

始



鑄鐵會

金石鑄造株式會社

特228
853



釜石鑛山株式會社製

鑄 鐵 管

一 手 販 賣

三井物産株式會社

資 本 金

壹 億 圓

本 部

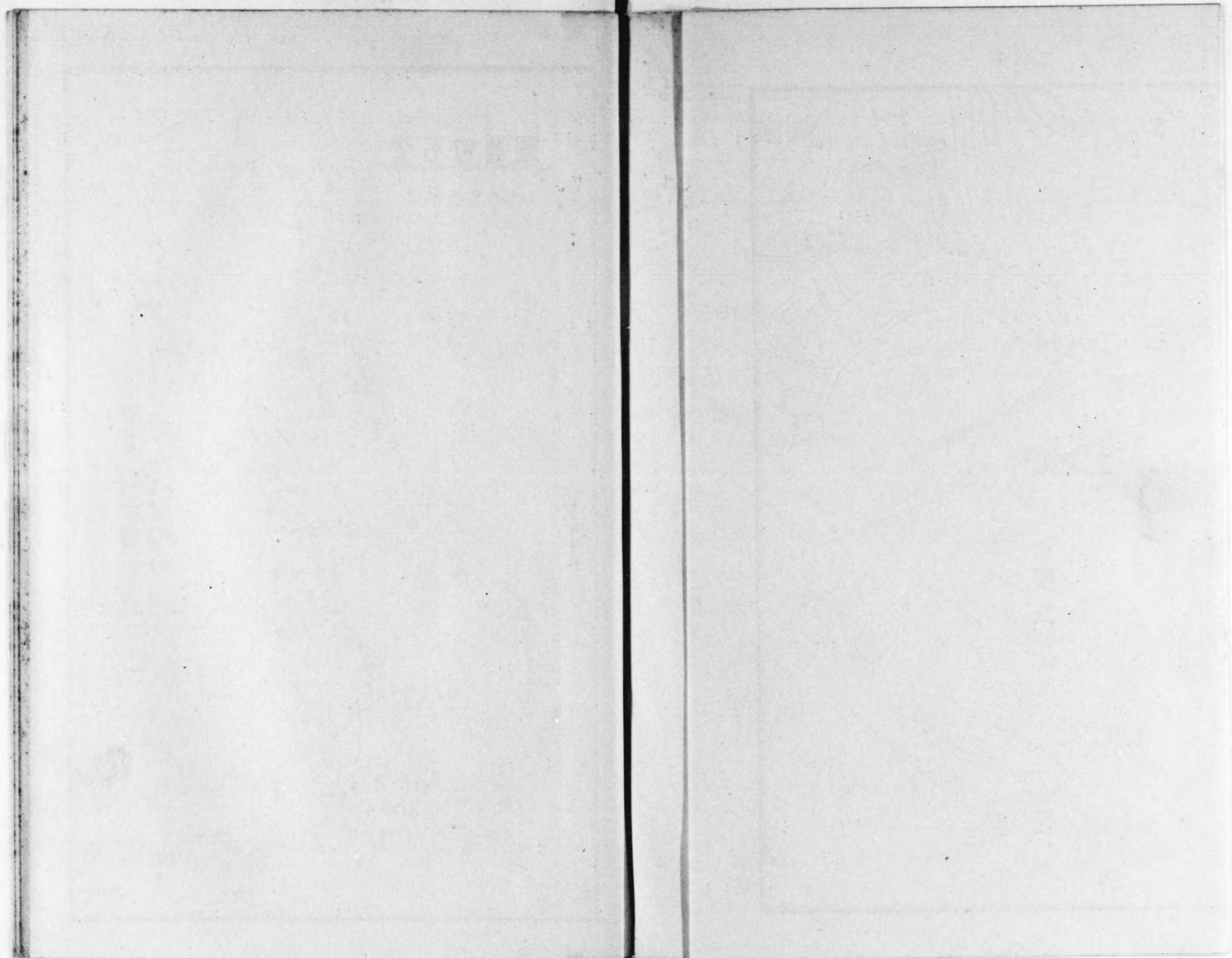
東京市日本橋區本町二丁目一番地
三井物産株式會社 機械部鐵道掛

電話日本橋(24) {自2251
 {至2275
(夜間休日用) {自2281
 {至2285

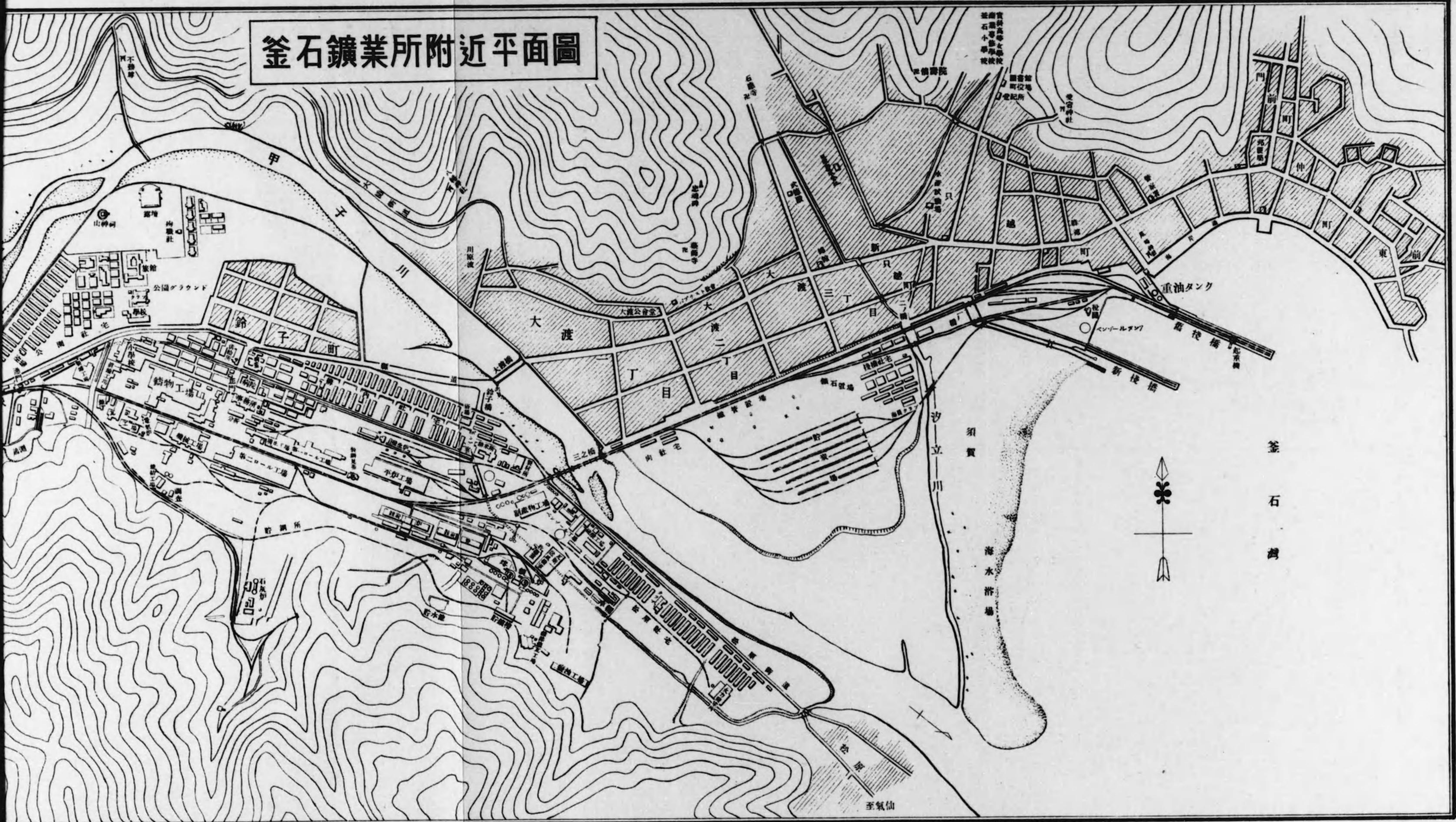
支 店

大阪支店	大阪市東區高麗橋二丁目一番地
名古屋支店	名古屋市中區笹島町四丁目二番地
橫濱支店	橫濱市中區日本大通リ一四番地
神戸支店	神戸市海岸通三番地
小樽支店	小樽市色内町五丁目一〇番地
門司支店	門司市大字門司字棧橋通二番地ノ四
長崎支店	長崎市常盤町三番地
三池支店	大牟田市有明町六九番地
臺北支店	臺北市表町一丁目三一番地
高雄支店	高雄市新濱町一丁目五一番地
京城支店	京城府黃金町一丁目六三番地
大連支店	大連市山縣通一八二番地

