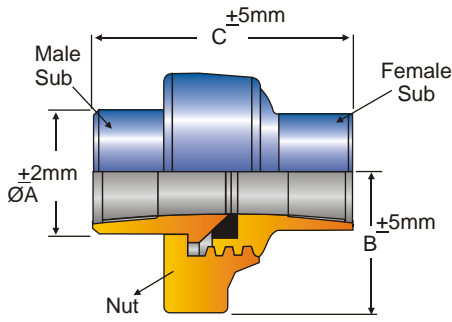


## HAMMER UNIONS

**Fig. 600. Silver Subs - Black Nut**

These unions have wide range of applications including steam service and line connections. These unions are provided with a bronze seat in the female for the effective sealing and prevention of rust formation. Suitable for 6000 PSI CWP.

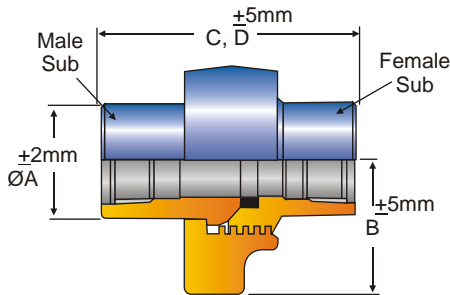


**6,000 PSI CWP (FIG - 600)**

SIZE (INCH)	A		B		C		ACME (TPI)	UNION WEIGHT	
	INCH	MM	INCH	MM	INCH	MM		LBSF	KGF
1	1.75	44.5	2.26	57.5	3.58	91	6STD	3.52	1.6
1 1/2	2.55	65	3.07	78	4.92	125	4STD	9.26	4.20
2	3.07	78	3.70	94	6.42	163	2STD	15.43	7.00
2 1/2	3.54	90	4.17	106	7.52	191	2STD	20.28	9.20
3	4.25	108	4.54	115.5	8.72	221.5	2STD	27.23	12.40
4	5.27	134	5.19	132	10.04	255	2STD	40.0	18.10

**Fig 602. Orange Subs - Black Nut**

These unions are recommended for manifold and line connections truck mounting and in mud services. This union has resilient lip-type seal for positive sealing and also protects secondary metal - to metal seal. Suitable for 6000 PSI.

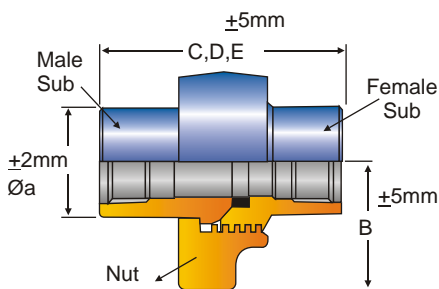


**6,000 PSI CWP (FIG - 602)**

SIZE	A		B		C		BUTT WELDED END D		ACME (TPI)	UNION WEIGHT	
	INCH	MM	INCH	MM	INCH	MM	INCH	MM		LBSF	KGF
1	1.75	44.5	2.28	58	3.50	89	3.50	89	6STD	3.30	1.5
1 1/4	2.60	66	3.23	82	4.88	124	4.88	124	4STD	11.00	5.0
1 1/2	2.56	65	3.06	77.8	4.88	124	4.88	124	4STD	9.7	4.4
2	3.07	78	3.81	97	5.25	133.5	5.28	133.5	3MOD	12.12	5.5
2 1/2	3.51	89.1	3.75	95.5	6.24	158.5	5.59	142	3MOD	15.87	7.2
3	4.25	108	4.52	115	6.22	158	5.62	143	3MOD	20.94	9.5
4	5.27	134	5.04	128	8.23	209	5.67	144	3MOD	30.86	14.0

**Fig 1002. Blue Subs - Red Nut**

These unions are designed for high pressure systems like choke and kill lines, cementing, acidizing, testing and truck mounted system. This union has a lip-type seal made of nitrile rubber and subs made of alloy steel, suitable for 10,000 PSI.



