by the following elements:

- a) reference to this part of ISO 13948; [ISO 13948-1:2015](https://standards.iteh.ai/catalog/standards/sist/d100a697-4b99-4021-865e-e0c19dae2b06/iso-13948-1-2015)
- b) the type of connection, in accordance with [Figures 1 to 5](#) and [Tables 1 to 5](#);
- c) the thread designation, in accordance with ISO 261.

EXAMPLE A low-pressure fuel connection of type A with an M10 × 1,25 thread is designated as follows:

ISO 13948-1 – A – M10 × 1,25