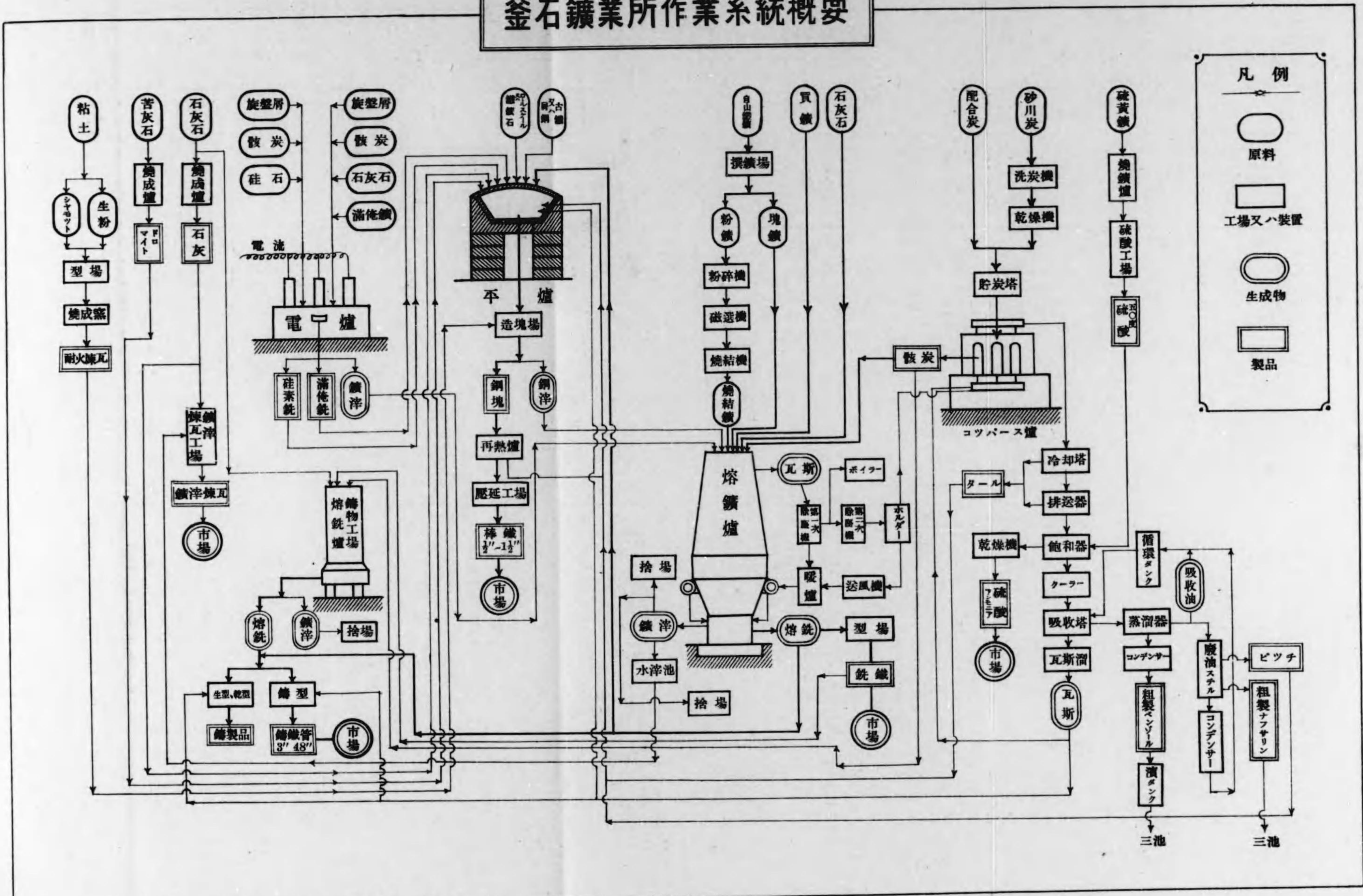
⊗ 内外各地=支店ノ外出張所、出張員、派出員ヲ置ク ⊗



釜石鑛業所附近平面圖



釜石鑛業所作業系統概要





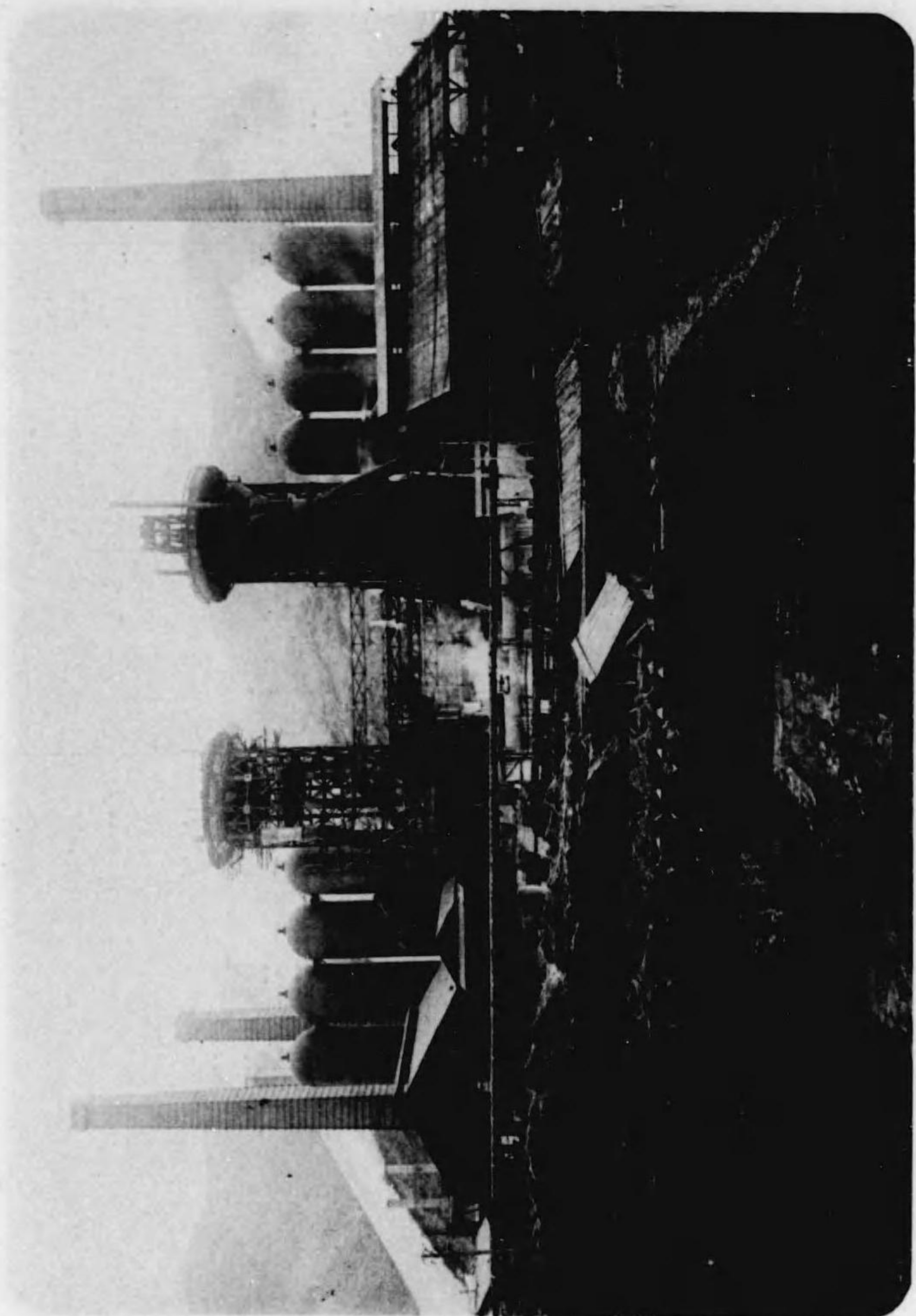
景全所業鑛石釜



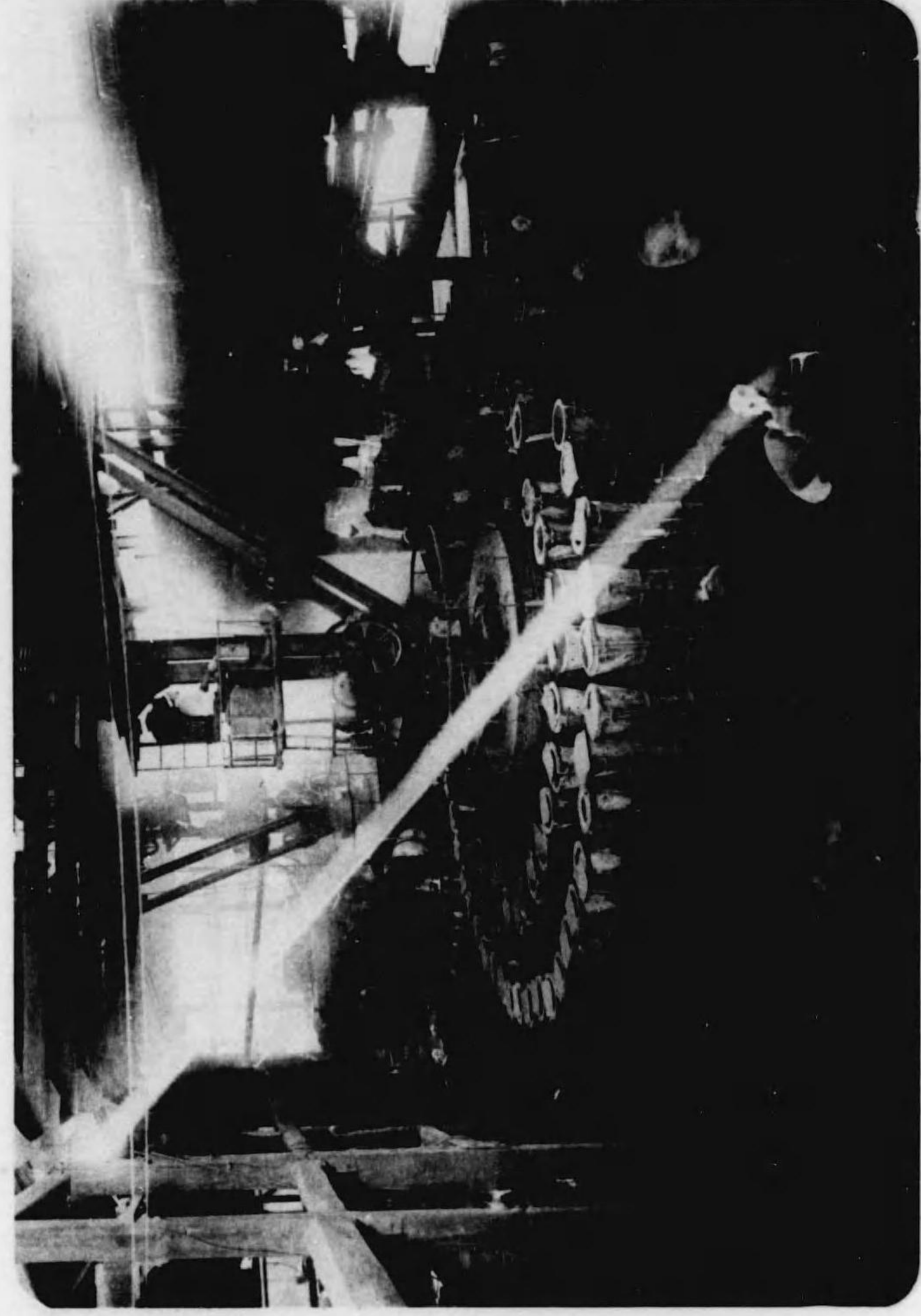
探 鑽 場 八 番 坑 附 近



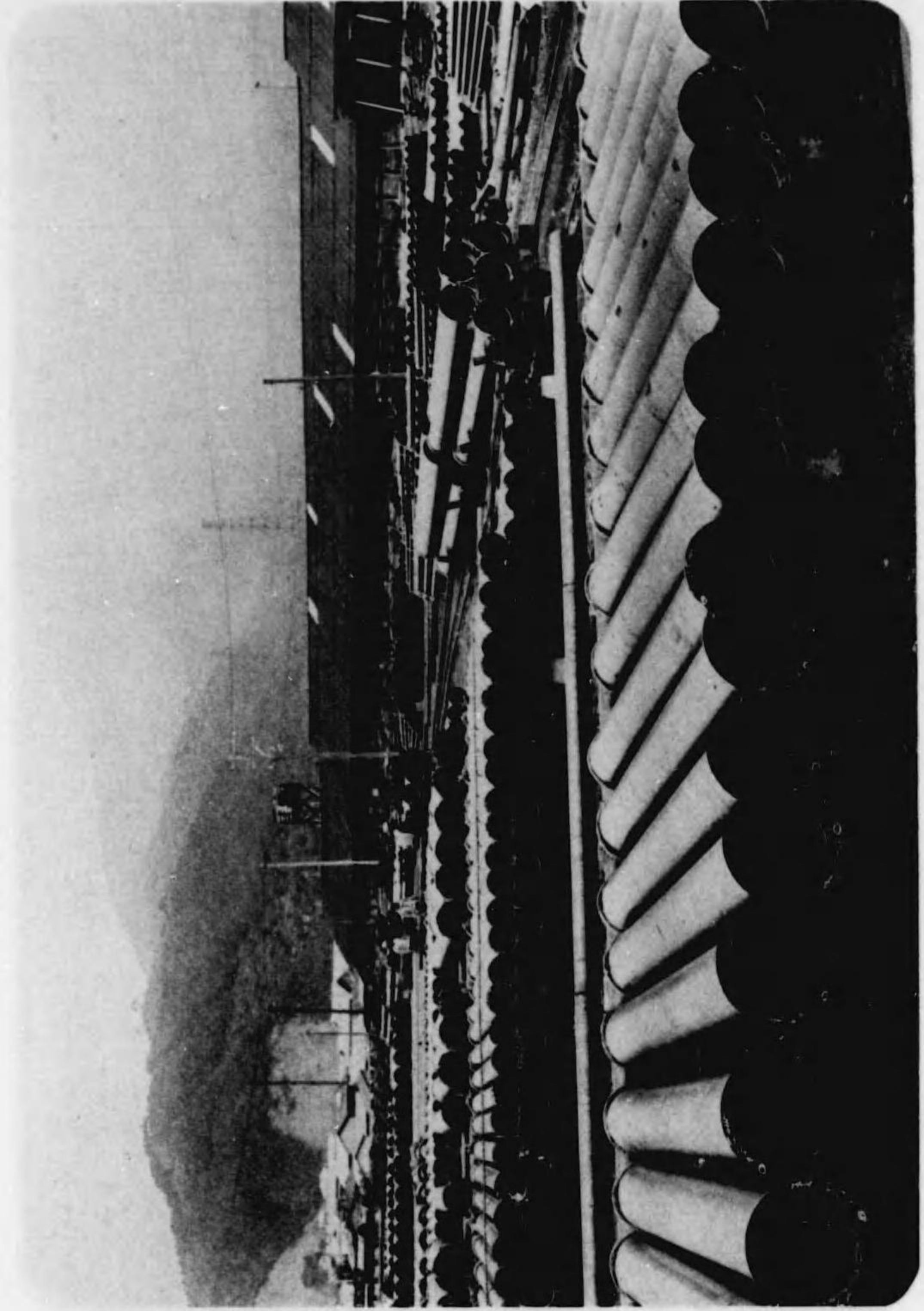
坑內探實情況



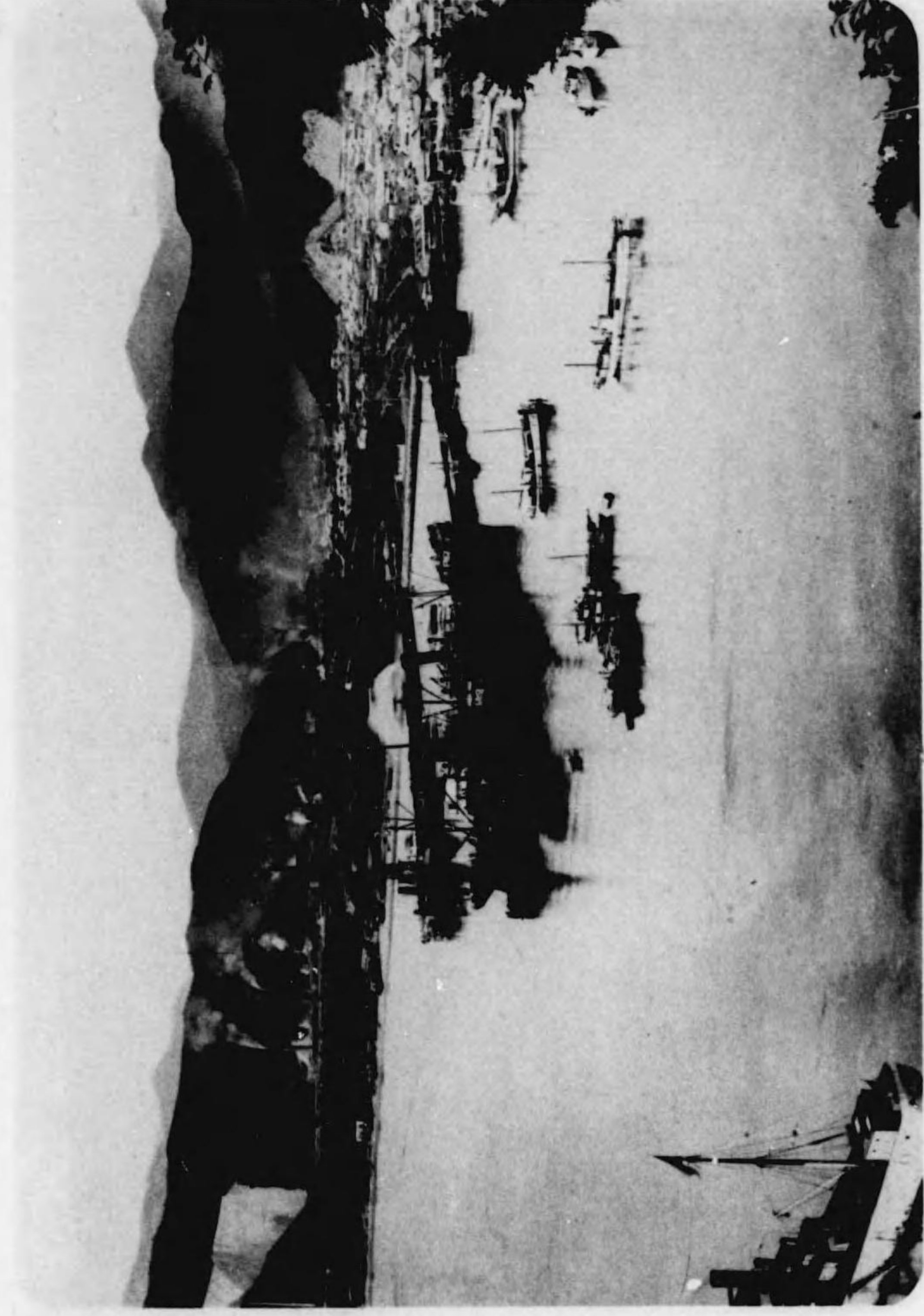
熔 鑄 爐



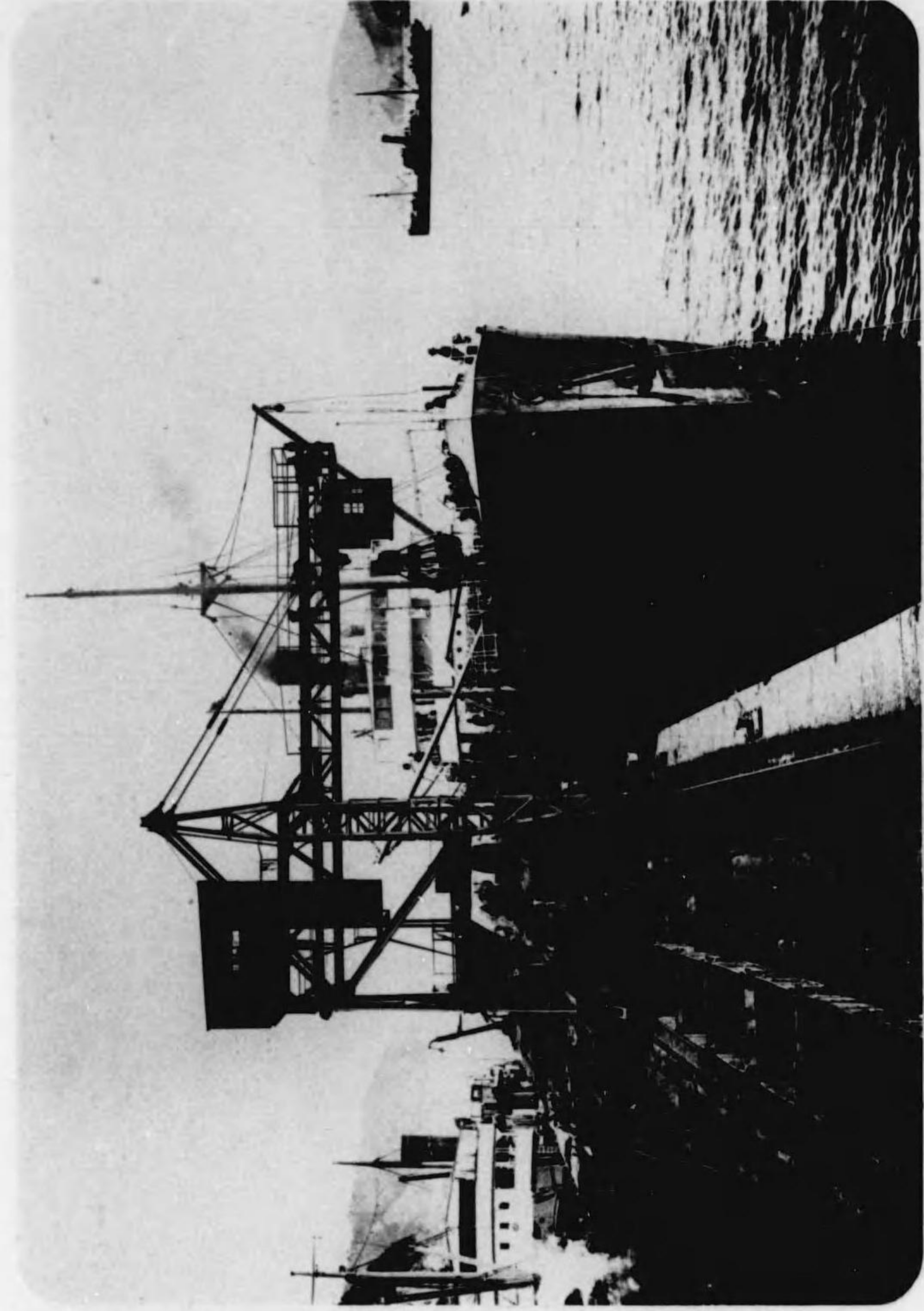
部一ノ場工管鐵鑄



管 鐵 鑄



釜石港全景



シ
ン
ー
レ
ク
橋
棧



圖表及寫真

- 釜石位置圖
- 釜石鑛業所附近本前圖
- 同 作業系統概要
- 釜石鑛業所全景
- 釜石鑛山探鑛場全景
- 同 坑內探掘實況
- 同 熔鑛爐
- 同 鑄鐵管工場ノ一部
- 同 鑄鐵管
- 釜石港全景
- 同 棧橋クレーン

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製品及生産能力 2

銑鐵、鋼材、鑄鐵管、硫酸安母尼亞、鑛滓煉瓦、粗製ベンゾール

事業ノ概要 3

- 探 鑛 鑛區、鑛石、探鑛、選鑛、運鑛
- 製 銑 現況並ニ豫定
- 製 鋼 及 壓 延
- 鑄 鐵 管
- 運 輸 交 通 社船、港灣設備、陸上設備、旅客道程
- 工場ノ地積及要員 敷地坪數、建坪數、從業員
- 從業員=對スル施設 社宅、供給所、小學校、病院、俱樂部、公園及運動場、眞道會、青年訓練所、青年團、鑛業所在郷軍人分會

上水協議會諸規格

水道條令

水壓表

度量衡換算表



釜石鑛山株式會社

沿 草

嘉永二年(西曆1849年)三河ノ人高須、陸中ノ人中野、大橋ニ小規模ノ熔鑛爐ヲ設ケ附近ニテ採取セル磁鐵鑛ヲ以テ鐵ノ製煉ヲ始メタリ。

明治維新ノ際舊南部藩ノ所有ニ歸シ藩主鑛業ヲ獎勵シ其臣大島高任ヲシテ洋式高爐ヲ築造センメ面目ヲ一新セリ。

明治六年盛岡ノ人小野善右衛門大橋鑛山ヲ讓リ受ケ改良高爐二基ヲ建設シタルガ明治七年政府之ヲ買上ゲ釜石町鈴子ニ工場ヲ設ケ英國人技師數名ヲ招聘シ各種新式設備ヲ施シ明治十五年工事完成シ操業ヲ開始センモ結果良好ナラズ翌十六年遂ニ廢業セリ。

明治十八年田中長兵衛氏工場ノ一部ヲ借受ケ幾多ノ困難ヲ經テ漸ク鐵製煉ノ可能ヲ認メタルヲ以テ明治二十年釜石鑛山、工場、棧橋等全部ノ拂下ヲ受ケ其後附近ノ各鑛區ヲ買收シ現在事業ノ基礎ヲ作レリ。其後逐年擴張發達ヲ計リ明治三十五年ヨリ鑄鐵管ノ製造ヲ始メ更ニ同三十六年ヨリ壓延鋼材ノ製造ヲモ始メタリ。

大正六年株式組織ニ改メ田中鑛山株式會社ヲ設立ス。

大正十三年七月其ノ經營ヲ三井ニ於テ繼承スルニ及ビ釜石鑛山株式會社ト改稱シ銳意業務ノ刷新ヲ計リ漸ク堅實ナル發達ヲ來スト共ニ更ニ巨額ノ投資ヲ爲シ製鉄、製鋼及鑄鐵ノ設備ヲ擴大シテ製品ノ増加ヲ劃シ大ニ本邦製鐵界ニ貢獻セン事ヲ期セリ。

製品及生産能力

銑 鐵

昭和三年實産額(各種)……………八萬 匁
 昭和四年産出豫定……………十五萬 匁
 昭和五年以降……………二十萬 匁

鋼 材

丸鋼徑12^m/mヨリ48^m/mマデ……………八萬 匁

鑄 鐵 管

……………四萬 匁

硫酸安母尼亞

昭和三年……………千五百 匁
 昭和四年……………三千 匁
 昭和五年……………四千 匁

鑄 滓 煉 瓦

……………五千 匁

粗製ベンゾール

昭和四年……………三千 匁
 昭和五年……………四千 匁

事業ノ概要

採 鑛

製鉄供用ノ鑛石ハ主トシテ自産鑛ニ依ル

鑛 區 所在地：岩手縣上閉伊郡甲子、上郷、栗橋ノ三箇村ニ跨ル。

採掘鑛區面積：一百九十三萬餘坪

試掘鑛區面積：三百十三萬五千坪

鑛 石 磁鐵鑛ニシテ品質精良ナリ、分析品位大凡次ノ如シ。

百分中	鐵	硅酸	石灰	礬土	硫黃	磷
	58.086	6.600	6.905	2.560	0.723	0.039

採 鑛 シュリンケージ採鑛法ニ依リ採掘ス、總テ機械掘ニシテ人力ニ依ラズ、照明モ坑内總テ電燈ヲ完備シ手提ゲ燈ノ要ナキコト他山ニ其比ヲ見ザル所ナリ。

選 鑛 鑛石ハ之ヲ選鑛場ニ於テ碎鑛機ニヨリ方約二寸ノ大サニ碎キ篩機ニヨリ塊粉鑛ニ篩分ケ、更ニ岩石ヲ選別シタル後貯鑛槽ニ入ル。

運 鑛 坑内運搬ニハ瓦斯倫機關車ヲ用ヒ、共ヨリ一哩ノ軌道ヲ經テ選鑛場ニ送り、選鑛場ヨリ熔鑛爐マデ11.5哩社有輕便鐵道ニ依リ運搬ス。

製 銑

目下 二百五十噸熔鑄爐一基稼行中。

豫定 昭和五年ヨリ熔鑄爐二基操業日産四百五十噸ニ進メ、昭和六年ヨリ附屬設備ノ完成ト共ニ五百五十噸トナス豫定。

原料鑛石ハ自産鑛ノ外一部輸入赤鐵鑛ヲ配合シ石灰石ハ自營鐵道沿線ノ洞泉及大松ヨリ採掘シテ供用ス。

製煉用ノ骸炭ハ三井鑛山株式會社經營ノ北海道砂川粉炭及北海道炭礦汽船會社ノ夕張粉炭ヲ主要原料トシ、コツパース式副産物採收裝置ヲ有スル骸炭爐ニヨリ製造ス。

目下擴張工事トシテ三池式最新考案ニヨル骸炭爐築造中ナリ。銑鐵ノ分析品位ハ大略次ノ如ク品質優良ニシテ靱性強大ナル特徴ヲ有スルコト普ク人ノ知ルトコロナリ。

	全炭素	硅素	滿 俺	磷	硫 黄
鑄物用一號	3.00-4.00	2.50-3.50	0.30-0.55	0.15-0.25	微量
二號	〃	2.00-3.00	〃	〃	0.02以下
三號	〃	1.50-2.50	〃	〃	0.01以下
四號	〃	1.00-2.00	〃	〃	0.01以下
鹽基性銑	〃	1.30以下	1.00-1.50	0.20-0.50	0.02-0.05

銑鐵ノ種類ハ下記色分ヲ以テ區別ス。

一號銑	兩端	白	色
二號	〃	青	色
三號	〃	赤	色
四號	〃	黑	色

當社銑ニハ二箇所ニ「K」ノ字ヲ鑄出セリ。

製鋼及壓延

目下「シーメンス・マルチン」二十五噸平爐四基ヲ以テ操業ス。内三基ハ發生爐瓦斯ヲ、一基ハ骸炭爐瓦斯及コールタールヲ燃料トシテ精鍊ヲ行ヒ熔鋼ヲ小鋼塊ニ鑄造ス。

鋼塊ハ之ヲ第一第二ノ小型壓延工場ニ送り再熱爐ニテ加熱シ壓延機ニ掛ケ12^m乃至48^mノ丸鋼材ヲ製造ス。

鑄 鐵 管

斯業ノ開始以來熔銑法、成型法、乾燥法ニ付夙夜研究ヲ怠ラス改善ニ努メ就中鑄鐵管作業中最モ重要ナル鑄型乾燥用ノ燃料ニ於テ先ツ「レトルト」瓦斯ヲ用ヒ其後發生爐瓦斯ニ變更シ次テ熱風乾燥法ヲ採用シ遂ニ進ンデ大正二年五月ニ至リ熔鑄爐瓦斯使用ニ成功シ茲ニ初メテ經濟上最モ有利ナル方法ヲ採用スルニ至レリ。

而シテ更ニ大正十年四月「コツパース」骸炭爐瓦斯ヲ使用シ得ルニ至リ、益々好成績ヲ舉ゲ爾來技術ノ進展ハ銑鐵ノ優良ト相俟チ彌々釜石鑄鐵管ノ聲價ヲ高メ管質ノ均齊ニシテ強靱ナルヲ誇ルニ至レリ。

原料ハ總テ自家産ノ銑鐵ヲ使用シ管種内徑75^mヨリ1,500^m迄ヲ製造ス。管ハ一本毎ニ嚴重ナル計量、管體検査竝ニ水壓試驗ヲ行フ。

直管ノ外各種異形管ノ鑄造ヲナス。

當社ノ製品ニハ總テ釜石ノ印ヲ鑄出ス。

運 輸 交 通

製品ノ積出シ、購入品ノ引取ハ主トシテ海運ニヨリ社船二隻ヲ充當シ傍ラ隨時傭船ヲ爲シテ之ヲ輔ケシム。

社 船	みかど丸 (重量噸バンカー共2,380噸)
	勢 德 丸 (" 1,475噸)

港 灣 設 備

棧橋二架	一ハ幅五十四尺 長サ六百尺
	一ハ幅三十尺 長サ五百七十尺

水深干潮面二十五呎
五六千噸級ノ船舶繫留安全ナリ

荷役用起重機 五噸クレーン二臺ヲ設備シ荷役ノ敏速ヲ期セリ。

陸上設備

釜石、大橋間輕便鐵道	ゲージ2'-6"	9.2
工場内側線	// //	11.6
蒸氣機關車		9臺

旅客道程

東北本線花卷驛ニテ岩手輕鐵ニ乗替ヘ仙人峠驛下車
 峠約一里徒歩連絡(馬、駕アリ)大橋驛ヨリ當社釜石鐵道
 鈴子驛ニ至ル。
 別ニ岩手輕鐵遠野驛ヨリ鈴子迄自動車ノ便アリ(約三
 時間)

工場ノ地積及要員

敷地坪數	(鑛山ヲ除ク)	245,000坪
建坪數	工場並附屬家屋共	35,000坪
従業員	職員	170名
	職工、勞務者	3,500名

従業員ニ對スル施設

従業員及家族子弟ノ教育、娛樂健康ニ就テ特ニ注意シ社宅、日
 用品廉價供給所、小學校、病院、俱樂部ヲ設ケ、公園及運動場
 フモ設備ス。
 又従業員ノ意思疎通ヲ計ルタメ工場委員制度ニヨル協調機關
眞道會ヲ設ケ、青年職工教化ノ爲ニハ青年訓練所及青年團、軍
人團トシテハ獨立ノ鑛業所在郷軍人分會アリ。

上水協議會

- 水道用鑄鐵管規格
- 水道用水栓類規格
- 水道用鉛管規格
- 翼車式量水器ニ關スル規格
- 附 錄

舊協定水道用鑄鐵管仕様書標準

-
- 水道條例
 - 水 壓 表
 - 度量衡換算表

水道用鑄鐵管規格

大正14年10月第22回上水協議會決定

大正15年10月第23回上水協議會改正

昭和 2年10月第24回上水協議會改正

昭和 3年 7月第25回上水協議會改正

水道用鑄鐵管規格及其の附表

水道用鑄鐵管規格及其の附表
水道用鑄鐵管仕様書標準の寸法を「メートル」式に変更及異形管の種類増加に関する調査書
水道用鑄鐵管の重量計算法

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- 1 甲 號 水道用鑄鐵管規格及其の附表
- 2 乙 號 水道用鑄鐵管仕様書標準の寸法を「メートル」式に変更及異形管の種類増加に関する調査書
- 3 丙 號 水道用鑄鐵管の重量計算法

甲 號

水道用鑄鐵管規格及其の附表

水道用鑄鐵管規格

第一章 總 則

第一條 本規格ハ砂型ヲ用キテ鑄造セル水道用ノ直管及
異形管(以下總括シテ管ト稱ス)ニ適用ス

第二章 種 別

第二條 直管ハ之ヲ二種ニ分チ靜水頭45m乃至75mニ對ス
ルモノヲ普通壓管ト稱シ靜水頭45m未滿ニ對スルモノ
ヲ低壓管ト稱ス
異形管ハ總テ靜水頭75m以下ニ對スルモノトシ前項ノ
種別ヲ設ケス

第三章 製造法

第三條 管ハ良質ノ鉄鐵ヲ用キテ鑄造シ組織均一且強靱
ニシテ錐モミシ易キモノナルコトヲ要ス

第四條 管ハ鑄込ミタル後急激ナル冷却ニ依リテ生スル
不等收縮其ノ他ノ障害ヲ避クル爲必要ナル時間鑄型ヨ
リ取出ササルコトヲ要ス

第五條 印籠接手ノ直管ハ承口ヲ下ニシ相當ノ押湯ヲ附
シ垂直ノ位置ニ於テ鑄造スルモノトス
押湯ノ部分ハ冷却ノ後丁寧ニ之ヲ切取ルモノトス

第四章 抗折試驗及抗張試驗

第六條 管ノ鑄造 = 用ウル銻銑 = 付テハ抗折試験ヲ行フモノトス

注文者又ハ其ノ指定シタル検査員(以下單 = 検査員ト稱ス) = 於テ必要ト認メタルトキハ抗張試験ヲ併セ行フモノトス

第七條 抗折試験片及抗張試験片 = 在リテハ一銻銑毎 = 試験片各3箇ヲ造リ之カ試験ヲ行ヒ3箇ノ平均 = 依リ其ノ成績ヲ定ムルモノトス

注文者又ハ検査員 = 於テ必要ト認メタルトキハ前項ノ試験ヲ2回以上行ハシムルコトヲ得

第八條 抗折試験 = 在リテハ幅50mm.厚25mm.長約650mm = 鑄造シタル鑄放シノママノ試験片ヲ用キ之ヲ600mmヲ隔ツル支ヘ刃ノ上 = 平手 = 載セ其ノ中心 = 800kgノ荷重ヲ加ヘタルトキ之 = 耐ヘ漸次荷重ヲ増加シ其ノ折レル前6.8mm以上ノ撓みヲ示スコトヲ要ス