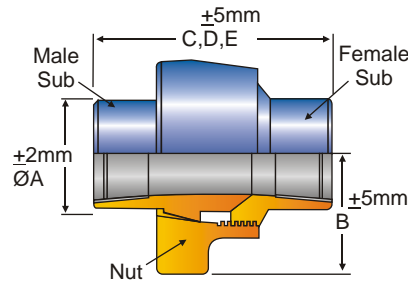
**10,000 PSI CWP (FIG - 1002)**

SIZE	A		B		C		BUTT WELDED END				ACME (TPI)	UNION WEIGHT	
	INCH	MM	INCH	MM	INCH	MM	D		E			LBSF	KGF
							SCH-160 INCH	SCH-160 MM	SCH-XXS INCH	SCH-XXS MM			
1	1.75	44.5	2.28	58	3.50	89	3.50	89	3.50	89	6STD	3.5	1.6
1 1/4	2.60	66	2.95	75	4.88	124	4.88	124	4.88	124	4STD	9.7	4.4
1 1/2	2.55	65	3.18	81	4.88	124	4.88	124	4.88	124	4STD	9.25	4.2
2	3.07	78	3.81	97	5.25	133.5	5.28	133.5	5.28	133.5	3MOD	12.12	5.5
2 1/2	3.46	88	3.78	96	6.18	157	6.18	157	6.18	157	4STD	16.0	7.0
2 1/2(EUE)	3.81	97	4.00	100	5.51	140	-	-	-	-	4STD	17.8	8.1
3	4.25	108	4.52	115	6.22	158	5.51	140	5.51	140	4STD	22.26	10.1
4	5.27	134	5.04	128	8.23	209	5.67	144	5.67	144	4STD	33.0	15.0
5	5.55	141	6.10	155	6.22	158	6.22	158	6.22	158	3STD	56.0	25.4
6	6.62	168.3	6.81	173	6.57	167	6.57	167	6.57	167	3STD	79.8	36.2

## HAMMER UNIONS

### Fig 1003. Green Subs - Black Nut

These unions have a ball seat incorporating a primary 'O' ring seal with a metal secondary seal which assures perfect sealing in misalignment position. Degree of misalignment upto 2" size is 4° and beyond 2" size it is 7 1/2°. This union is ideally suited for use on high pressure lines. Available in 10000 PSI with end threaded or butt-welded for welding.

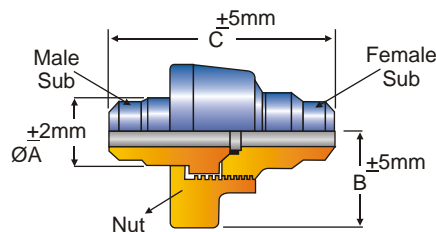


10,000 PSI CWP (FIG - 1003)

Size (Inch)	A		B		C		Beveled Ends				ACME (TPI)	Union Weight	
	Inch	mm	Inch	mm	Inch	mm	D		E			lbsf	kgf
							Sch-160 Inch	mm	Sch-xxs Inch	mm			
1	1.77	45	2.36	60	5.0	127	5.0	127	5.0	127	4STD	5.0	2.3
2	3.00	76	3.86	98	4.80	122	4.80	122	4.80	122	4STD	12.6	5.7
3	4.29	109	4.96	126	9.17	233	8.82	224	9.17	233	4STD	44.5	20.0
4	5.43	138	5.74	146	10.94	278	10.78	274	10.98	279	4STD	73.0	32.8
5	5.62	143	6.74	146	-	-	10.78	274	10.98	279	6STD	73.0	32.8

### Fig 1004. Red Nut - Grey Subs

These union use lip type seal ring end here faces of male and female sub are perfectly square. These are available in 5" & 6" butt weld sizes.



