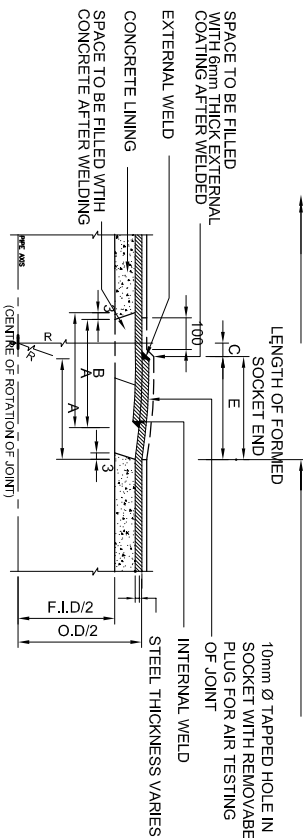
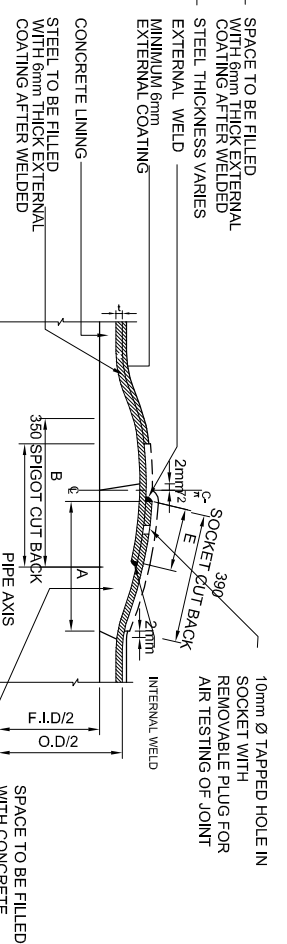


HEMI-SPHERICAL SLEEVE JOINT/SIP JOINTS
(FOR PIPES BELOW 700mm F.I.D.)



HEMI-SPHERICAL SLEEVE JOINT/SIP JOINTS
(FOR PIPES 700mm F.I.D. AND ABOVE)

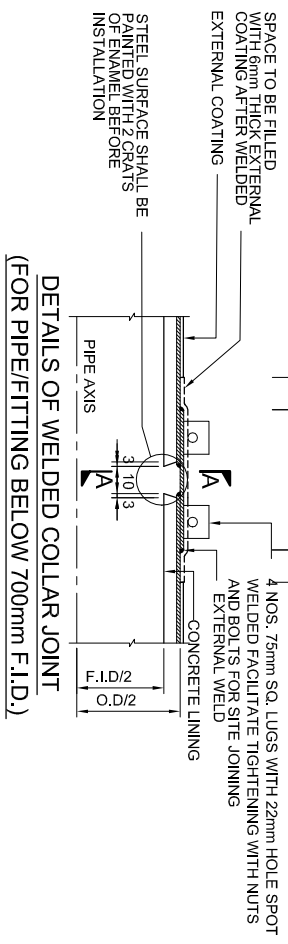
PIPE F.I.D. (mm)	PIPE O.D. (mm)	RADIUS (mm)	STEEL THICKNESS (mm)	HEMI-SPHERICAL SLEEVE JOINT			MAX. W (mm)		
				ENGAGEMENT E (mm)	MINIMUM A (mm)	B (mm)			
149.1	177.3	89	4.1	25	20	130	30	5	10
204.0	232.2	116	4.1	25	20	130	30	5	10
257.8	286.0	143	4.1	25	20	130	30	5	10
313.8	345.4	173	5.8	35	25	145	45	10	20
388.4	426.0	213	5.8	35	25	145	45	10	20
415.5	453.1	227	5.8	35	25	145	45	10	20
469.4	507.0	254	5.8	35	25	145	45	10	20
522.7	560.3	280	5.8	35	25	145	45	10	20
628.0	667.0	334	6.5	45	30	160	60	15	20
701.2	754.0	377	7.4	45	30	160	60	15	-
751.2	804	402	7.4	45	30	160	60	15	-
1036.0	1107.0	554	9.5	60	40	180	80	20	-
1200.0	1270.0	635	10.0	65	40	190	90	25	-



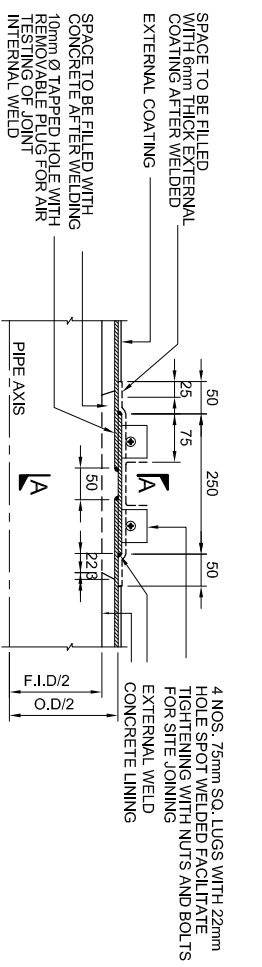
SPHERICAL SLEEVE JOINT
(FOR PIPES 1400mm F.I.D. AND ABOVE)

PIPE F.I.D. (mm)	PIPE O.D. (mm)	RADIUS R (mm)	STEEL THICKNESS (mm)	SPHERICAL SLEEVE JOINT DETAIL			A (mm)	B (mm)	C (mm)
				ENGAGEMENT E (mm)	MINIMUM A (mm)	B (mm)			
2200.0	2290.0	1190	15	164	60	335	538	50	
2050.0	2138.0	1111	14	153	56	301	503	47	
1800.0	1876.0	977	13	137	52	274	451	41	
1400.0	1472.0	769	11	112	44	223	368	33	

SECTION A-A



DETAILS OF WELDED COLLAR JOINT
(FOR PIPE/FITTING BELOW 700mm F.I.D.)



DETAILS OF WELDED COLLAR JOINT
(FOR PIPE/FITTING 700mm F.I.D. AND ABOVE)

NOTE:-
1. ALL DIMENSIONS ARE IN MILLIMETRE UNLESS OTHERWISE STATED.
2. THE OUTSIDE DIAMETER OF PIPE SHALL MEAN THE EXTERNAL DIAMETER OF STEEL PIPE BEFORE COATING.



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DRAWING TITLE :
DETAILS OF JOINTS
(SHEET 1 OF 2)

DRAWING NO :
SPAN/MS/STD/F/013