抗折試験片ノ幅及厚ハ各10%以内ノ増減ヲ許シ其ノ程度 = 應シテ前項ノ荷重ヲ増減スルモノトス

第九條 抗張試験 = 在リテハ標準抗張試験片第三號 = 依リ徑Dヲ25mm乃至30mm = 仕上タル試験片ヲ用キ抗張力12.5kg/mm²以上ナルコトヲ要ス

第十條 抗折試験及抗張試験ノ成績カ本規格 = 合セサルトキハ其ノ試験片ノ代表スル銻銑ヲ用キテ鑄造シタル管ヲ總テ不合格トス

第五章 形狀寸法

第十一條 管ノ断面 = 於ケル内外周ハ實用的同心圓タルヘク又直管ハ其ノ管體真直ナルコトヲ要ス

管ノ形狀寸法ハ附表 = 依ルモノトス

第十二條 印籠接手ノ承口内徑及挿口外徑ノ公差ハ次表 = 依ルモノトス

公稱内徑 mm	公差 mm			
	直管		異形管	
	承口	挿口	承口	挿口
350以下	+3	-3	+4.5	-4.5
400-900	+4	-4	+6	-6
1000以上	+5	-5	+7.5	-7.5

第十三條 管厚ノ公差ハ直管 = 在リテハ負(-)ハ10%トシ正(+)ハ挿口寸法 = 影響ナキ限り制限ヲ附セス 但シ公差ノ最小値ハ1.5mm最大値ハ3mmトス

異形管 = 對シテハ前項ノ公差 = 其ノ50%ノ増加ヲ許スモノトス

第六章 記號

第十四條 管 = ハ外側一定ノ場所 = 水ノ字製造所ノ記號製造ノ年及番號ヲ高3mm.以上 = 鑄出スモノトス 但シ番號ハ注文者ノ承認ヲ經テ之ヲ省クコトヲ得 前項ノ外普通壓管 = ハ㊦又低壓管 = ハ㊧ノ記號ヲ鑄出スモノトス

不合格品 = 對シテハ第一項ノ水ノ字ヲ削リ落スモノトス

第七章 検査

第十五條 管ハ内外面共ニ滑ニシテ疵、瘤、錆、巢其ノ他有害ナル欠點ナキコトヲ要ス

疵、巢等ニ對シ詰め金又ハ埋め金ヲ爲スコトヲ許サス

第十六條 管ハ之ヲ十分ニ掃除シタル後小形ノ錠ヲ以テ輕ク錠打シ鑄物ノ良否ヲ検査スルモノトス

異形管ニ在リテハ註文者又ハ検査員ニ於テ特ニ必要ト

認メタルトキ切斷若ハ破壊シテ其ノ形狀寸法ヲ検査スルコトヲ得

第八章 塗装

第十七條 管ハ總テ内外面共ニ「コールタールピッチ」及亞麻仁油ノ混合塗料ヲ以テ塗装スルモノトス

塗装面ハ滑ニシテ光澤ヲ有シ寒暑ニ依リテ異狀ヲ呈セサルモノタルヲ要ス

第十八條 塗装ヲ爲スニハ管ノ内外面ヲ清潔ニ掃除シ錆ヲ完全ニ除去シ全體ヲ150°Cニ熱シ同溫度ノ前條ノ塗料液ニ浸シ液槽ヨリ引上ケタル後十分ニ液滴ヲ去リ空氣中ニ放置乾燥セシムルモノトス

第九章 水壓試験

第十九條 水壓試験ハ管ノ塗装乾燥シタル後1箇毎ニ之

ヲ行フモノトス

水壓試験ニ在リテハ次表規定ノ水壓ヲ保チツツ輕ク錠打ヲ爲シ漏洩ナキコトヲ要ス

種 別	公 稱 内 徑 mm	水 壓 kg/cm ²
低 壓 管	500 以上	10.5
	450 以下	17.5
普 通 壓 管 及 異 形 管	500 以上	14.0
	450 以下	17.5

前項ノ錠打ニ用ウル錠ハ軟鋼製ニシテ重量 1kg 以内、柄ノ長約 450mm トス

第十章 重量

第二十條 管ノ重量ハ塗装シタルモノニ付之ヲ測定シ附表ニ依ルモノトス

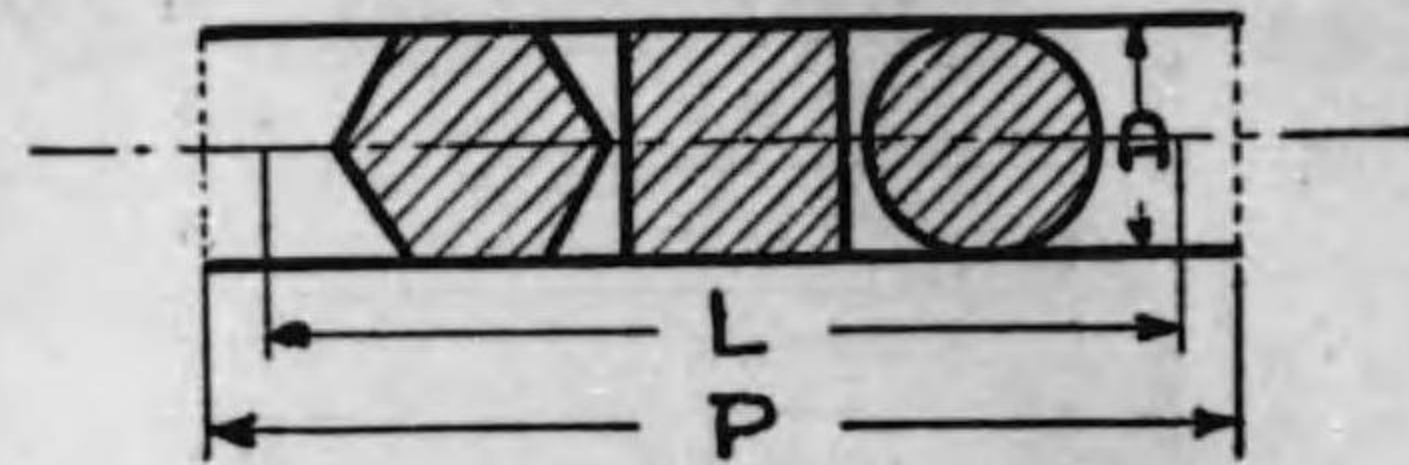
重量ノ公差ハ正(+)ハ制限ヲ附セス負(-)ハ次表ニ依ルモノトス

公 稱 内 徑 mm	公 差 %	
	直 管	異 形 管
350 以下	-4	-8
400-900	-3	-6
1000以上	-2	-4

附 錄 (日本標準規格第1號拔萃)

金屬材料抗張試驗片第三號

徑(又ハ對邊距離) 25mmヲ超ユル試驗片



標點距離 L ハ徑(又ハ對邊距離) D ノ 4 倍、兩端ヲ太クスル
モノニ在リテハ平行部ノ長 P ハ D ノ約 4.5 倍

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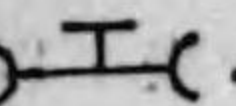
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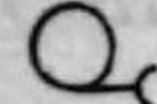
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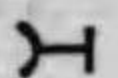
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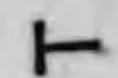
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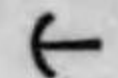
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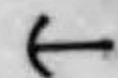
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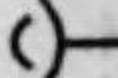
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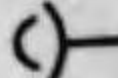
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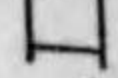
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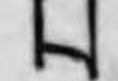
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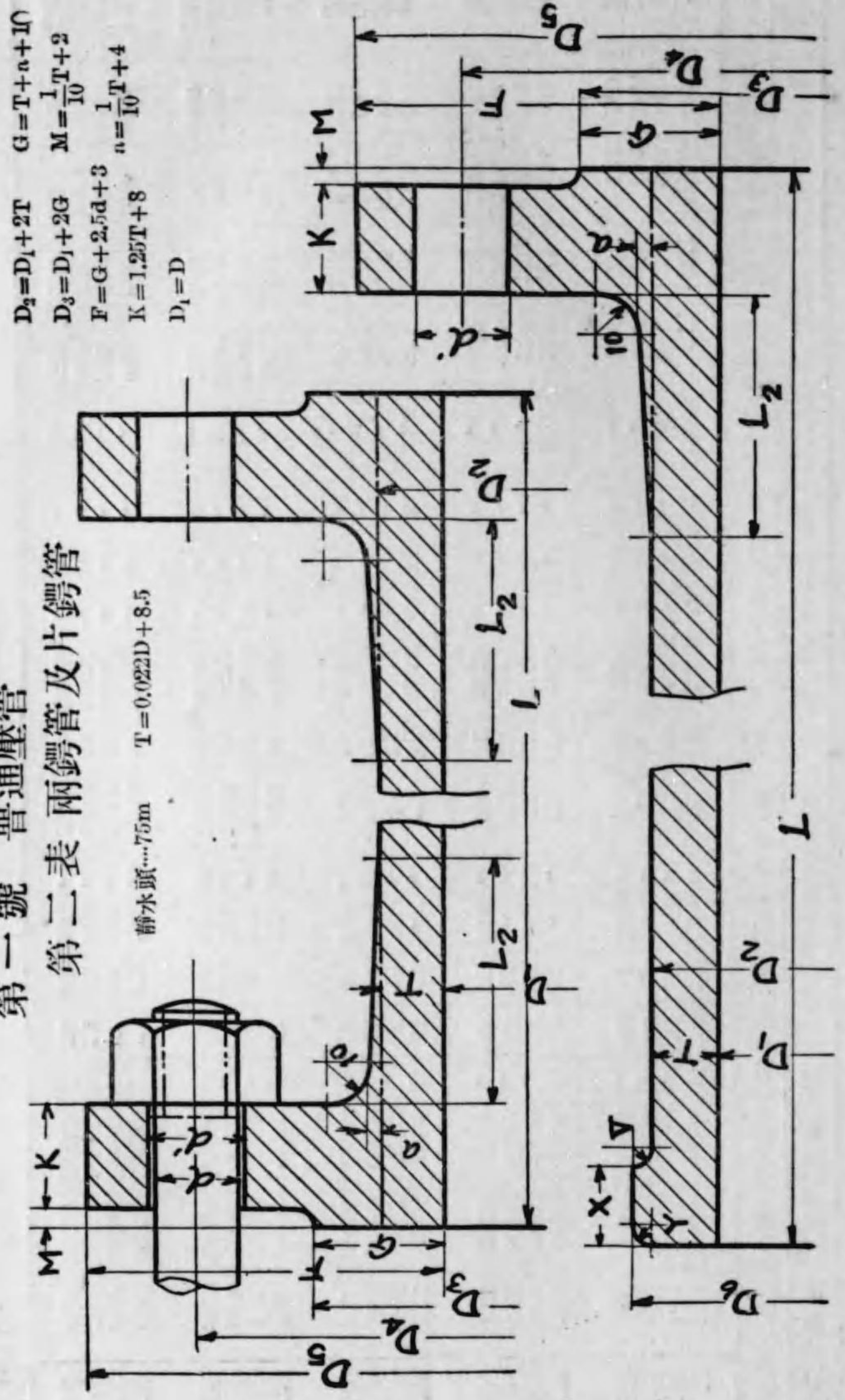
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(1) 本附表ニ於テハ特ニ記載セルモノノ外寸法ノ單位ハ耗 (mm) トシ 重量ハ斤 (kg) トス。

(2) 本附表中ノ「ボルト」ノ徑ノ欄ニハ「メートル」ねぢ「ボルト」ノ徑ヲ記入セルモ近似ノ徑ヲ有スル「ウイツトウオース」ねぢ「ボルト」ヲ以テ之ニ代フルコトヲ得。

第一號 普通壓管
第二表 兩鈔管及片鈔管

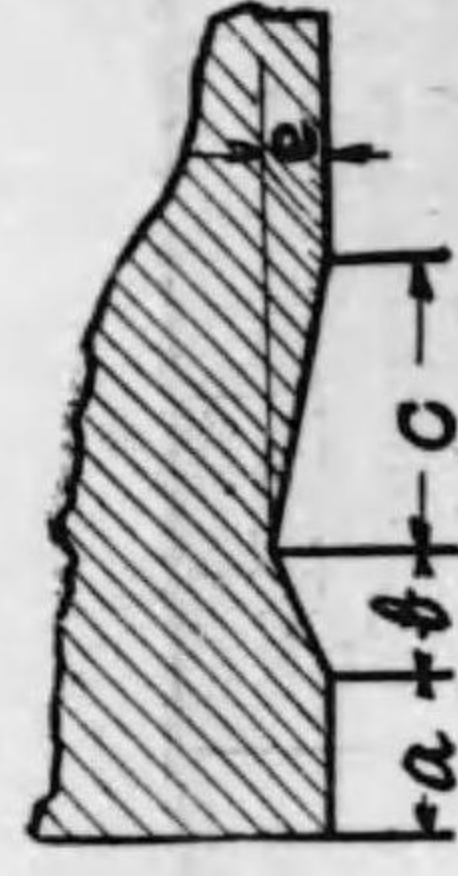


兩鈔管及片鈔管

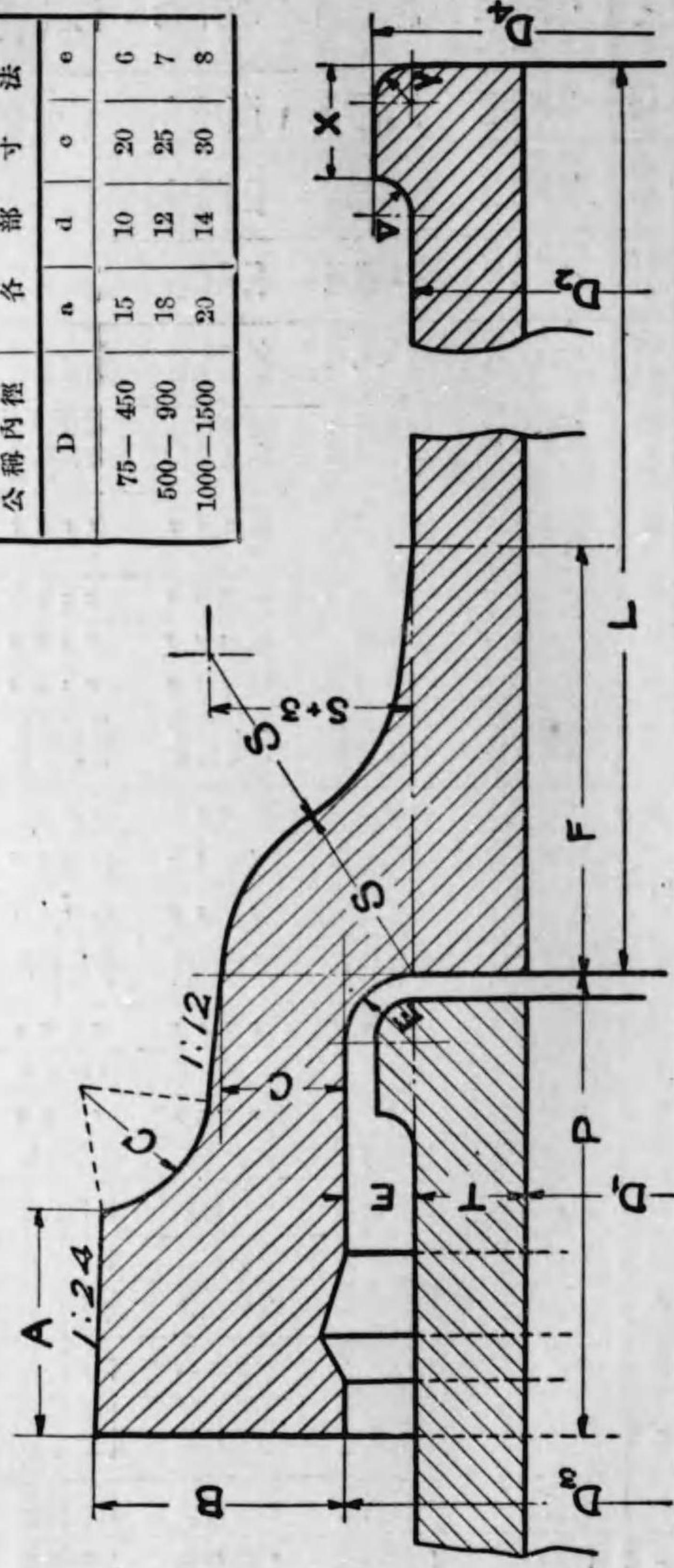
公稱 內徑 D	管厚實外徑		鈔 寸 法										ボ ル ト		挿 口 寸 法				重			量 米		公稱 內徑 D		
	T	D ₂	D ₃	G	M	a	L ₂	中 心 間 D ₁	徑 d	孔 d'	數	D _b	V	X	Y	L	鈔 部	挿 口 突 部	直 部 I m	兩鈔管	片鈔管					
75	10.2	95.4	68	211	21	125	25	3	5	100	168	16	18	4	105.4	5	15	4	3070	4.82	.174	19.7	68.6	64.0	75	
100	10.7	121.4	69	238	22	152	26	"	"	"	195	"	"	"	131.4	"	"	"	"	"	6.03	.220	26.8	92.4	86.6	100
125	11.3	147.6	"	263	"	177	"	"	"	"	230	"	"	"	157.6	"	"	"	"	"	6.81	.265	34.8	118	112	125
150	11.8	173.6	70	290	23	204	27	"	"	"	247	"	"	"	183.6	"	"	"	"	"	8.13	.310	43.1	146	138	150
200	12.9	225.8	71	342	24	256	28	"	"	"	229	"	"	8	235.8	"	"	"	"	"	10.4	.401	62.1	207	197	200
250	14.0	278.0	80	410	26	308	29	"	"	"	300	18	21	10	288.0	"	20	"	"	"	15.0	.652	83.6	281	266	250
300	15.1	330.2	82	464	27	362	31	4	6	120	414	"	24	"	340.2	"	"	"	"	"	19.1	.773	108	361	343	300
350	16.2	382.4	90	530	28	414	32	"	"	"	472	22	24	"	392.4	"	"	"	"	"	24.5	.893	134	452	423	350
400	17.3	434.6	91	582	30	466	33	"	"	"	524	"	"	12	446.6	6	25	5	4000	28.9	1.54	163	710	684	400	
450	18.4	486.8	101	652	31	518	34	"	"	"	585	24	27	"	498.8	"	"	"	"	"	36.6	1.72	195	853	818	450
500	19.5	539.0	103	706	32	572	36	"	"	"	639	"	"	"	551.0	"	"	"	"	"	41.8	1.88	229	1000	960	500
600	21.7	643.4	105	810	35	676	38	"	"	"	743	"	"	16	655.4	"	"	"	"	"	52.4	2.24	305	1330	1280	600
700	23.9	747.8	114	928	38	780	40	"	"	"	854	27	30	"	759.8	"	"	"	"	"	69.7	2.60	391	1700	1640	700
800	26.1	852.2	117	1034	41	886	43	5	7	140	966	"	"	"	864.2	"	"	"	"	"	87.3	2.96	488	2130	2040	800
900	28.3	956.6	128	1156	44	990	45	"	"	"	1073	33	35	"	968.6	"	"	"	"	"	113	3.32	594	2600	2490	900
1000	30.5	1061.0	131	1262	46	1096	48	"	"	"	1179	"	"	24	1073.0	"	"	6	"	"	129	3.62	711	3100	2980	1000
1100	32.7	1165.4	138	1366	49	1200	50	"	"	"	1283	"	"	"	1177.4	"	"	"	"	"	149	3.97	838	3650	3500	1100
1200	34.9	1269.8	135	1470	52	1304	52	"	"	"	1387	"	"	28	1281.8	"	"	"	"	"	170	4.33	975	4240	4080	1200
1350	38.2	1426.4	146	1642	56	1462	56	6	8	160	1552	36	38	"	1438.4	"	"	"	"	"	223	4.86	1200	5250	5030	1350
1500	41.5	1583.0	150	1800	60	1620	60	"	"	"	1710	"	"	32	1595.0	"	"	"	"	"	263	5.39	1450	6310	6060	1500