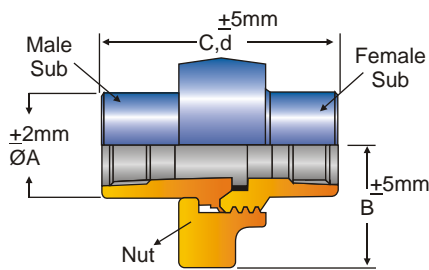
10,000 PSI CWP (FIG - 1004)

Size (Inch)	A		B		C		ACME (TPI)	Union Weight	
	Inch	mm	Inch	mm	BUTT WELDED ENDS			lbsf	kgf
					Inch	mm			
5	6.30	160.0	6.50	165.1	8.15	207.0	-	86	39
6	7.40	189.0	7.2	182.8	9.50	241.3	-	142	64

## HAMMER UNIONS

### Fig 1502. Blue Nut - Pink Subs

These unions are widely used in cementing, manifold and other services wherein extra high pressures of 15,000 PSI CWP are encountered. These unions are provided with replaceable seal ring.



15,000 PSI CWP (FIG - 1502)

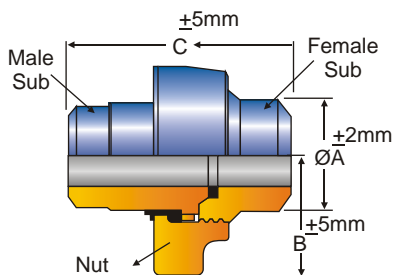
Size (Inch)	A		B		C		D		ACME (TPI)	Union Weight	
	Inch	mm	Inch	mm	Inch	mm	BEVELED ENDS			lbsf	kgf
							Inch	mm			
1	2.18	55.5	2.75	70	4.33	110	4.33	110	3.5STD	8.5	3.8
1.1/2	2.96	75.2	3.48	88.5	5.39	137	5.39	137	3.5STD	12.8	5.7
2	3.22	82	3.86	98	7.03	178.5	6.30	160	3STD	20.3	9.2
2.1/2	3.74	95.2	3.96	100.6	7.28	185	7.08	180	3STD	23.0	10.3
3	4.45	113	4.53	115	7.67	195	5.28	134	3.5STD	29.5	13.3
4	5.75	146.1	6.00	152.2	8.54	217	10.55	268	3MOD	76.5	34.4
5	6.45	164	6.53	166	-	-	9.0	230	-	96	43
6	7.48	190	7.2	183	-	-	9.8	249	-	148	67

### Fig 2002. Green Nut - Grey Subs

These unions are provided with replacement lip-type seal and are recommended for choke and kill lines, cementing, acidizing and testing services for pressure up to 20,000 PSI CWP.

### Fig 2202. (H2S) - Olive Green

These unions are specially designed for sour gas service in accordance with NACE Std. MR-01-75 and API Std. RP-14E for pressure up to 15000 PSI CWP. Dimensions identical with Fig-2002 above.



20,000 PSI CWP (Fig. - 2002)

15,000 PSI CWP (Fig. - 2202)

Size (Inch)	A		B		C		ACME (TPI)		Union Weight	
	Inch	mm	Inch	mm	Inch	mm	Fig. 2002	Fig. 2202	lbsf	kgf
							-	-		
2	2.5	63.5	3.75	95.2	7.44	189	4	5	22.6	10.1
3	5.38	136.7	6.00	152	10.51	267	4	5	49.0	22.2
4	5.5	139.7	6.00	152	8.65	220	-	-	77.5	35.1
5	6.12	155.4	6.55	166	10.9	277	-	-	112.0	50.8
6	7.75	197.0	7.30	185	13.20	335	-	-	169.0	76.7

#### NOTE:

1. PARVEEN 2" Fig 2202 is interchangeable with Fig 2" 2052/2252 & 2 1/2" 2052/2252 of other reputed makes.
2. Dimension 'A' will vary depending upon size of weld preparation.