※ 重量欄中各欄ノ數值彼此加減シテ符合セサルモノアルハ四捨五入ノ結果ナリ

第二號 低壓管
第一表 直管



公稱內徑	各 部 寸 法		
D	a	d	e
75-450	15	10	20
500-900	18	12	25
1000-1500	23	14	30



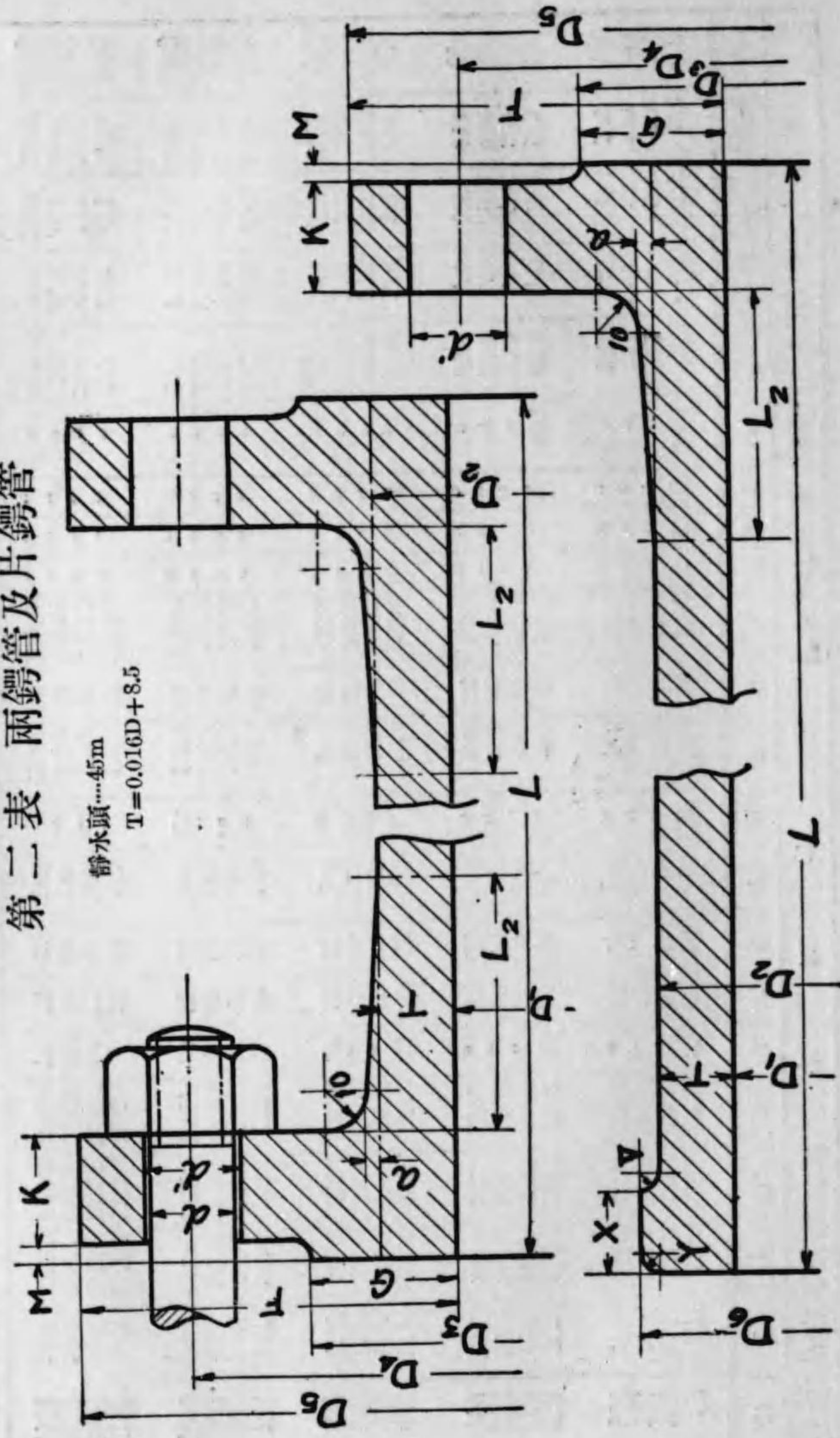
靜水頭.....45mT=0.016D+S.5

直管

公稱內徑 D	管厚 T	實內徑			承口			寸法			插口寸法			重 量			公稱內徑 D			
		D ₁	D ₂	D ₃	A	B	C	P	E	F	S	D ₄	V	X	Y	L		承口突部	插口突部	直部
75	9.7	76.0	95.4	115.4	35	30	15	90	10	71.4	25	105.4	5	15	4	3000	7.71	.174	18.8	64.3
100	10.1	101.2	121.4	141.4	"	31	16	95	"	73.1	26	131.4	"	"	"	"	10.1	.200	25.4	86.6
125	10.5	126.6	147.6	167.6	"	32	"	"	"	"	"	157.6	"	"	"	"	12.0	.265	32.6	110
150	10.9	151.8	173.6	193.6	"	34	17	100	"	74.9	27	183.6	"	"	"	"	15.3	.310	40.1	136
200	11.7	202.4	225.8	245.8	40	36	18	105	11	76.7	28	235.8	"	"	"	4000	20.6	.401	56.7	248
250	12.5	253.0	278.0	300.0	"	38	19	110	"	80.1	30	288.0	"	20	"	"	28.0	.652	75.1	329
300	13.3	303.6	330.2	352.2	"	40	20	"	"	81.8	31	340.2	"	"	"	"	33.6	.773	95.3	416
350	14.1	354.2	382.4	404.4	"	42	21	"	"	83.6	32	392.4	"	"	"	"	41.6	.898	117	512
400	14.9	404.8	434.6	456.6	45	45	23	115	"	87.0	34	446.6	6	25	5	"	52.5	1.54	141	620
450	15.7	455.4	486.8	508.8	"	47	24	"	"	88.8	35	498.8	"	"	"	"	63.0	1.72	167	734
500	16.5	506.0	539.0	563.0	"	49	25	120	12	92.2	37	551.0	"	"	"	"	75.3	1.88	195	857
600	18.1	607.2	643.4	667.4	50	53	27	130	"	95.7	39	655.4	"	"	"	"	97.2	2.24	256	1120
700	19.7	708.4	747.8	771.8	"	58	29	125	"	99.2	41	759.8	"	"	"	"	125	2.60	324	1430
800	21.3	809.6	852.2	876.2	55	62	31	130	"	102.6	43	864.2	"	"	"	"	160	2.96	400	1760
900	22.9	910.8	956.6	980.6	"	67	34	135	"	107.8	46	968.6	"	"	"	"	202	3.32	484	2140
1000	24.5	1012.0	1061.0	1087.0	60	71	36	140	13	113.0	49	1073.0	"	"	6	"	244	3.62	574	2550
1100	26.1	1113.2	1165.4	1191.4	"	74	38	145	"	116.6	51	1177.4	"	"	"	"	290	3.97	671	2980
1200	27.7	1214.4	1269.8	1295.8	65	77	40	150	"	120.0	53	1281.8	"	"	"	"	344	4.33	778	3460
1350	30.1	1366.2	1426.4	1452.4	70	80	42	160	"	125.2	56	1438.4	"	"	"	"	434	4.86	951	4240
1500	32.5	1518.0	1583.0	1609.0	75	83	47	165	"	132.0	60	1595.0	"	"	"	"	518	5.39	1140	5080

※ 重量欄中各欄ノ數値概此加減シテ符合セサルモノアルハ四捨五入ノ結果ナリ

第二號 低壓管
第二表 兩銑管及片銑管

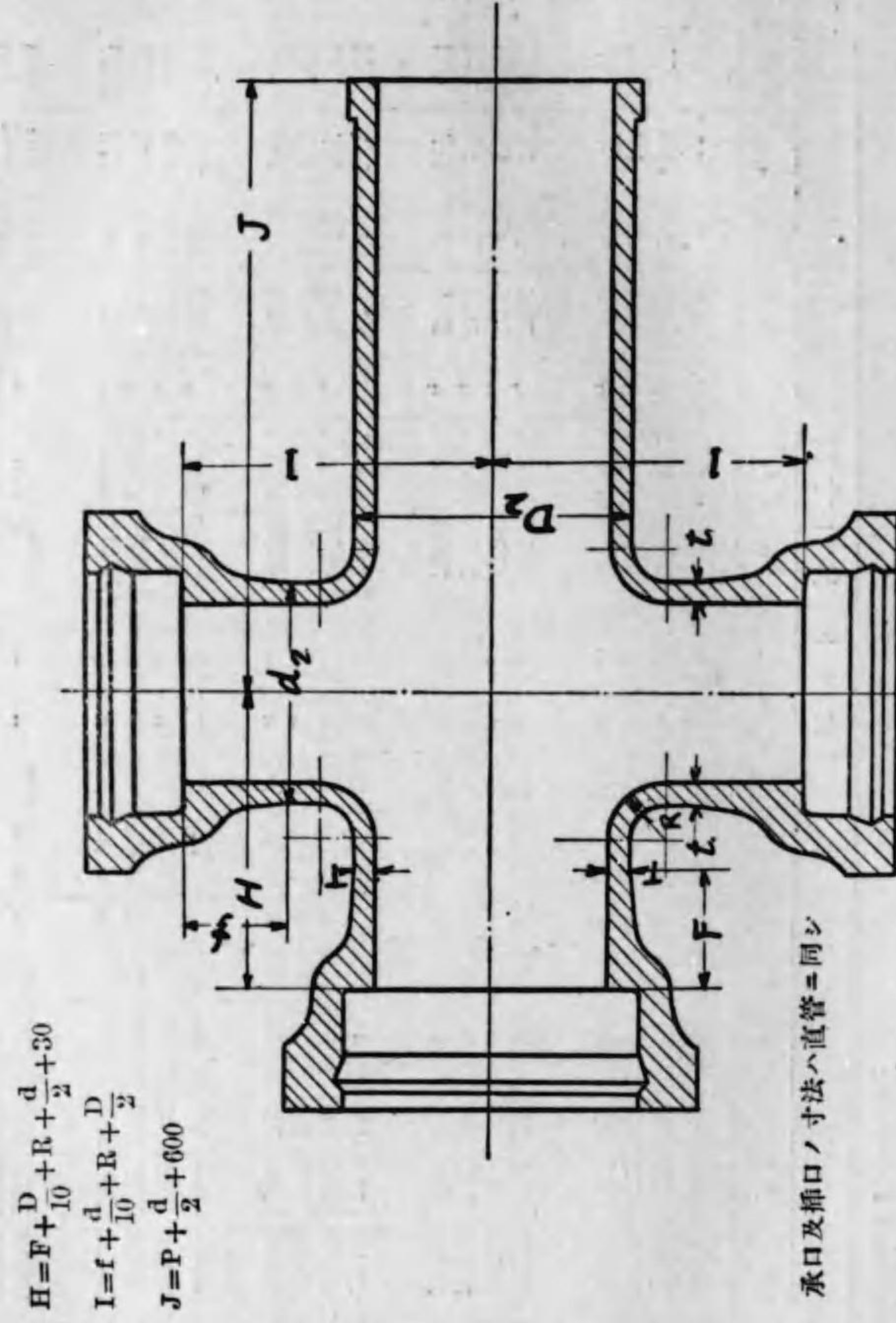


兩銑管及片銑管

公稱 內徑 D	管厚			實內徑			實外徑			銑		寸		法		ボルト		挿口		寸法		有效 長		重		量		公稱 內徑 D
	T	D ₁	D ₂	F	D ₃	D ₄	M	a	L ₁	中心距 D ₄	孔數 d	孔徑 d'	D ₆	V	X	Y	L	挿口 突部	銑部	直 徑	挿口 突部	銑部	直 徑	銑部	片銑管	片銑管		
75	9.7	76.0	95.4	67.5	211.21	211.21	125	24.5	3	5	106	168	16	18	4	105.4	5	15	4	3000	4.82	174	18.8	66.1	61.4	75		
100	10.1	101.2	121.4	68.4	238.22	238.22	152	25.4	"	"	195	"	"	"	6	131.4	"	"	"	"	6.03	220	25.4	88.3	82.5	100		
125	10.5	126.6	147.6	68.2	263	263	177	25.2	"	"	230	"	"	"	"	157.6	"	"	"	"	6.81	265	32.6	111	105	125		
150	10.9	151.8	175.6	69.1	290.23	290.23	204	26.1	"	"	247	"	"	"	"	183.6	"	"	"	"	8.15	310	40.1	137	129	150		
200	11.7	202.4	225.8	69.8	342.24	342.24	256	26.8	"	"	299	"	"	"	8	235.8	"	"	"	"	10.4	401	56.7	191	181	200		
250	12.5	253.0	278.0	78.5	410.26	410.26	308	27.5	"	"	360	18	"	"	10	288.0	"	30	"	"	15.0	452	75.1	255	241	250		
300	13.3	303.6	330.2	80.2	464.27	464.27	362	29.2	4	6	414	"	"	"	10	340.2	"	"	"	"	19.1	524	95.3	324	306	300		
350	14.1	354.2	382.4	87.9	530.28	530.28	414	29.5	"	"	472	22	"	"	21	392.4	"	"	"	"	24.5	593	117	402	377	350		
400	14.9	404.8	434.6	88.6	582.30	582.30	466	30.6	"	"	524	"	"	"	12	446.6	6	25	5	4000	28.9	654	141	596	596	400		
450	15.7	455.4	484.8	98.3	652.31	652.31	518	31.3	"	"	585	24	"	"	27	498.8	"	"	"	"	36.6	742	167	742	708	450		
500	16.5	506.0	539.0	100.0	706.32	706.32	572	33.0	"	"	639	"	"	"	"	551.0	"	"	"	"	41.8	824	195	864	824	500		
600	18.1	607.2	643.4	101.4	810.35	810.35	676	34.4	"	"	743	"	"	"	16	655.4	"	"	"	"	52.4	1080	256	1130	1080	600		
700	19.7	708.4	747.8	109.8	928.38	928.38	780	35.8	"	"	854	27	"	"	30	759.8	"	"	"	"	69.7	1370	324	1440	1370	700		
800	21.3	809.6	852.2	112.2	1034.41	1034.41	886	38.2	5	7	960	"	"	"	20	864.2	"	"	"	"	87.3	1690	400	1780	1690	800		
900	22.9	910.8	956.6	122.6	1156.44	1156.44	990	39.6	"	"	1073	33	"	"	35	968.6	"	"	"	"	113	2050	484	2110	2050	900		
1000	24.5	1012.0	1061.0	125.0	1262.46	1262.46	1096	42.0	"	"	1179	"	"	"	24	1073.0	"	"	"	"	129	2430	574	2520	2430	1000		
1100	26.1	1113.2	1165.4	126.4	1366.49	1366.49	1200	43.4	"	"	1283	"	"	"	"	1177.4	"	"	"	"	149	2840	671	2990	2840	1100		
1200	27.7	1214.4	1269.8	127.8	1470.52	1470.52	1304	44.8	"	"	1387	"	"	"	28	1281.8	"	"	"	"	170	3450	778	3450	3290	1200		
1350	30.1	1366.2	1426.4	137.9	1642.56	1642.56	1462	47.9	6	8	1552	36	"	"	38	1483.4	"	"	"	"	233	4250	951	4250	4030	1350		
1500	32.5	1518.0	1583.0	141.0	1800.60	1800.60	1620	51.0	"	"	1710	"	"	"	32	1595.0	"	"	"	"	263	5090	1140	5090	4830	1500		

※重量欄中各欄ノ數値彼此加減シテ符合セサルモノアルハ四捨五入ノ結果ナリ

第三號 十字管
第一表 三承十字管



三承十字管

公稱內徑 D	管厚 d	管厚		實外徑		R	管長			重量
		T	t	D ₂	d ₂		H	I	J	
75	75	11.2	11.2	95.4	95.4	50	200	170	730	47.8
100	100	11.8	11.8	121.4	12.4	"	210	180	750	57.6
"	"	"	"	"	"	"	"	"	"	64.8
125	75	12.4	12.4	147.6	95.4	"	"	190	730	68.0
"	100	"	"	"	121.4	"	220	200	750	75.9
"	125	"	"	"	147.6	"	230	"	760	82.0
150	75	13.0	13.0	173.6	95.4	"	210	"	740	80.6
"	100	"	"	"	121.4	"	220	210	750	88.3
"	125	"	"	"	147.6	"	230	"	760	94.5
"	150	"	"	"	173.6	"	250	220	780	104.0
200	100	14.2	14.2	225.8	121.4	"	230	230	750	114
"	125	"	"	"	147.6	"	240	240	760	122
"	150	"	"	"	173.6	60	260	250	780	134
"	200	"	"	"	225.8	"	290	260	800	152
250	100	15.4	15.4	278.0	121.4	50	240	"	760	147
"	125	"	"	"	147.6	60	260	270	770	156
"	150	"	"	"	173.6	"	270	280	780	167
"	200	"	"	"	225.8	"	300	"	810	187
"	250	"	"	"	278.0	"	320	290	830	211
300	100	16.6	16.0	330.2	121.4	50	240	230	760	179
"	125	"	"	"	147.6	60	260	300	770	190
"	150	"	16.6	"	173.6	"	280	"	780	202
"	200	"	"	"	225.8	"	300	310	810	223
"	250	"	"	"	278.0	70	340	330	830	253
"	300	"	"	"	330.2	"	360	"	860	274
350	100	17.8	16.0	382.4	121.4	60	260	320	760	220
"	125	"	"	"	147.6	"	270	"	770	228
"	150	"	17.0	"	173.6	"	280	330	790	242
"	200	"	17.8	"	225.8	60	310	"	810	265
"	250	"	"	"	278.0	70	340	350	840	295
"	300	"	"	"	330.2	"	370	360	860	320
"	350	"	"	"	382.4	"	390	"	890	349
400	100	19.0	16.0	434.6	121.4	60	270	340	760	265
"	125	"	"	"	147.6	"	280	350	770	275
"	150	"	17.0	"	173.6	"	300	"	790	290
"	200	"	18.0	"	225.8	70	330	370	810	321
"	250	"	19.0	"	278.0	"	350	380	840	348
"	300	"	"	"	330.2	80	390	390	860	373
"	350	"	"	"	382.4	"	410	400	890	409
"	400	"	"	"	434.6	90	450	420	910	454

三承十字管

公稱內徑		管 厚		實 外 徑		R	管 長			重 量
D	d	T	t	D ₂	d ₂		H	I	J	
450	100	20.2	16.0	486.8	121.4	60	270	370	770	314
	125	"	"	"	147.6	"	290	"	780	325
	150	"	17.0	"	173.6	70	310	390	790	342
	200	"	18.0	"	225.8	"	330	"	820	367
	250	"	19.0	"	278.0	80	370	410	840	403
	300	"	20.0	"	330.2	"	390	420	870	434
	350	"	20.2	"	382.4	"	420	"	890	465
	400	"	"	"	434.6	90	450	440	920	512
	450	"	"	"	486.8	"	480	450	940	554
	500	100	21.5	16.0	539.0	121.4	60	280	390	770
125		"	"	"	147.6	"	300	400	780	379
150		"	17.0	"	173.6	70	320	410	790	396
200		"	18.0	"	225.8	"	340	420	820	424
250		"	19.0	"	278.0	80	380	440	840	462
300		"	20.0	"	330.2	"	400	"	870	491
350		"	21.0	"	382.4	"	430	450	890	529
400		"	21.5	"	434.6	90	460	470	920	581
450		"	"	"	486.8	"	490	"	940	629
500		"	"	"	539.0	100	520	490	970	670
600	150	23.9	17.0	643.4	173.6	80	340	470	800	517
	200	"	18.0	"	225.8	"	370	480	820	548
	250	"	19.0	"	278.0	"	390	490	850	585
	300	"	20.0	"	330.2	90	430	500	870	623
	350	"	21.0	"	382.4	"	450	510	900	663
	400	"	23.0	"	434.6	"	480	520	920	716
	450	"	23.9	"	486.8	100	510	530	950	771
	500	"	"	"	539.0	"	540	540	970	819
	600	"	"	"	643.4	110	600	570	1020	934
	700	150	26.3	17.0	747.8	173.6	80	350	520	800
200		"	18.0	"	225.8	"	380	530	830	691
250		"	19.0	"	278.0	90	410	550	850	745
300		"	20.0	"	330.2	"	440	"	880	785
350		"	21.0	"	382.4	"	460	560	900	825
400		"	23.0	"	434.6	100	500	580	930	894
450		"	24.0	"	486.8	"	520	"	950	939
500		"	25.0	"	539.0	"	550	600	980	1000
600		"	26.3	"	643.4	110	610	620	1030	1130
700		"	"	"	747.8	"	660	630	1080	1250

三承十字管

公稱內徑		厚 管		實 外 徑		R	管 長			重 量
D	d	T	t	D ₂	d ₂		H	I	J	
800	150	28.7	17.0	852.2	173.6	80	370	570	810	833
	200	"	18.0	"	225.8	"	390	580	830	868
	250	"	19.0	"	278.0	90	430	600	860	926
	300	"	20.0	"	330.2	"	450	"	880	960
	350	"	21.0	"	382.4	"	480	610	910	1010
	400	"	23.0	"	434.6	100	510	630	930	1080
	450	"	24.0	"	486.8	"	540	"	960	1140
	500	"	25.0	"	539.0	110	570	650	980	1200
	600	"	27.0	"	643.4	"	620	670	1030	1330
	700	"	28.7	"	747.8	120	680	690	1080	1500
800	"	"	"	852.2	"	730	700	1130	1650	
500	200	31.1	18.0	956.6	225.8	90	420	640	840	1080
	250	"	19.0	"	278.0	"	440	650	860	1120
	300	"	20.0	"	330.2	"	470	"	890	1170
	350	"	21.0	"	382.4	100	500	670	910	1230
	400	"	23.0	"	434.6	"	530	680	940	1300
	450	"	24.0	"	486.8	110	560	690	960	1360
	500	"	25.0	"	539.0	"	590	700	990	1430
	600	"	27.0	"	643.4	120	650	730	1040	1580
	700	"	29.0	"	747.8	"	700	740	1090	1740
	800	"	31.1	"	852.2	130	760	760	1140	1940
900	"	"	"	956.6	"	810	780	1190	2140	
1000	300	33.6	20.0	1061.0	330.2	100	500	710	890	1420
	350	"	21.0	"	382.4	"	520	720	920	1470
	400	"	23.0	"	434.6	110	550	740	940	1550
	450	"	24.0	"	486.8	"	580	"	970	1620
	500	"	25.0	"	539.0	120	610	760	990	1690
	600	"	27.0	"	643.4	"	660	780	1040	1840
	700	"	29.0	"	747.8	130	720	800	1090	2020
	800	"	31.0	"	852.2	"	770	810	1140	2200
	900	"	33.6	"	956.6	140	830	840	1190	2470
	1000	"	"	"	1061.0	"	880	850	1240	2670
1100	400	36.0	23.0	1165.4	434.6	110	570	790	950	1820
	450	"	24.0	"	486.8	"	600	"	970	1880
	500	"	25.0	"	539.0	120	630	810	1000	1970
	600	"	27.0	"	643.4	"	680	830	1050	2120
	700	"	29.0	"	747.8	130	740	850	1100	2310
	800	"	31.0	"	852.2	"	790	860	1150	2510
	900	"	34.0	"	956.6	140	850	890	1200	2790
	1000	"	36.0	"	1061.0	"	900	900	1250	3020
	1100	"	"	"	1065.4	150	960	930	1300	3290
	1200	400	38.4	23.0	1269.8	434.6	110	580	840	950
450		"	24.0	"	486.8	120	610	850	970	2190
500		"	25.0	"	539.0	"	640	860	1000	2270

三承十字管

公稱内徑 D	管厚 a	管厚 T	管厚 t	實外徑		R	管長			重量
				D ₂	d ₂		H	I	J	
1200	600	38.4	27.0	1269.8	643.4	130	700	890	1050	2460
"	700	"	29.0	"	747.8	"	750	900	1100	2640
"	800	"	31.0	"	852.2	140	810	920	1150	2860
"	900	"	34.0	"	958.6	"	860	940	1200	3120
"	1000	"	36.0	"	1061.0	150	920	960	1250	3400
"	1100	"	38.4	"	1165.4	"	970	980	1300	3700
"	1200	"	"	"	1269.8	"	1020	990	1350	4020

第三號 十字管
第二表 三銜十字管

$$B = L_2 + M + K + \frac{D}{10} + R + \frac{d}{2} + 30$$

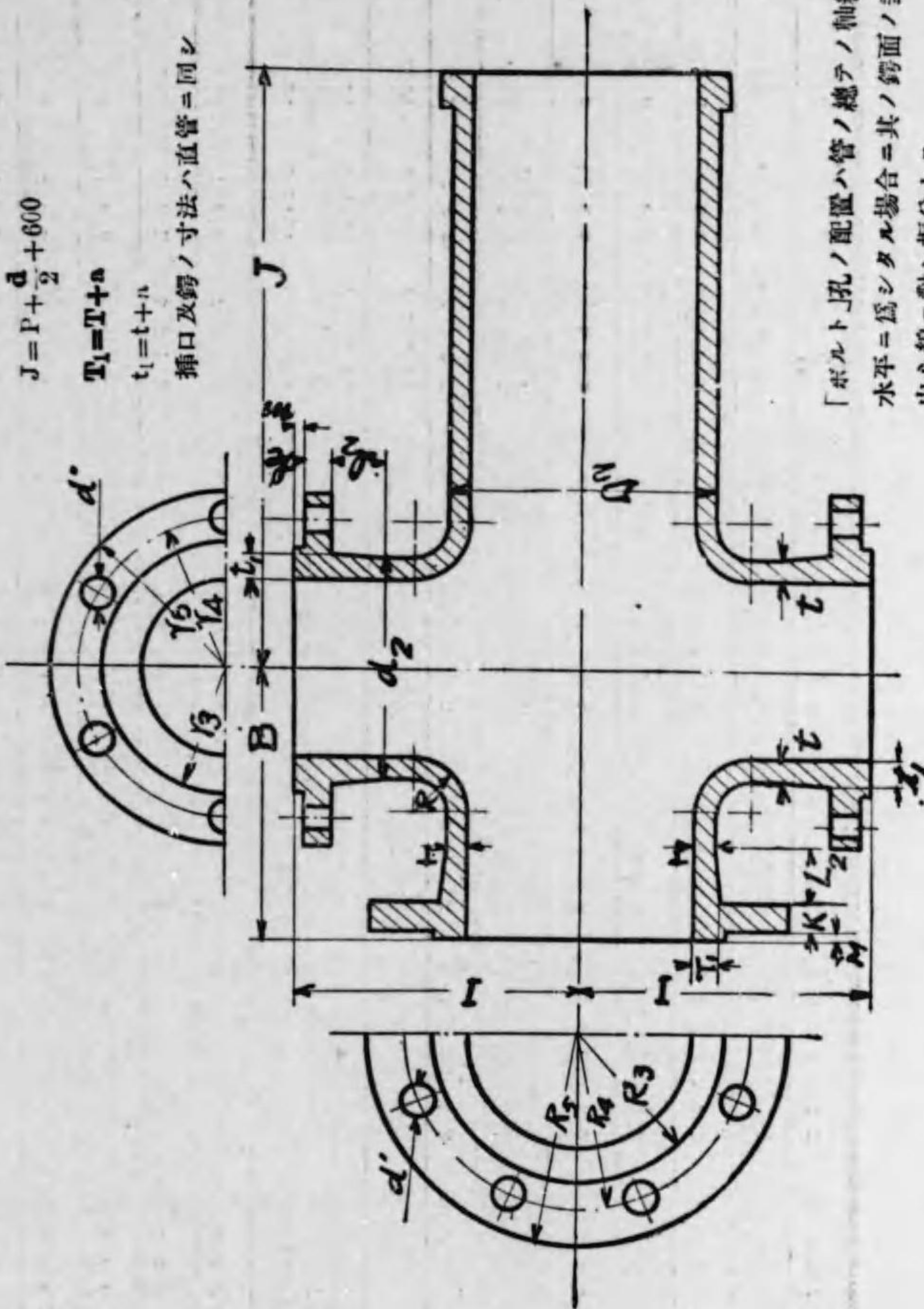
$$I = L_1 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$J = P + \frac{d}{2} + 600$$

$$T_1 = T + a$$

$$t_1 = t + a$$

挿口及銜ノ寸法ハ直管ニ同シ



「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ
水平ニ爲シタル場合ニ其ノ銜面ノ垂直
中心線ニ對シ振分トス

三 鈔 十 字 管

公稱內徑		管 厚		實 外 徑		R	管 長					本			
D	d	T	t	D ₂	d ₂		B	I	J	L ₁	L ₂	T ₁	K	M	R ₅
75	75	11.2	11.2	95.4	95.4	50	249	219	730	100	100	16.2	21	3	105.5
100	100	11.8	11.8	121.4	121.4	"	252	231	"	"	"	16.8	22	"	119.0
"	100	"	"	"	121.4	"	265	235	750	"	"	"	"	"	"
125	75	12.4	12.4	147.6	95.4	"	255	244	730	"	"	17.4	"	"	131.5
"	100	"	"	"	121.4	"	267	247	750	"	"	"	"	"	"
"	125	"	"	"	147.6	"	280	250	760	"	"	"	"	"	"
150	75	13.0	13.0	173.6	95.4	"	253	256	740	"	"	18.0	23	"	145.0
"	100	"	"	"	121.4	"	271	260	750	"	"	"	"	"	"
"	125	"	"	"	147.6	"	284	262	760	"	"	"	"	"	"
"	150	"	"	"	173.6	"	296	266	780	"	"	"	"	"	"
200	100	14.2	14.2	225.8	121.4	"	277	285	750	"	"	19.2	24	"	171.0
"	125	"	"	"	147.6	"	289	287	760	"	"	"	"	"	"
"	150	"	"	"	173.6	60	312	301	780	"	"	"	"	"	"
"	200	"	"	"	225.8	"	337	307	800	"	"	"	"	"	"
250	100	15.4	15.4	278.0	121.4	50	284	310	760	"	"	20.4	26	"	205.0
"	125	"	"	"	147.6	60	306	322	770	"	"	"	"	"	"
"	150	"	"	"	173.6	"	319	326	780	"	"	"	"	"	"
"	200	"	"	"	225.8	"	344	332	810	"	"	"	"	"	"
"	250	"	"	"	278.0	"	369	339	830	"	"	"	"	"	"
300	100	16.6	16.0	330.2	121.4	50	311	335	760	120	"	22.6	27	4	232.0
"	125	"	"	"	147.6	60	333	347	770	"	"	"	"	"	"
"	150	"	16.6	"	173.6	"	346	351	780	"	"	"	"	"	"
"	200	"	"	"	225.8	"	371	357	810	"	"	"	"	"	"
"	250	"	"	"	278.0	70	406	374	830	"	"	"	"	"	"
"	300	"	"	"	330.2	"	431	401	860	"	120	"	"	"	"
350	100	17.8	16.0	382.4	121.4	60	327	370	760	"	100	23.8	28	"	265.0
"	125	"	"	"	147.6	"	339	372	770	"	"	"	"	"	"
"	150	"	17.0	"	173.6	"	352	376	790	"	"	"	"	"	"
"	200	"	17.8	"	225.8	"	377	382	810	"	"	"	"	"	"
"	250	"	"	"	278.0	70	412	399	840	"	"	"	"	"	"
"	300	"	"	"	330.2	"	437	426	860	"	120	"	"	"	"
"	350	"	"	"	382.4	"	462	432	890	"	"	"	"	"	"
400	100	19.0	16.0	434.6	121.4	60	334	395	760	"	100	25.0	30	"	291.0
"	125	"	"	"	147.6	"	346	397	770	"	"	"	"	"	"
"	150	"	17.0	"	173.6	"	359	401	790	"	"	"	"	"	"
"	200	"	18.0	"	225.8	70	394	417	810	"	"	"	"	"	"
"	250	"	19.0	"	278.0	"	419	424	840	"	"	"	"	"	"
"	300	"	"	"	330.2	80	454	461	860	"	120	"	"	"	"
"	350	"	"	"	382.4	"	479	467	890	"	"	"	"	"	"
"	400	"	"	"	434.6	90	514	487	910	"	"	"	"	"	"

管 鈔		枝		管		鈔		重量	公稱內徑					
R ₄	R ₃	$\frac{R_4+R_3}{d}$ 數	t ₁	k	m	r ₅	r ₄		r ₃	$\frac{R_4+R_3}{d}$ 數	D	d		
84.0	62.5	18	4	16.2	21	3	105.5	84.0	62.5	18	4	42.3	75	75
97.5	76.0	"	"	16.8	"	"	"	"	"	"	"	51.5	100	"
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	57.3	"	100
110.0	88.5	"	6	17.4	"	"	105.5	84.0	62.5	"	"	61.2	125	75
"	"	"	"	"	"	"	119.0	97.5	76.0	"	"	67.1	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	72.0	"	125
123.5	102.0	"	"	18.0	21	"	105.5	84.5	62.5	"	4	72.3	150	75
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	78.0	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	82.6	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	87.8	"	150
149.5	128.0	"	8	19.2	22	"	119.0	97.5	76.0	"	4	103	200	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	108	"	125
"	"	"	"	"	"	"	145.0	123.5	102.0	"	"	117	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	130	"	200
180.0	154.0	21	"	20.4	22	"	119.0	97.5	76.0	"	4	134	250	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	142	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	150	"	150
"	"	"	"	"	"	"	171.0	149.5	128.0	"	8	165	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	185	"	250
207.0	181.0	"	10	21.0	22	"	119.0	97.5	76.0	18	4	169	300	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	177	"	125
"	"	"	"	21.6	23	"	145.0	123.5	102.0	"	"	187	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	204	"	200
"	"	"	"	"	"	"	205.0	180.0	154.0	21	"	229	"	250
"	"	"	"	22.6	27	4	232.0	207.0	181.0	"	10	255	"	300
236.0	207.0	24	"	21.0	22	3	119.0	97.5	76.0	18	4	208	350	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	216	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	227	"	150
"	"	"	"	22.8	24	"	171.0	149.5	128.0	"	8	245	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	273	"	250
"	"	"	"	23.8	27	4	232.0	207.0	181.0	"	10	301	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	329	"	350
262.0	233.0	"	12	21.0	22	3	119.0	97.5	76.0	18	4	249	400	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	253	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	269	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	292	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	320	"	250
"	"	"	"	25.0	27	4	232.0	207.0	181.0	"	10	352	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	381	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	415	"	400

三 鈔 十 字 管

公稱內徑	管 厚	實 外 徑	管 長											本			
			R	B	I	J	L ₂	L ₁	T ₁	K	M	R ₅					
D	d	T	t	D ₂	d ₂												
450	100	20.2	16.0	486.8	121.4	60	340	420	770	120	100	26.2	31	4	326.0		
"	125	"	"	"	147.6	"	352	422	780	"	"	"	"	"	"		
"	150	"	17.0	"	173.6	70	375	436	790	"	"	"	"	"	"		
"	200	"	18.0	"	225.8	"	400	442	820	"	"	"	"	"	"		
"	250	"	19.0	"	278.0	80	435	459	840	"	"	"	"	"	"		
"	300	"	20.0	"	330.2	"	460	486	870	"	120	"	"	"	"		
"	350	"	20.2	"	382.4	"	485	492	890	"	"	"	"	"	"		
"	400	"	"	"	434.6	90	520	509	920	"	"	"	"	"	"		
"	450	"	"	"	486.8	"	545	515	940	"	"	"	"	"	"		
500	100	21.5	16.0	539.0	121.4	60	346	445	770	"	100	27.5	32	"	353.0		
"	125	"	"	"	147.6	"	358	447	780	"	"	"	"	"	"		
"	150	"	17.0	"	173.6	70	381	461	790	"	"	"	"	"	"		
"	200	"	18.0	"	225.8	"	406	467	820	"	"	"	"	"	"		
"	250	"	19.0	"	278.0	80	441	484	840	"	"	"	"	"	"		
"	300	"	20.0	"	330.2	"	466	511	870	"	120	"	"	"	"		
"	350	"	21.0	"	382.4	"	491	517	890	"	"	"	"	"	"		
"	400	"	21.5	"	434.6	90	526	534	920	"	"	"	"	"	"		
"	450	"	"	"	486.8	"	551	540	940	"	"	"	"	"	"		
"	500	"	"	"	539.0	100	561	556	970	"	"	"	"	"	"		
600	150	23.9	17.0	643.4	173.6	80	404	521	800	"	100	29.9	35	"	405.0		
"	200	"	18.0	"	225.8	"	429	527	820	"	"	"	"	"	"		
"	250	"	19.0	"	278.0	"	454	534	850	"	"	"	"	"	"		
"	300	"	20.0	"	330.2	90	489	571	870	"	120	"	"	"	"		
"	350	"	21.0	"	382.4	"	514	577	900	"	"	"	"	"	"		
"	400	"	23.0	"	434.6	"	539	584	920	"	"	"	"	"	"		
"	450	"	23.9	"	486.8	100	574	600	950	"	"	"	"	"	"		
"	500	"	"	"	539.0	"	599	606	970	"	"	"	"	"	"		
"	600	"	"	"	643.4	110	659	629	1020	"	"	"	"	"	"		
700	150	26.3	17.0	747.8	173.6	80	420	570	800	"	100	32.3	38	"	464.0		
"	200	"	18.0	"	225.8	"	442	577	830	"	"	"	"	"	"		
"	250	"	19.0	"	278.0	90	477	594	850	"	"	"	"	"	"		
"	300	"	20.0	"	330.2	"	502	621	880	"	120	"	"	"	"		
"	350	"	21.0	"	382.4	"	527	627	900	"	"	"	"	"	"		
"	400	"	23.0	"	434.6	100	562	634	930	"	"	"	"	"	"		
"	450	"	24.0	"	486.8	"	587	650	950	"	"	"	"	"	"		
"	500	"	25.0	"	539.0	"	612	656	980	"	"	"	"	"	"		
"	600	"	26.3	"	643.4	110	672	679	1030	"	"	"	"	"	"		
"	700	"	"	"	747.8	"	722	692	1080	"	"	"	"	"	"		
800	150	28.7	17.0	852.2	173.6	80	451	621	810	140	100	35.7	41	5	517.0		
"	200	"	18.0	"	225.8	"	476	627	830	"	"	"	"	"	"		
"	250	"	19.0	"	278.0	90	511	644	860	"	"	"	"	"	"		
"	300	"	20.0	"	330.2	"	536	651	880	"	120	"	"	"	"		
"	350	"	21.0	"	382.4	"	566	677	910	"	"	"	"	"	"		
"	400	"	23.0	"	434.6	100	596	694	930	"	"	"	"	"	"		

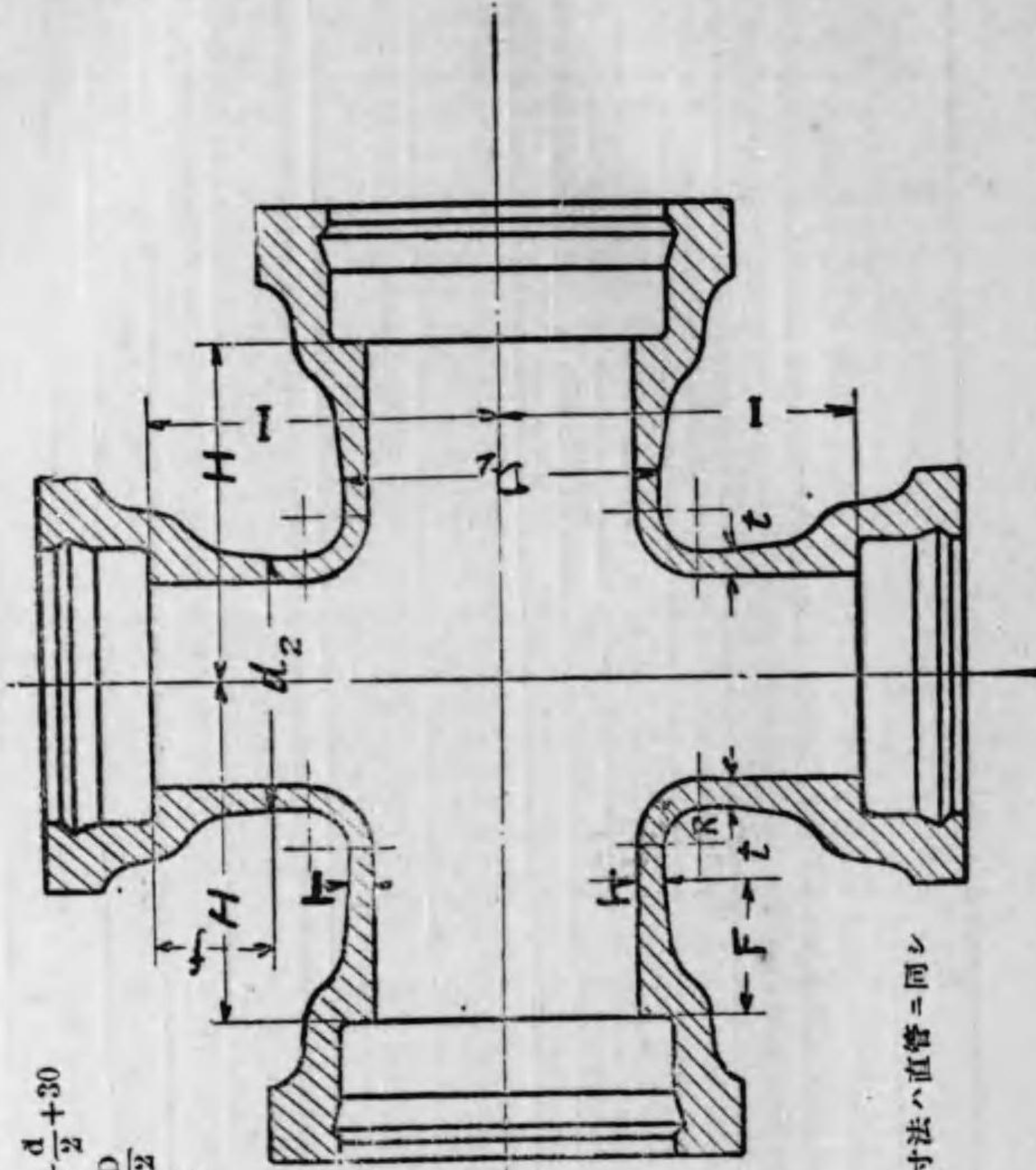
管 鈔		枝		管			鈔		重量	公稱內徑				
R ₄	R ₃	ボルト孔 d' 數	t ₁	k	m	r ₅	r ₄	r ₃		ボルト孔 d'' 數	D	d		
292.5	259.0	27	12	21.0	22	3	119.0	97.5	76.0	18	4	298	450	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	306	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	320	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	344	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	"	21	376	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	412	"	300
"	"	"	"	26.2	28	"	265.0	236.0	207.0	"	24	442	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	479	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	"	27	516	"	450
319.5	286.0	"	"	21.0	22	3	119.0	97.5	76.0	18	4	347	500	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	356	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	372	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	397	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	"	21	430	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	467	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	"	24	503	"	350
"	"	"	"	27.5	30	"	291.0	262.0	233.0	"	12	545	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	"	27	583	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	621	"	500
371.5	338.0	"	16	22.0	23	3	145.0	123.5	102.0	18	6	485	600	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	508	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	"	21	545	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	588	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	"	24	629	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	671	"	400
"	"	"	"	29.9	31	"	326.0	292.5	259.0	"	27	729	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	768	"	500
"	"	"	"	"	35	"	405.0	371.5	338.0	"	16	855	"	600
427.0	390	30.0	"	22.0	23	3	145.0	123.5	102.0	18	6	628	700	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	660	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	"	21	702	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	747	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	"	24	787	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	841	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	"	27	895	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	946	"	500
"	"	"	"	32.3	35	"	405.0	371.5	338.0	"	16	1060	"	600
"	"	"	"	"	38	"	464.0	427.0	390.0	"	30	1160	"	700
480.0	443	"	20	22.0	23	3	145.0	123.5	102.0	18	6	800	800	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	833	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	"	21	885	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	924	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	"	24	981	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1040	"	400

三 鈎 十 字 管

公稱內徑	管厚	實外徑		R	管 長					本						
		D ₂	d ₂		B	I	J	L ₂	l ₂	T ₁	K	M	R ₅			
800	450	28.7	24.0	852.2	486.8	100	621	700	960	140	120	35.7	41	5	517.0	
	500	"	25.0	"	539.0	110	646	716	980	"	"	"	"	"	"	
	600	"	27.0	"	643.4	"	706	729	1030	"	"	"	"	"	"	
	700	"	28.7	"	747.8	120	756	752	1080	"	"	"	"	"	"	
	800	"	"	"	852.2	"	816	786	1130	"	140	"	"	"	"	
900	200	31.1	18.0	956.6	225.8	90	469	687	840	"	100	38.1	44	"	578.0	
	250	"	19.0	"	278.0	"	524	694	860	"	"	"	"	"	"	
	300	"	20.0	"	330.2	"	549	721	890	"	120	"	"	"	"	
	350	"	21.0	"	382.4	100	584	737	910	"	"	"	"	"	"	
	400	"	23.0	"	434.6	"	609	744	940	"	"	"	"	"	"	
	450	"	24.0	"	486.8	110	644	760	960	"	"	"	"	"	"	
	500	"	25.0	"	539.0	"	669	766	990	"	"	"	"	"	"	
	600	"	27.0	"	643.4	120	729	789	1040	"	"	"	"	"	"	
	700	"	29.0	"	747.8	"	779	802	1090	"	"	"	"	"	"	
	800	"	31.1	"	852.2	130	839	846	1140	"	140	"	"	"	"	
	900	"	"	"	956.6	"	889	859	1190	"	"	"	"	"	"	
1000	300	33.6	20.0	1061.0	330.2	100	571	781	890	"	120	40.6	46	"	631.0	
	350	"	21.0	"	382.4	"	596	787	920	"	"	"	"	"	"	
	400	"	23.0	"	434.6	110	631	804	940	"	"	"	"	"	"	
	450	"	24.0	"	486.8	"	656	810	970	"	"	"	"	"	"	
	500	"	25.0	"	539.0	120	691	826	990	"	"	"	"	"	"	
	600	"	27.0	"	643.4	"	731	839	1040	"	"	"	"	"	"	
	700	"	29.0	"	747.8	130	801	862	1090	"	"	"	"	"	"	
	800	"	31.0	"	852.2	"	851	896	1140	"	140	"	"	"	"	
	900	"	33.6	"	956.6	140	911	919	1190	"	"	"	"	"	"	
	1000	"	"	"	1061.0	"	961	931	1240	"	"	"	"	"	"	
	1100	400	36.0	23.0	1165.4	434.6	110	644	854	950	"	120	43.0	49	"	633.0
450		"	24.0	"	486.8	"	669	860	970	"	"	"	"	"	"	
500		"	25.0	"	539.0	120	704	866	1000	"	"	"	"	"	"	
600		"	27.0	"	643.4	"	754	889	1050	"	"	"	"	"	"	
700		"	29.0	"	747.8	130	814	912	1100	"	"	"	"	"	"	
800		"	31.0	"	852.2	"	864	946	1150	"	140	"	"	"	"	
900		"	34.0	"	956.6	140	924	969	1200	"	"	"	"	"	"	
1000		"	36.0	"	1061.0	"	974	981	1250	"	"	"	"	"	"	
1100		"	"	"	1165.4	150	1034	1004	1300	"	"	"	"	"	"	
1200		400	38.4	23.0	1269.8	434.6	110	657	904	950	"	120	45.4	52	"	735.0
		450	"	24.0	"	486.8	120	692	920	970	"	"	"	"	"	"
	500	"	25.0	"	539.0	"	717	926	1000	"	"	"	"	"	"	
	600	"	27.0	"	643.4	130	777	949	1050	"	"	"	"	"	"	
	700	"	29.0	"	747.8	"	827	962	1100	"	"	"	"	"	"	
	800	"	31.0	"	852.2	140	887	1006	1150	"	140	"	"	"	"	
	900	"	34.0	"	956.6	"	937	1019	1200	"	"	"	"	"	"	
	1000	"	36.0	"	1061.0	150	994	1041	1250	"	"	"	"	"	"	
	1100	"	38.4	"	1165.4	"	1047	1054	1300	"	"	"	"	"	"	
	1200	"	"	"	1269.8	"	1097	1067	1350	"	"	"	"	"	"	

管 鈎		枝		管			鈎		重量	公稱內徑				
R ₄	R ₃	ボルト孔 d'	數	t ₁	k	m	r ₅	r ₄		r ₃	d''	數	D	d
480.0	443.0	30	20	30.0	31	4	326.0	292.5	259.0	27	12	1090	800	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1150	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1270	"	600
"	"	"	"	34.7	38	"	464.0	427.0	390.0	30	"	1420	"	700
"	"	"	"	35.7	41	5	517.0	480.0	443.0	"	20	1580	"	800
536.5	495.0	35	"	23.0	24	3	171.0	149.5	128.0	18	8	1010	500	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	1050	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	1110	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1160	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1220	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1290	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1360	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1470	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1620	"	700
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	1830	"	800
"	"	"	"	38.1	41	5	517.0	480.0	443.0	"	20	1830	"	800
"	"	"	"	"	44	"	578.0	536.5	495.0	35	"	1990	"	900
589.5	548.0	"	24	26.0	27	4	232.0	207.0	181.0	21	10	1350	1000	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1410	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1470	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1540	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1610	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1730	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1910	"	700
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2110	"	800
"	"	"	"	40.6	44	"	578.0	536.5	495.0	35	"	2350	"	900
"	"	"	"	"	46	"	631.0	589.5	548.0	"	24	2510	"	1000
641.5	600.0	"	"	39.0	30	4	291.0	262.0	233.0	24	12	1720	1100	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1790	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1870	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	2010	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2190	"	700
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2440	"	800
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2640	"	900
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2910	"	1000
"	"	"	"	"	49	"	683.0	641.5	600.0	"	"	3080	"	1100
693.5	652.0	"	28	29.0	30	4	291.0	262.0	233.0	24	12	2000	1200	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	2080	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	2160	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	2320	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2500	"	700
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2720	"	800
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2960	"	900
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	3210	"	1000
"	"	"	"	45.4	49	"	683.0	641.5	600.0	"	"	3470	"	1100
"	"	"	"	"	52	"	735.0	693.5	652.0	"	28	3690	"	1200

第三號 十字管
第三表 四承十字管



$$H = F + \frac{D}{10} + R + \frac{d}{2} + 30$$

$$I = t + \frac{d}{10} + R + \frac{D}{2}$$

$$J = P + \frac{d}{2} + 60$$

承口ノ寸法ハ直管ニ同シ

四承十字管

公稱內徑 D	管厚 d	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
75	75	11.2	11.2	95.4	95.4	50	200	170	44.1
100	100	11.8	11.8	121.4	121.4	"	210	180	52.1
"	"	"	"	"	"	"	"	"	58.9
125	75	12.4	12.4	147.6	95.4	"	"	190	60.1
"	100	"	"	"	121.4	"	220	200	67.6
"	125	"	"	"	147.6	"	230	"	73.7
150	75	13.0	13.0	173.6	95.4	"	210	"	70.6
"	100	"	"	"	121.4	"	220	210	78.3
"	125	"	"	"	147.6	"	230	"	84.5
"	150	"	"	"	173.6	"	250	220	94.2
200	100	14.2	14.2	225.8	121.4	"	230	230	99.3
"	125	"	"	"	147.6	"	240	240	107
"	150	"	"	"	173.6	60	260	250	119
"	200	"	"	"	225.8	"	290	260	138
250	100	15.4	15.4	278.0	121.4	50	240	"	128
"	125	"	"	"	147.6	60	260	270	137
"	150	"	"	"	173.6	"	270	280	148
"	200	"	"	"	225.8	"	300	"	168
"	250	"	"	"	278.0	"	320	290	191
300	100	16.6	16.0	330.2	121.4	50	240	280	151
"	125	"	"	"	147.6	60	260	300	162
"	150	"	16.6	"	173.6	"	280	"	176
"	200	"	"	"	225.8	"	300	310	196
"	250	"	"	"	278.0	70	340	330	228
"	300	"	"	"	330.2	"	360	"	248
350	100	17.8	16.0	382.4	121.4	60	260	320	187
"	125	"	"	"	147.6	"	270	"	195
"	150	"	17.0	"	173.6	"	280	330	208
"	200	"	17.8	"	225.8	"	310	"	232
"	250	"	"	"	278.0	70	340	350	262
"	300	"	"	"	330.2	"	370	360	289
"	350	"	"	"	382.4	"	390	"	315
400	100	19.0	16.0	434.6	121.4	60	270	340	229
"	125	"	"	"	147.6	"	280	350	238
"	150	"	17.0	"	173.6	"	300	"	254
"	200	"	18.0	"	225.8	70	330	370	282
"	250	"	19.0	"	278.0	"	350	380	311
"	300	"	"	"	330.2	80	390	390	343
"	350	"	"	"	382.4	"	410	400	374
"	400	"	"	"	434.6	90	450	420	423

四承十字管

公稱內徑 D	管厚 a	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
450	100	20.2	16.0	486.8	121.4	60	270	370	268
	125	"	"	"	147.6	"	290	"	282
	150	"	17.0	"	173.6	70	310	390	301
	200	"	18.0	"	225.8	"	330	"	324
	250	"	19.0	"	278.0	80	370	410	364
	300	"	20.0	"	330.2	"	390	420	393
	350	"	20.2	"	382.4	"	420	"	426
	400	"	"	"	434.6	90	450	440	473
450	"	"	"	486.8	"	480	450	517	
500	100	21.5	16.0	539.0	121.4	60	280	390	313
	125	"	"	"	147.6	"	300	400	329
	150	"	17.0	"	173.6	70	320	410	348
	200	"	18.0	"	225.8	"	340	420	373
	250	"	19.0	"	278.0	80	380	440	417
	300	"	20.0	"	330.2	"	400	"	443
	350	"	21.0	"	382.4	"	430	450	485
	400	"	21.5	"	434.6	90	460	470	536
	450	"	"	"	486.8	"	490	"	586
	500	"	"	"	539.0	100	520	490	628
600	150	23.9	17.0	643.4	173.6	80	340	470	460
	200	"	18.0	"	225.8	"	370	480	495
	250	"	19.0	"	278.0	"	390	490	523
	300	"	20.0	"	330.2	90	430	500	573
	350	"	21.0	"	382.4	"	450	510	610
	400	"	23.0	"	434.6	"	480	520	666
	450	"	23.9	"	486.8	100	510	530	721
	500	"	"	"	539.0	"	540	540	772
	500	"	"	"	539.0	"	540	540	772
	600	"	"	"	643.4	110	600	570	890
700	150	26.3	17.0	747.8	173.6	80	350	520	592
	200	"	18.0	"	225.8	"	380	530	632
	250	"	19.0	"	278.0	90	410	550	679
	300	"	20.0	"	330.2	"	440	"	720
	350	"	21.0	"	382.4	"	460	560	759
	400	"	23.0	"	434.6	100	500	580	832
	450	"	24.0	"	486.8	"	520	"	877
	500	"	25.0	"	539.0	"	550	600	943
	600	"	26.3	"	643.4	110	610	620	1080
	700	"	"	"	747.8	"	660	630	1190
800	150	28.7	17.0	852.2	173.6	80	370	570	754
	200	"	18.0	"	225.8	"	390	580	789
	250	"	19.0	"	278.0	90	430	600	853
	300	"	20.0	"	330.2	"	450	"	887
	350	"	21.0	"	382.4	"	480	610	941

四承十字管

公稱內徑 D	管厚 a	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
800	400	28.7	23.0	852.2	434.6	100	510	630	1010
	450	"	24.0	"	486.8	"	540	"	1070
	500	"	25.0	"	539.0	110	570	650	1140
	600	"	27.0	"	643.4	"	620	670	1290
	700	"	28.7	"	747.8	120	680	690	1440
800	"	"	"	852.2	"	730	700	1590	
900	200	31.1	18.0	956.6	225.8	90	420	640	1000
	250	"	19.0	"	278.0	"	440	650	1050
	300	"	20.0	"	330.2	"	470	"	1100
	350	"	21.0	"	382.4	100	500	670	1160
	400	"	23.0	"	434.6	"	530	680	1230
	450	"	24.0	"	486.8	110	560	690	1300
	500	"	25.0	"	539.0	"	590	700	1370
	600	"	27.0	"	643.4	120	650	730	1530
	700	"	29.0	"	747.8	"	700	740	1690
	800	"	31.1	"	852.2	130	760	760	1890
900	"	"	"	956.6	"	810	780	2090	
1000	300	33.6	20.0	1061.0	330.2	100	500	710	1350
	350	"	21.0	"	382.4	"	520	720	1400
	400	"	23.0	"	434.6	110	550	740	1480
	450	"	24.0	"	486.8	"	580	"	1550
	500	"	25.0	"	539.0	120	610	760	1630
	600	"	27.0	"	643.4	"	660	780	1780
	700	"	29.0	"	747.8	130	720	800	1970
	800	"	31.0	"	852.2	"	770	810	2160
	900	"	33.6	"	956.6	140	830	840	2430
	1000	"	"	"	1061.0	"	880	850	2630
1100	400	36.0	23.0	1165.4	434.6	110	570	790	1750
	450	"	24.0	"	486.8	"	600	"	1830
	500	"	25.0	"	539.0	120	630	810	1920
	600	"	27.0	"	643.4	"	680	830	2070
	700	"	29.0	"	747.8	130	740	850	2270
	800	"	31.0	"	852.2	"	790	860	2460
	900	"	34.0	"	956.6	140	850	890	2750
	1000	"	36.0	"	1061.0	"	900	900	2990
	1100	"	"	"	1165.4	150	960	930	3210
	1200	400	38.4	23.0	1269.8	434.6	110	580	840
450		"	24.0	"	486.8	120	610	850	2140
500		"	25.0	"	539.0	"	640	860	2230
600		"	27.0	"	643.4	130	700	890	2420
700		"	29.0	"	747.8	"	750	900	2610
800		"	31.0	"	852.2	140	810	920	2840
900	"	34.0	"	956.6	"	860	940	3100	

四承十字管

公稱内徑 D	管厚 d	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
1200	1000	38.4	36.0	1269.8	1061.0	150	920	960	3380
"	1100	"	38.4	"	1165.4	"	970	980	3690
"	1200	"	"	"	1269.8	"	1020	990	4060

$$P = L_2 + M + K + \frac{D}{10} + R + \frac{d}{2} + 30$$

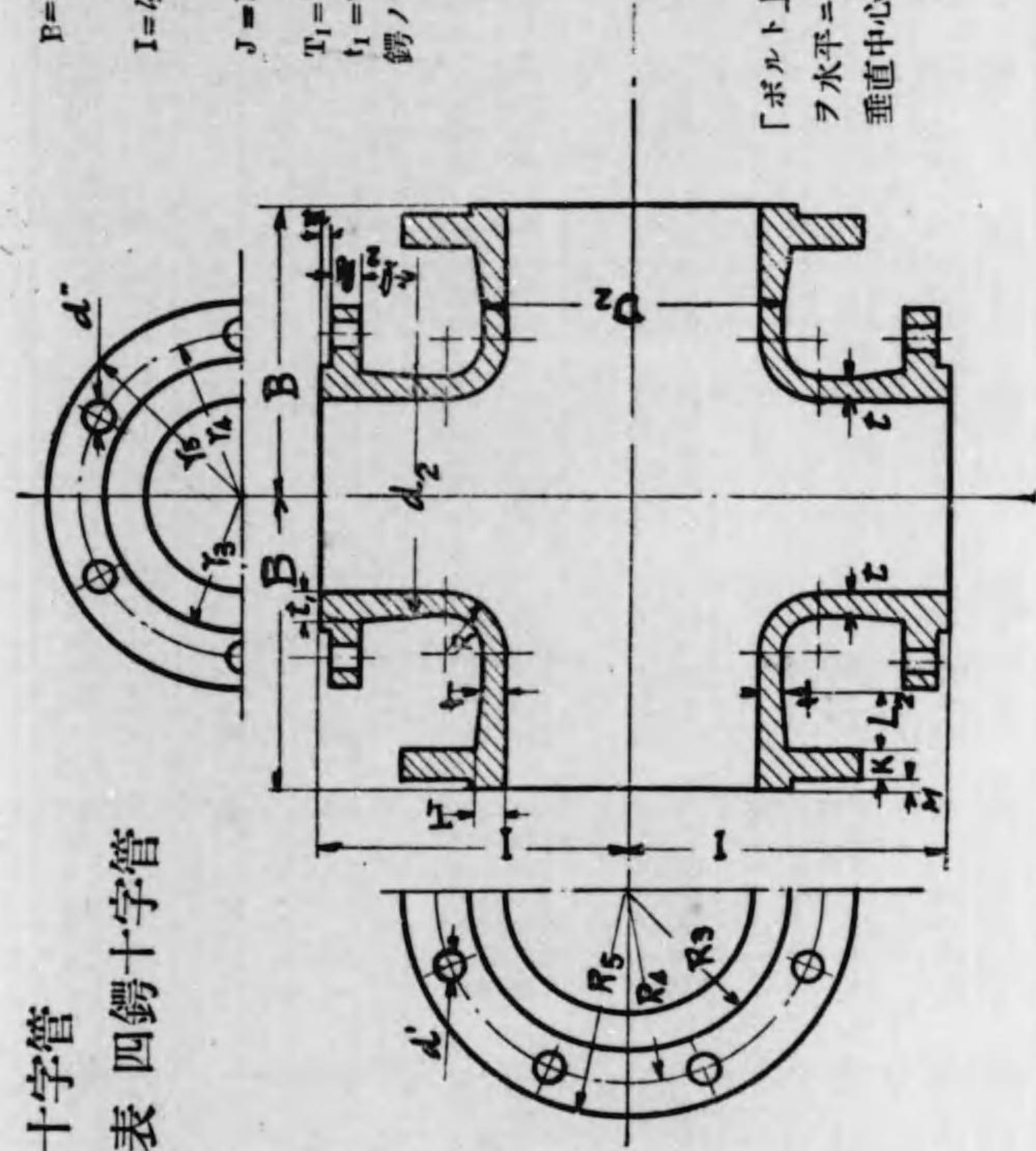
$$I = L_1 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$J = P + \frac{d}{2} + 600$$

$$T_1 = T + n$$

$$t_1 = t + n$$

銲ノ寸法ハ直管ニ同シ



「ポルト」孔ノ配置ハ管ノ總テノ軸線
ヲ水平ニ爲シタル場合ニ共ノ銲面ノ
垂直中心線ニ對シ振分トス

第三號十字管
第四表 四銲十字管

四銜十字管

公稱內徑		管厚		實外徑		R	管長				本			
D	d	T	t	D ₂	d ₂		B	I	L ₂	L ₂	T ₁	K	M	R ₃
75	75	11.2	11.2	95.4	95.4	50	249	219	100	100	16.2	21	3	105.5
100	"	11.8	11.8	121.4	"	"	252	231	"	"	16.8	22	"	119.0
"	100	"	"	121.4	"	"	265	235	"	"	"	"	"	"
125	75	12.4	12.4	147.6	95.4	"	255	244	"	"	17.4	"	"	131.5
"	100	"	"	121.4	"	"	267	247	"	"	"	"	"	"
"	125	"	"	147.6	"	"	280	250	"	"	"	"	"	"
150	75	13.0	13.0	173.6	95.4	"	253	256	"	"	18.0	23	"	145.0
"	100	"	"	121.4	"	"	271	260	"	"	"	"	"	"
"	125	"	"	147.6	"	"	284	262	"	"	"	"	"	"
"	150	"	"	173.6	"	"	296	266	"	"	"	"	"	"
200	100	14.2	14.2	225.8	121.4	"	277	285	"	"	19.2	24	"	171.0
"	125	"	"	147.6	"	"	289	287	"	"	"	"	"	"
"	150	"	"	173.6	60	312	301	"	"	"	"	"	"	"
"	200	"	"	225.8	"	337	307	"	"	"	"	"	"	"
250	100	15.4	15.4	278.0	121.4	50	284	310	"	"	20.4	26	"	205.0
"	125	"	"	147.6	60	306	322	"	"	"	"	"	"	"
"	150	"	"	173.6	"	319	326	"	"	"	"	"	"	"
"	220	"	"	225.8	"	340	332	"	"	"	"	"	"	"
"	250	"	"	278.0	"	269	339	"	"	"	"	"	"	"
300	100	16.6	16.0	330.2	121.4	50	311	335	120	"	22.6	27	4	232.0
"	125	"	"	147.6	60	333	347	"	"	"	"	"	"	"
"	150	"	16.6	173.6	"	346	351	"	"	"	"	"	"	"
"	200	"	"	225.8	"	371	357	"	"	"	"	"	"	"
"	250	"	"	278.0	70	406	374	"	"	"	"	"	"	"
"	300	"	"	330.2	"	431	401	"	120	"	"	"	"	"
350	100	17.8	16.0	332.4	121.4	60	327	370	"	100	23.8	28	"	265.0
"	125	"	"	147.6	"	339	372	"	"	"	"	"	"	"
"	150	"	17.0	173.6	"	352	376	"	"	"	"	"	"	"
"	200	"	17.8	225.8	"	377	382	"	"	"	"	"	"	"
"	250	"	"	278.0	70	412	399	"	"	"	"	"	"	"
"	300	"	"	330.2	"	437	426	"	120	"	"	"	"	"
"	350	"	"	332.4	"	462	432	"	"	"	"	"	"	"
400	100	19.0	16.0	434.6	121.4	60	334	395	"	100	25.0	30	"	291.0
"	125	"	"	147.6	"	346	397	"	"	"	"	"	"	"
"	150	"	17.0	173.6	"	359	401	"	"	"	"	"	"	"
"	200	"	18.0	225.8	70	394	417	"	"	"	"	"	"	"
"	250	"	19.0	278.0	"	419	424	"	"	"	"	"	"	"
"	300	"	"	330.2	80	454	461	"	120	"	"	"	"	"
"	350	"	"	332.4	"	479	467	"	"	"	"	"	"	"
"	400	"	"	434.6	90	514	487	"	"	"	"	"	"	"

管		銜		枝		管		銜		重量	公稱內徑			
R ₄	R ₃	ボルト孔 d'	數	t	k	m	r ₁	r ₄	r ₃		ボルト孔 d''	數	D	d
84.0	62.5	18	4	16.2	21	3	105.5	84.0	62.5	18	4	36.7	75	75
97.5	76.0	"	"	16.8	"	"	"	"	"	"	"	43.4	100	"
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	48.9	"	100
110.0	88.5	"	6	17.4	21	"	105.5	84.0	62.5	"	"	49.7	125	75
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	55.4	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	60.4	"	125
123.5	102.0	"	"	18.0	21	"	105.5	84.0	62.5	"	4	57.1	150	75
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	63.4	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	67.9	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	72.8	"	150
149.5	128.0	"	8	19.2	22	"	119.0	97.5	76.0	"	4	80.7	200	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	86.3	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	94.8	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	108	"	200
180.0	154.0	21	"	20.4	22	"	119.0	97.5	76.0	"	4	105	250	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	114	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	122	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	137	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	157	"	250
207.0	181.0	"	10	21.0	22	"	119.0	97.5	76.0	18	4	134	300	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	145	"	125
"	"	"	"	21.6	23	"	145.0	123.5	102.0	"	"	154	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	170	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	197	"	250
"	"	"	"	22.6	27	4	232.0	207.0	181.0	"	10	223	"	300
236.0	207.0	24	"	21.0	22	3	119.0	97.5	76.0	18	4	168	350	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	176	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	187	"	150
"	"	"	"	22.8	24	"	171.0	149.5	128.0	"	8	207	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	234	"	250
"	"	"	"	23.8	27	4	232.0	207.0	181.0	"	10	262	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	290	"	350
262.0	233.0	"	12	21.0	22	3	119.0	97.5	76.0	18	4	200	400	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	208	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	219	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	245	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	268	"	250
"	"	"	"	25.0	27	4	232.0	207.0	181.0	"	10	306	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	335	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	371	"	400

四鈔十字管

公稱 內徑	管厚		實外徑		R	管長								本
	D	d	T	t		D ₂	d ₂	B	I	L ₁	L ₂	T ₁	K	
450	100	20.2	16.0	486.8	121.4	60	340	420	120	100	26.2	31	4	326.0
"	125	"	"	"	147.6	"	352	422	"	"	"	"	"	"
"	150	"	17.0	"	173.6	70	375	436	"	"	"	"	"	"
"	200	"	18.0	"	225.8	"	400	442	"	"	"	"	"	"
"	250	"	19.0	"	278.0	80	435	459	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	460	486	"	120	"	"	"	"
"	350	"	20.2	"	382.4	"	485	492	"	"	"	"	"	"
"	400	"	"	"	434.6	90	520	509	"	"	"	"	"	"
"	450	"	"	"	486.8	"	545	515	"	"	"	"	"	"
500	100	21.5	16.0	539.0	121.4	60	346	445	"	100	27.5	32	"	353.0
"	125	"	"	"	147.6	"	358	447	"	"	"	"	"	"
"	150	"	17.0	"	173.6	70	381	461	"	"	"	"	"	"
"	200	"	18.0	"	225.8	"	406	467	"	"	"	"	"	"
"	250	"	19.0	"	278.0	80	441	484	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	466	511	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	491	517	"	"	"	"	"	"
"	400	"	21.5	"	434.6	90	526	534	"	"	"	"	"	"
"	450	"	"	"	486.8	"	551	540	"	"	"	"	"	"
"	500	"	"	"	539.0	100	561	556	"	"	"	"	"	"
600	150	23.9	17.0	643.4	173.6	80	404	521	"	100	29.9	35	"	405.0
"	200	"	18.0	"	225.8	"	429	527	"	"	"	"	"	"
"	250	"	19.0	"	278.0	"	454	534	"	"	"	"	"	"
"	300	"	20.0	"	330.2	90	489	571	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	514	577	"	"	"	"	"	"
"	400	"	23.0	"	434.6	"	539	584	"	"	"	"	"	"
"	450	"	23.9	"	486.8	100	574	600	"	"	"	"	"	"
"	500	"	"	"	539.0	"	599	606	"	"	"	"	"	"
"	600	"	"	"	643.4	110	659	629	"	"	"	"	"	"
700	150	26.3	17.0	747.8	173.6	80	420	570	"	100	32.3	38	"	464.0
"	200	"	18.0	"	225.8	"	442	577	"	"	"	"	"	"
"	250	"	19.0	"	278.0	90	477	594	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	502	621	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	527	627	"	"	"	"	"	"
"	400	"	23.0	"	434.6	100	562	634	"	"	"	"	"	"
"	450	"	24.0	"	486.8	"	587	650	"	"	"	"	"	"
"	500	"	25.0	"	539.0	"	612	656	"	"	"	"	"	"
"	600	"	26.3	"	643.4	110	672	679	"	"	"	"	"	"
"	700	"	"	"	747.8	"	722	692	"	"	"	"	"	"
800	150	28.7	17.0	852.2	173.6	80	451	621	140	100	35.7	41	5	517.0
"	200	"	18.0	"	225.8	"	476	627	"	"	"	"	"	"
"	250	"	19.0	"	278.0	90	511	644	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	536	651	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	566	677	"	"	"	"	"	"
"	400	"	23.0	"	434.6	100	596	694	"	"	"	"	"	"
"	450	"	24.0	"	486.8	"	621	700	"	"	"	"	"	"

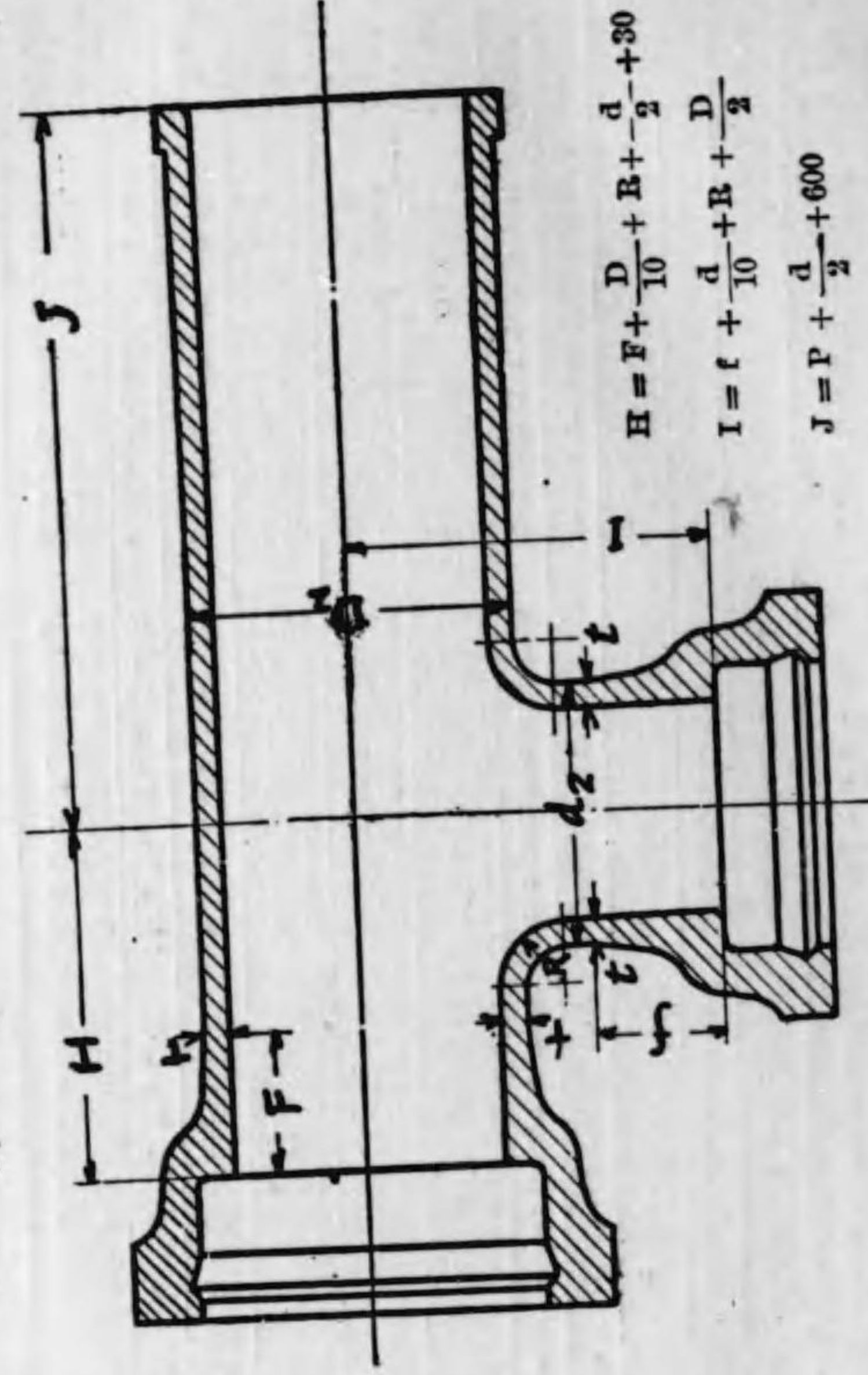
管		鈔		枝		管		鈔		重量	公稱內徑			
R ₁	R ₃	ボルト孔 d' 數	t ₁	k	m	r ₅	r ₄	r ₃	ボルト孔 d'' 數		D	d		
292.5	259.0	27	12	21.0	22	3	119.0	97.5	76.0	18	4	241	450	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	250	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	267	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	289	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	324	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	359	"	300
"	"	"	"	26.2	28	"	265.0	236.0	207.0	24	"	391	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	429	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	27	"	467	"	450
319.5	286.0	"	"	21.0	22	3	119.0	97.5	76.0	18	4	280	500	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	290	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	309	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	332	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	369	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	406	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	442	"	350
"	"	"	"	27.5	30	"	291.0	262.0	233.0	"	12	486	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	27	"	525	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	558	"	500
371.5	338.0	"	16	22.0	23	3	145.0	123.5	102.0	18	6	404	600	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	430	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	465	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	513	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	552	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	596	"	400
"	"	"	"	29.9	31	"	326.0	292.5	259.0	27	"	656	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	696	"	500
"	"	"	"	"	35	"	405.0	371.5	338.0	"	16	789	"	600
427.0	390.0	30	"	22.0	23	3	145.0	123.5	102.0	18	6	532	700	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	561	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	609	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	652	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	694	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	750	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	806	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	855	"	500
"	"	"	"	32.3	35	"	405.0	371.5	338.0	"	16	971	"	600
"	"	"	"	"	38	"	464.0	427.0	390.0	30	"	1089	"	700
480.0	443.0	"	20	22.0	23	3	145.0	123.5	102.0	18	6	696	800	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	733	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	787	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	829	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	887	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	947	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1000	"	450

四銜十字管

公稱 內徑	管 厚	實 外徑	R	管 長				本						
				B	I	L ₂	L ₁	T ₁	K	M	R ₃			
800	500	23.7	25.0	852.2	539.0	110	646	716	140	120	35.7	41	5	517.0
	600	"	27.0	"	643.4	"	706	729	"	"	"	"	"	"
	700	"	23.7	"	747.8	120	756	752	"	"	"	"	"	"
	800	"	"	"	852.2	"	816	786	"	140	"	"	"	"
900	200	31.1	18.0	956.6	225.8	90	469	687	"	100	33.1	44	"	578.0
	250	"	19.0	"	278.0	"	524	694	"	"	"	"	"	"
	300	"	20.0	"	330.2	"	549	721	"	120	"	"	"	"
	350	"	21.0	"	382.4	100	584	737	"	"	"	"	"	"
	400	"	23.0	"	434.6	"	609	744	"	"	"	"	"	"
	450	"	24.0	"	486.8	110	644	760	"	"	"	"	"	"
	500	"	25.0	"	539.0	"	669	766	"	"	"	"	"	"
	600	"	27.0	"	643.4	120	729	789	"	"	"	"	"	"
	700	"	29.0	"	747.8	"	779	802	"	"	"	"	"	"
	800	"	31.1	"	852.2	130	839	846	"	140	"	"	"	"
900	"	"	"	956.6	"	889	859	"	"	"	"	"	"	
1000	300	33.6	20.0	1061.0	330.2	100	571	781	"	120	40.6	46	"	631.0
	350	"	21.0	"	382.4	"	596	787	"	"	"	"	"	"
	400	"	23.0	"	434.6	110	631	804	"	"	"	"	"	"
	450	"	24.0	"	486.8	"	656	810	"	"	"	"	"	"
	500	"	25.0	"	539.0	120	691	826	"	"	"	"	"	"
	600	"	27.0	"	643.4	"	731	839	"	"	"	"	"	"
	700	"	29.0	"	747.8	130	801	862	"	"	"	"	"	"
	800	"	31.0	"	852.2	"	851	896	"	140	"	"	"	"
	900	"	33.6	"	956.6	140	911	919	"	"	"	"	"	"
	1000	"	"	"	1061.0	"	961	931	"	"	"	"	"	"
1100	400	36.0	23.0	1165.4	434.6	110	644	854	"	120	43.0	49	"	683.0
	450	"	24.0	"	486.8	"	669	860	"	"	"	"	"	"
	500	"	25.0	"	539.0	120	704	866	"	"	"	"	"	"
	600	"	27.0	"	643.4	"	754	889	"	"	"	"	"	"
	700	"	29.0	"	747.8	130	814	912	"	"	"	"	"	"
	800	"	31.0	"	852.2	"	864	946	"	140	"	"	"	"
	900	"	34.0	"	956.6	140	924	969	"	"	"	"	"	"
	1000	"	36.0	"	1061.0	"	974	981	"	"	"	"	"	"
	1100	"	"	"	1165.4	150	1034	1004	"	"	"	"	"	"
	1200	400	38.4	23.0	1269.8	434.6	110	657	904	"	120	45.4	52	"
450		"	24.0	"	486.8	120	692	920	"	"	"	"	"	"
500		"	25.0	"	539.0	"	717	926	"	"	"	"	"	"
600		"	27.0	"	643.4	130	777	949	"	"	"	"	"	"
700		"	29.0	"	747.8	"	827	962	"	"	"	"	"	"
800		"	31.0	"	852.2	140	887	1006	"	140	"	"	"	"
900		"	34.0	"	956.6	"	937	1019	"	"	"	"	"	"
1000		"	36.0	"	1061.0	150	994	1041	"	"	"	"	"	"
1100		"	38.4	"	1165.4	"	1047	1054	"	"	"	"	"	"
1200		"	"	"	1269.8	"	1097	1067	"	"	"	"	"	"

管 銜		枝		管		銜		重量		公稱內徑			
R ₄	R ₃	ボルト孔 d' 數	t ₁	k	m	r ₅	r ₄	r ₃	ボルト孔 d' 數	D	d		
480.0	443.0	30 20	31.0	32	4	353.0	319.5	286.0	27	12	1060	800	
"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1180	"	
"	"	"	34.7	38	"	464.0	427.0	390.0	30	"	1340	"	
"	"	"	35.7	41	5	517.0	480.0	443.0	"	20	1500	"	
536.5	495.0	35	23.0	24	3	171.0	149.5	123.0	18	8	879	900	
"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	924	"	
"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	974	"	
"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1040	"	
"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1090	"	
"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1170	"	
"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1220	"	
"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1350	"	
"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1500	"	
"	"	"	38.1	41	5	517.0	480.0	443.0	"	20	1710	"	
"	"	"	"	44	"	578.0	536.5	495.0	"	"	1870	"	
589.5	548.0	"	24	26.0	27	4	232.0	207.0	181.0	21	10	1220	1000
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1280	"
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1360	"
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1420	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1510	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1620	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1810	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2010	"
"	"	"	"	40.6	44	"	578.0	536.5	495.0	35	"	2250	"
"	"	"	"	"	46	"	631.0	589.5	548.0	"	24	2420	"
641.5	600.0	"	"	29.0	30	4	291.0	262.0	233.0	24	12	1590	1100
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1660	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1740	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1880	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2070	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2270	"
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2530	"
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2750	"
"	"	"	"	"	49	"	683.0	641.5	600.0	"	"	2980	"
693.5	652.0	"	23	29.0	30	4	291.0	262.0	233.0	24	12	1850	1200
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1950	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	2020	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	2190	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2370	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2610	"
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2840	"
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	3100	"
"	"	"	"	45.4	49	"	683.0	641.5	600.0	"	"	3360	"
"	"	"	"	"	52	"	735.0	693.5	652.0	"	28	3580	"

管
第四號丁字管
第一表 二承丁字管



承口及挿口ノ寸法ハ直管ニ同シ

二承丁字管

公稱內徑 D	管厚 d	管厚		實外徑		R	管長			重量
		T	t	D ₂	d ₂		H	I	J	
75	75	11.2	11.2	95.4	95.4	50	200	170	730	37.8
100	100	11.8	11.8	121.4	121.4	"	210	180	750	47.6
125	75	12.4	12.4	147.6	95.4	"	"	190	730	58.0
"	100	"	"	"	121.4	"	220	200	750	62.5
"	125	"	"	"	147.6	"	230	"	760	66.9
150	75	13.0	13.0	173.6	95.4	"	210	"	740	70.5
"	100	"	"	"	121.4	"	220	210	750	74.9
"	125	"	"	"	147.6	"	230	"	760	78.4
"	150	"	"	"	173.6	"	250	220	780	84.3
200	100	14.2	14.2	225.8	121.4	"	230	230	750	101
"	125	"	"	"	147.6	"	240	240	760	105
"	150	"	"	"	173.6	60	260	250	780	113
"	200	"	"	"	225.8	"	290	260	800	124
250	100	15.4	15.4	278.0	121.4	50	240	"	760	134
"	125	"	"	"	147.6	60	260	270	770	140
"	150	"	"	"	173.6	"	270	230	780	146
"	200	"	"	"	225.8	"	300	"	810	159
"	250	"	"	"	278.0	"	320	290	830	172
300	100	16.6	16.0	330.2	121.4	50	240	230	760	167
"	125	"	"	"	147.6	60	260	300	770	173
"	150	"	16.6	"	173.6	"	230	"	730	130
"	200	"	"	"	225.8	"	300	310	810	194
"	250	"	"	"	278.0	70	340	330	830	212
"	300	"	"	"	330.2	"	360	"	860	226
350	100	17.8	16.0	332.4	121.4	60	260	320	760	206
"	125	"	"	"	147.6	"	270	"	770	212
"	150	"	17.0	"	173.6	"	230	330	790	221
"	200	"	17.8	"	225.8	"	310	"	810	236
"	250	"	"	"	278.0	70	340	350	840	256
"	300	"	"	"	330.2	"	370	360	860	272
"	350	"	"	"	332.4	"	390	"	890	304
400	100	19.0	16.0	434.6	121.4	60	270	340	760	252
"	125	"	"	"	147.6	"	230	350	770	253
"	150	"	17.0	"	173.6	"	300	"	790	270
"	200	"	18.0	"	225.8	70	330	370	810	237
"	250	"	19.0	"	278.0	"	350	330	840	307
"	300	"	"	"	330.2	80	390	390	860	331
"	350	"	"	"	332.4	"	410	400	890	347

二承丁字管

公稱內徑 D	管厚 d	實外徑 D ₂	管厚 t	實外徑 d ₂	R	管長			重量
						H	I	J	
400	400	434.6	19.0	434.6	90	450	420	910	375
450	100	486.8	20.2	121.4	60	270	370	770	300
"	125	"	"	147.6	"	290	"	780	309
"	150	"	17.0	173.6	70	310	390	790	321
"	200	"	18.0	225.8	"	330	"	820	339
"	250	"	19.0	278.0	80	370	410	840	363
"	300	"	20.0	330.2	"	390	420	870	384
"	350	"	20.2	382.4	"	420	"	890	405
"	400	"	"	434.6	90	450	440	920	434
"	450	"	"	486.8	"	480	450	940	461
500	100	539.0	21.5	121.4	60	280	390	770	352
"	125	"	"	147.6	"	300	400	780	363
"	150	"	17.0	173.6	70	320	410	790	375
"	200	"	18.0	225.8	"	340	420	820	395
"	250	"	19.0	278.0	80	380	440	840	422
"	300	"	20.0	330.2	"	400	"	870	443
"	350	"	21.0	382.4	"	430	450	890	468
"	400	"	21.5	434.6	90	460	470	920	501
"	450	"	"	486.8	"	490	"	940	532
"	500	"	"	539.0	100	520	490	970	560
600	150	643.4	23.9	173.6	80	340	470	800	496
"	200	"	18.0	225.8	"	370	480	820	520
"	250	"	19.0	278.0	"	390	490	850	546
"	300	"	20.0	330.2	90	430	500	870	575
"	350	"	21.0	382.4	"	450	510	900	604
"	400	"	23.0	434.6	"	480	520	920	639
"	450	"	23.9	486.8	100	510	530	950	676
"	500	"	"	539.0	"	540	540	970	708
"	600	"	"	643.4	110	600	570	1020	783
700	150	747.8	26.3	173.6	80	350	520	800	642
"	200	"	18.0	225.8	"	380	530	830	675
"	250	"	19.0	278.0	90	410	550	850	707
"	300	"	20.0	330.2	"	440	"	880	740
"	350	"	21.0	382.4	"	460	560	900	768
"	400	"	23.0	434.6	100	500	580	930	818
"	450	"	24.0	486.8	"	520	"	950	849
"	500	"	25.0	539.0	"	550	600	980	895
"	600	"	26.3	643.4	110	610	620	1030	982
"	700	"	"	747.8	"	660	630	1080	1060
800	150	852.2	28.7	173.6	80	370	570	810	813
"	200	"	18.0	225.8	"	390	580	830	851
"	250	"	19.0	278.0	90	430	600	860	889
"	300	"	20.0	330.2	"	450	"	880	917

二承丁字管

公稱內徑 D	管厚 d	實外徑 D ₂	管厚 t	實外徑 d ₂	R	管長			重量
						H	I	J	
800	350	852.2	28.7	382.4	90	480	610	910	942
"	400	"	23.0	434.6	100	510	630	930	1000
"	450	"	24.0	486.8	"	540	"	960	1050
"	500	"	25.0	539.0	110	570	650	980	1100
"	600	"	27.0	643.4	"	620	670	1030	1190
"	700	"	28.7	747.8	120	680	690	1080	1300
"	800	"	"	852.2	"	730	700	1130	1400
900	200	956.6	31.1	225.8	90	420	640	840	1050
"	250	"	19.0	278.0	"	440	650	860	1090
"	300	"	20.0	330.2	"	470	"	890	1130
"	350	"	21.0	382.4	100	500	670	910	1180
"	400	"	23.0	434.6	"	520	680	940	1230
"	450	"	24.0	486.8	110	560	690	960	1280
"	500	"	25.0	539.0	"	590	700	990	1330
"	600	"	27.0	643.4	120	650	730	1040	1440
"	700	"	29.0	747.8	"	700	740	1090	1560
"	800	"	31.1	852.2	130	760	760	1140	1690
"	900	"	"	956.6	"	810	780	1190	1820
1000	300	1061.0	33.6	330.2	100	500	710	890	1370
"	350	"	21.0	382.4	"	520	720	920	1420
"	400	"	23.0	434.6	110	550	740	940	1480
"	450	"	24.0	486.8	"	580	"	970	1540
"	500	"	25.0	539.0	120	610	760	990	1590
"	600	"	27.0	643.4	"	660	780	1040	1710
"	700	"	29.0	747.8	130	720	800	1090	1840
"	800	"	31.0	852.2	"	770	810	1140	1970
"	900	"	33.6	956.6	140	830	840	1190	2150
"	1000	"	"	1061.0	"	880	850	1240	2290
1100	400	1165.4	36.0	434.6	110	570	790	950	1750
"	450	"	24.0	486.8	"	600	"	970	1810
"	500	"	25.0	539.0	120	630	810	1000	1880
"	600	"	27.0	643.4	"	680	830	1050	2000
"	700	"	29.0	747.8	130	740	850	1100	2150
"	800	"	31.0	852.2	"	790	860	1150	2290
"	900	"	34.0	956.6	140	850	890	1200	2480
"	1000	"	36.0	1061.0	"	900	900	1250	2640
"	1100	"	"	1165.4	150	960	930	1300	2830
1200	400	1269.8	38.4	434.6	110	580	840	950	2090
"	450	"	24.0	486.8	120	610	850	970	2110
"	500	"	25.0	539.0	"	640	860	1000	2190
"	600	"	27.0	643.4	130	700	890	1050	2340
"	700	"	29.0	747.8	"	750	900	1100	2480
"	800	"	31.0	852.2	140	810	920	1150	2650
"	900	"	34.0	956.6	"	860	940	1200	2840
"	1000	"	36.0	1061.0	150	920	960	1250	3030

二承丁字管

公稱内徑		管厚		實外徑		R	管長			重量
D	d	T	t	D ₂	d ₂		H	I	J	
1200	1100	38.4	38.4	1269.8	1165.4	150	970	980	1300	3240
"	1200	"	"	"	1269.8	"	1020	990	1350	3480

第四號 丁字管
第二表 二銲丁字管

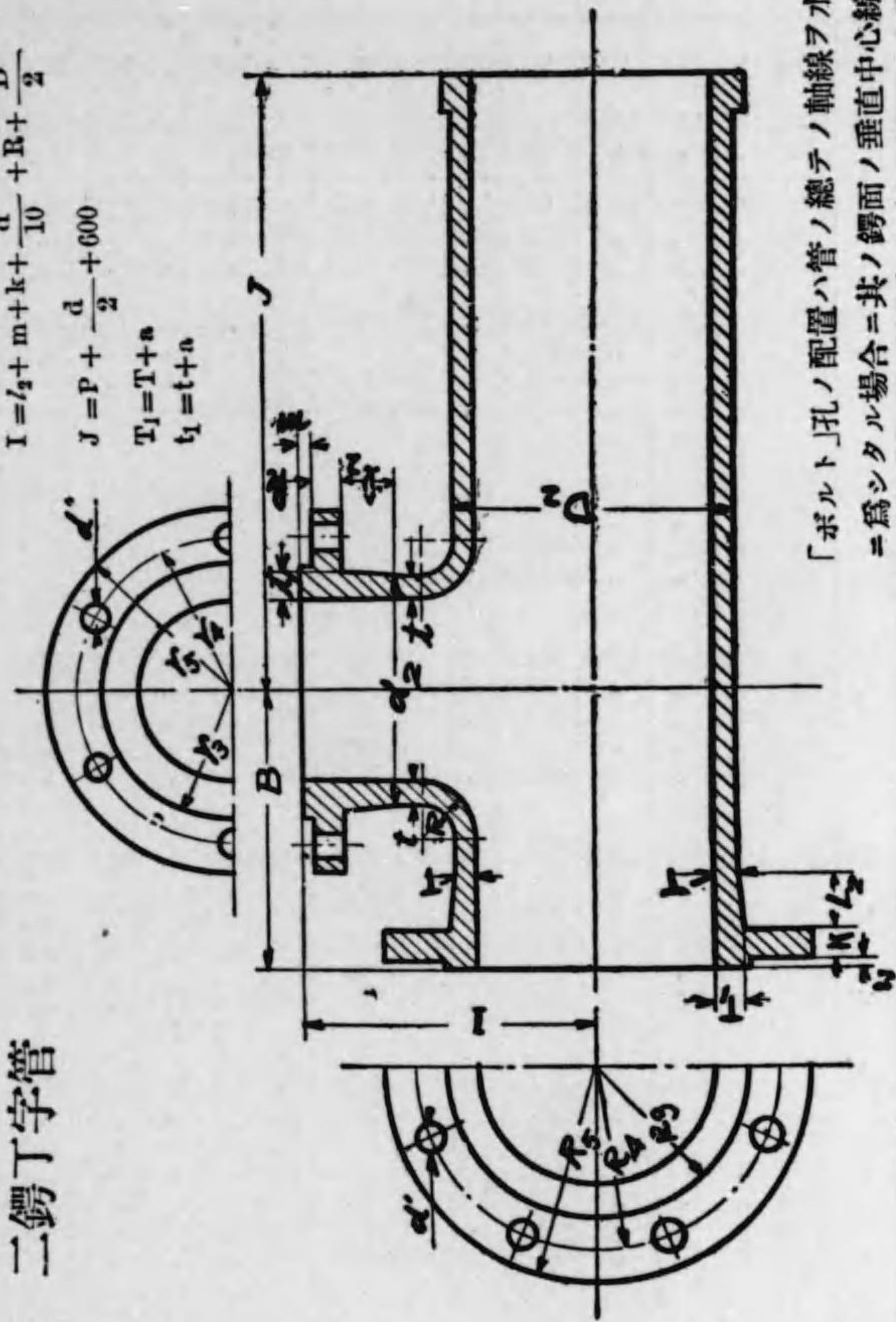
$$B = L_2 + M + K + \frac{D}{10} + R + \frac{d}{2} + 30$$

$$I = l_2 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$J = P + \frac{d}{2} + 600$$

$$T_1 = T + a$$

$$t_1 = t + a$$



「ボルト」孔ノ配置ハ管ノ總線ヲ水平
ニ爲シタル場合ニ共ノ銲面ノ垂直中心線ニ
對シ振分トス

二 鋤 丁 字 管

公稱內徑		管 厚		實 外 徑		R	管 長					本			
D	d	T	t	D ₂	d ₂		B	I	J	L ₂	L ₁	T ₁	K	M	R _s
75	75	11.2	11.2	95.4	95.4	50	249	219	730	100	100	16.2	21	3	105.5
100	100	11.8	11.8	121.4	121.4	"	252	231	"	"	"	16.8	22	"	119.0
"	"	"	"	"	"	"	265	235	750	"	"	"	"	"	"
125	75	12.4	12.4	147.6	95.4	"	255	244	730	"	"	17.4	"	"	131.5
"	100	"	"	"	121.4	"	267	247	750	"	"	"	"	"	"
"	125	"	"	"	147.6	"	280	250	760	"	"	"	"	"	"
150	75	13.0	13.0	173.6	95.4	"	253	256	740	"	"	18.0	23	"	145.0
"	100	"	"	"	121.4	"	271	260	750	"	"	"	"	"	"
"	125	"	"	"	147.6	"	284	262	760	"	"	"	"	"	"
"	150	"	"	"	173.6	"	296	266	780	"	"	"	"	"	"
200	100	14.2	14.2	225.8	121.4	"	277	285	750	"	"	19.2	24	"	171.0
"	125	"	"	"	147.6	"	289	287	760	"	"	"	"	"	"
"	150	"	"	"	173.6	60	312	301	780	"	"	"	"	"	"
"	200	"	"	"	225.8	"	337	307	800	"	"	"	"	"	"
250	100	15.4	15.4	273.0	121.4	50	284	310	760	"	"	20.4	26	"	205.0
"	125	"	"	"	147.6	60	306	322	770	"	"	"	"	"	"
"	150	"	"	"	173.6	"	319	326	780	"	"	"	"	"	"
"	200	"	"	"	225.8	"	344	332	810	"	"	"	"	"	"
"	250	"	"	"	273.0	"	369	339	830	"	"	"	"	"	"
300	100	16.6	16.0	330.2	121.4	50	311	335	760	120	"	22.6	27	4	232.0
"	125	"	"	"	147.6	60	333	347	770	"	"	"	"	"	"
"	150	"	16.6	"	173.6	"	346	351	780	"	"	"	"	"	"
"	200	"	"	"	225.8	"	371	357	810	"	"	"	"	"	"
"	250	"	"	"	273.0	70	406	374	830	"	"	"	"	"	"
"	300	"	"	"	330.2	"	431	401	860	120	"	"	"	"	"
350	100	17.8	16.0	382.4	121.4	60	327	370	760	"	100	23.8	28	"	265.0
"	125	"	"	"	147.6	"	339	372	770	"	"	"	"	"	"
"	150	"	17.0	"	173.6	"	352	376	790	"	"	"	"	"	"
"	200	"	17.8	"	225.8	"	377	382	810	"	"	"	"	"	"
"	250	"	"	"	273.0	70	412	399	840	"	"	"	"	"	"
"	300	"	"	"	330.2	"	437	426	860	120	"	"	"	"	"
"	350	"	"	"	382.4	"	462	432	890	"	"	"	"	"	"
400	100	19.0	16.0	434.6	121.4	60	334	395	760	"	100	25.0	30	"	291.0
"	125	"	"	"	147.6	"	346	397	770	"	"	"	"	"	"
"	150	"	17.0	"	173.6	"	359	401	790	"	"	"	"	"	"
"	200	"	18.0	"	225.8	70	394	417	810	"	"	"	"	"	"
"	250	"	19.0	"	273.0	"	419	424	840	"	"	"	"	"	"
"	300	"	"	"	330.2	80	454	461	860	"	"	"	"	"	"
"	350	"	"	"	382.4	"	479	467	890	120	"	"	"	"	"
"	400	"	"	"	434.6	90	514	487	910	"	"	"	"	"	"

管 鈎		枝		管		鈎		重量	公稱內徑						
R ₄	R ₃	ボルト孔 d' 數	t ₁	k	m	r ₅	r ₄		r ₃	ボルト孔 d' 數	D	d			
84.0	62.5	18	4	16.2	21	3	105.5	84.0	62.5	18	4	34.1	75	75	
97.5	76.0	"	"	16.8	"	"	"	"	"	"	"	"	43.3	100	"
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	"	46.6	"	100
110.0	88.5	"	6	17.4	21	"	105.5	84.0	62.5	"	"	"	52.8	125	75
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	"	56.4	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	59.3	"	125
123.5	102.0	"	"	18.0	21	"	105.5	84.0	62.5	"	4	"	63.8	150	75
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	"	67.4	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	70.2	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	"	73.5	"	150
149.5	123.0	"	8	19.2	22	"	119.0	97.5	76.0	"	4	"	91.7	200	100
"	"	"	"	"	"	"	131.5	100.0	88.5	"	6	"	95.2	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	"	101.0	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	"	109.0	"	200
180.0	154.0	21	"	20.4	22	"	119.0	97.5	76.0	"	4	"	123.0	250	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	128.0	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	"	133.0	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	"	143.0	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	"	155.0	"	250
207.0	181.0	"	10	21.0	22	"	119.0	97.5	76.0	18	4	"	157.0	300	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	164.0	"	125
"	"	"	"	21.6	23	"	145.0	123.5	102.0	"	"	"	170.0	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	"	181.0	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	"	197.0	"	250
"	"	"	"	22.6	27	4	232.0	207.0	181.0	"	10	"	214.0	"	300
236.0	207.0	24	"	21.0	22	3	119.0	97.5	76.0	18	4	"	197.0	350	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	202.0	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	"	210.0	"	150
"	"	"	"	22.8	24	"	171.0	149.5	128.0	"	8	"	223.0	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	"	241.0	"	250
"	"	"	"	23.8	27	4	232.0	207.0	181.0	"	10	"	258.0	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	"	276.0	"	350
262.0	233.0	"	12	21.0	22	3	119.0	97.5	76.0	18	4	"	237.0	400	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	243.0	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	"	252.0	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	"	269.0	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	"	288.0	"	250
"	"	"	"	25.0	27	4	232.0	207.0	181.0	"	10	"	308.0	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	"	328.0	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	"	350.0	"	400

二 銔 丁 字 管

公稱內徑		管 厚		實 外 徑		R	管 長					本			
D	d	T	t	D ₂	d ₂		B	I	J	L ₂	L ₁	T ₁	K	M	R ₃
450	100	20.2	16.0	486.8	121.4	60	340	420	770	120	100	26.2	31	4	326°0
	125	"	"	"	147.6	"	352	422	780	"	"	"	"	"	"
	150	"	17.0	"	173.6	70	375	436	790	"	"	"	"	"	"
	200	"	18.0	"	225.8	"	400	442	820	"	"	"	"	"	"
	250	"	19.0	"	278.0	80	435	459	840	"	"	"	"	"	"
	300	"	20.0	"	330.2	"	460	486	870	"	120	"	"	"	"
	350	"	20.2	"	382.4	"	485	492	890	"	"	"	"	"	"
	400	"	"	"	434.6	90	520	509	920	"	"	"	"	"	"
	450	"	"	"	486.8	"	545	515	940	"	"	"	"	"	"
500	100	21.5	16.0	539.0	121.4	60	346	445	770	"	100	27.5	32	"	353.0
	125	"	"	"	147.6	"	358	447	780	"	"	"	"	"	"
	150	"	17.0	"	173.6	70	381	461	790	"	"	"	"	"	"
	200	"	18.0	"	225.8	"	406	467	820	"	"	"	"	"	"
	250	"	19.0	"	278.0	80	441	484	840	"	"	"	"	"	"
	300	"	20.0	"	330.2	"	466	511	870	"	120	"	"	"	"
	350	"	21.0	"	382.4	"	491	517	890	"	"	"	"	"	"
	400	"	21.5	"	434.6	90	526	534	920	"	"	"	"	"	"
	450	"	"	"	486.8	"	551	540	940	"	"	"	"	"	"
500	"	"	"	539.0	100	561	556	970	"	"	"	"	"	"	
600	150	23.9	17.0	643.4	173.6	80	404	521	800	"	100	29.9	35	"	405.0
	200	"	18.0	"	225.8	"	429	527	820	"	"	"	"	"	"
	250	"	19.0	"	278.0	"	454	534	850	"	"	"	"	"	"
	300	"	20.0	"	330.2	90	489	571	870	"	120	"	"	"	"
	350	"	21.0	"	382.4	"	514	577	900	"	"	"	"	"	"
	400	"	23.0	"	434.6	"	539	584	920	"	"	"	"	"	"
	450	"	23.9	"	486.8	100	574	600	950	"	"	"	"	"	"
	500	"	"	"	539.0	"	599	606	970	"	"	"	"	"	"
	600	"	"	"	643.4	110	659	629	1020	"	"	"	"	"	"
700	150	26.3	17.0	747.8	173.6	80	420	570	800	"	100	32.3	38	"	464.0
	200	"	18.0	"	225.8	"	442	577	830	"	"	"	"	"	"
	250	"	19.0	"	278.0	90	477	594	850	"	"	"	"	"	"
	300	"	20.0	"	330.2	"	502	621	880	"	120	"	"	"	"
	350	"	21.0	"	382.4	"	527	627	900	"	"	"	"	"	"
	400	"	23.0	"	434.6	100	562	634	930	"	"	"	"	"	"
	450	"	24.0	"	486.8	"	587	650	950	"	"	"	"	"	"
	500	"	25.0	"	539.0	"	612	656	980	"	"	"	"	"	"
	600	"	26.3	"	643.4	110	672	679	1030	"	"	"	"	"	"
700	"	"	"	747.8	"	722	692	1080	"	"	"	"	"	"	
800	150	28.7	17.0	852.2	173.6	80	451	621	810	140	100	35.7	41	5	517.0
	200	"	18.0	"	225.8	"	476	627	830	"	"	"	"	"	"
	250	"	19.0	"	278.0	90	511	644	860	"	"	"	"	"	"
	300	"	20.0	"	330.2	"	536	651	880	"	120	"	"	"	"
	350	"	21.0	"	382.4	"	566	677	910	"	"	"	"	"	"
	400	"	23.0	"	434.6	100	596	694	930	"	"	"	"	"	"
	450	"	24.0	"	486.8	"	621	700	960	"	"	"	"	"	"

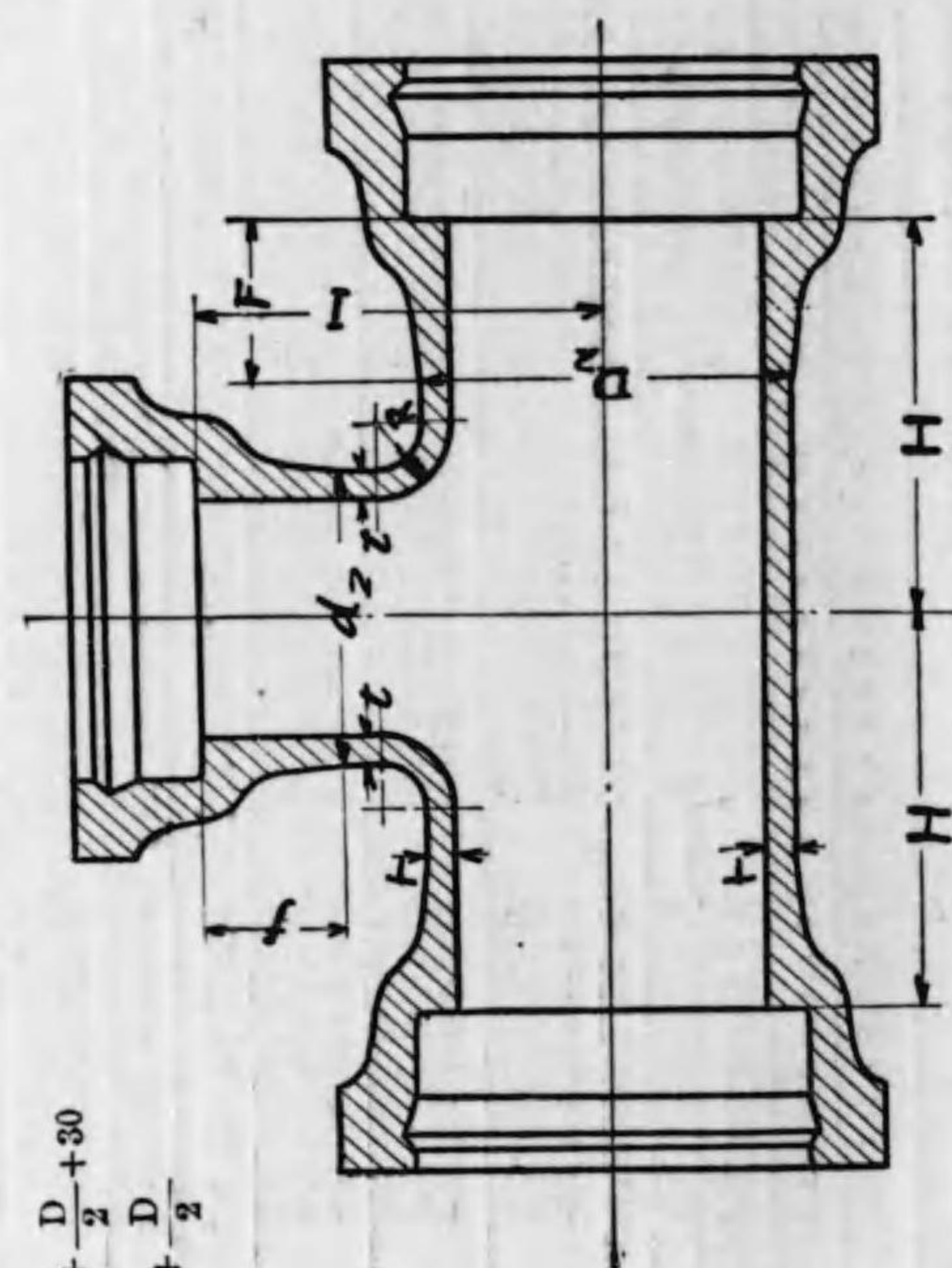
管 銔		枝 管					銔		重量	公稱內徑				
R ₁	R ₃	ボルト孔 d' 數	t ₁	k m	r ₅	r ₄	r ₃	ボルト孔 d 數		D	d			
292.5	259.0	27	12	21.0	22	3	119.0	97.5	76.0	18	4	286	450	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	293	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	304	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	321	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	343	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	367	"	300
"	"	"	"	26.2	28	"	265.0	236.0	207.0	24	"	386	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	412	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	27	"	435	"	450
319.5	286.0	"	"	21.0	22	3	119.0	97.5	76.0	18	4	336	500	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	343	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	355	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	374	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	398	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	424	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	447	"	350
"	"	"	"	27.5	30	"	291.0	262.0	233.0	"	12	476	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	27	"	501	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	525	"	500
371.5	338.0	"	16	22.0	23	3	145.0	123.5	102.0	18	6	468	600	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	487	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	515	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	545	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	575	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	603	"	400
"	"	"	"	29.9	31	"	326.0	292.5	259.0	27	"	643	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	670	"	500
"	"	"	"	"	35	"	405.0	371.5	338.0	"	16	733	"	600
427.0	390.0	30	"	22.0	23	3	145.0	123.5	102.0	18	6	612	700	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	639	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	672	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	706	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	736	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	777	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	813	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	851	"	500
"	"	"	"	32.3	35	"	405.0	371.5	338.0	"	16	930	"	600
"	"	"	"	"	38	"	464.0	427.0	390.0	30	"	1000	"	700
480.0	443.0	"	20	22.0	23	3	145.0	123.5	102.0	18	6	784	800	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	813	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	856	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	888	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	933	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	974	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1020	"	450

二 鐔 丁 字 管

公稱內徑	管厚	實外徑		R	管 長					本					
		D ₂	d ₂		B	I	J	L ₂	l ₂	T ₁	K	M	R ₅		
D	a	T	t	D ₂	d ₂	B	I	J	L ₂	l ₂	T ₁	K	M	R ₅	
800	500	28.7	25.0	852.2	539.0	110	646	716	980	140	120	35.7	41	5	517.0
"	600	"	27.0	"	643.4	"	706	729	1030	"	"	"	"	"	"
"	700	"	28.7	"	747.8	120	756	752	1080	"	"	"	"	"	"
"	800	"	"	"	852.2	"	816	786	1130	"	140	"	"	"	"
500	200	31.1	18.0	956.6	225.8	90	469	637	840	"	100	38.1	44	"	578.0
"	250	"	19.0	"	278.0	"	524	694	860	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	549	721	890	"	120	"	"	"	"
"	350	"	21.0	"	382.4	100	584	737	910	"	"	"	"	"	"
"	400	"	23.0	"	434.6	"	609	744	940	"	"	"	"	"	"
"	450	"	24.0	"	486.8	110	644	760	960	"	"	"	"	"	"
"	500	"	25.0	"	539.0	"	669	766	990	"	"	"	"	"	"
"	600	"	27.0	"	643.4	120	729	789	1040	"	"	"	"	"	"
"	700	"	29.0	"	747.8	"	779	802	1090	"	"	"	"	"	"
"	800	"	31.1	"	852.2	130	839	846	1140	"	140	"	"	"	"
"	900	"	"	"	956.6	"	889	859	1190	"	"	"	"	"	"
1000	300	33.6	20.0	1061.0	330.2	100	571	781	890	"	120	40.6	46	"	631.0
"	350	"	21.0	"	382.4	"	596	787	920	"	"	"	"	"	"
"	400	"	23.0	"	434.6	110	631	804	940	"	"	"	"	"	"
"	450	"	24.0	"	486.8	"	656	810	970	"	"	"	"	"	"
"	500	"	25.0	"	539.0	120	691	826	990	"	"	"	"	"	"
"	600	"	27.0	"	643.4	"	731	839	1040	"	"	"	"	"	"
"	700	"	29.0	"	747.8	130	801	862	1090	"	"	"	"	"	"
"	800	"	31.0	"	852.2	"	851	896	1140	"	140	"	"	"	"
"	900	"	33.6	"	956.6	140	911	919	1190	"	"	"	"	"	"
"	1000	"	"	"	1061.0	"	961	931	1240	"	"	"	"	"	"
1100	400	36.0	23.0	1165.4	434.6	110	644	854	950	"	120	43.0	49	"	683.0
"	450	"	24.0	"	486.8	"	669	860	970	"	"	"	"	"	"
"	500	"	25.0	"	539.0	120	704	866	1000	"	"	"	"	"	"
"	600	"	27.0	"	643.4	"	754	889	1050	"	"	"	"	"	"
"	700	"	29.0	"	747.8	130	814	912	1100	"	"	"	"	"	"
"	800	"	31.0	"	852.2	"	864	946	1150	"	140	"	"	"	"
"	900	"	34.0	"	956.6	140	924	969	1200	"	"	"	"	"	"
"	1000	"	36.0	"	1061.0	"	974	981	1250	"	"	"	"	"	"
"	1100	"	"	"	1165.4	150	1034	1004	1300	"	"	"	"	"	"
1200	400	38.4	23.0	1269.8	434.6	110	657	904	950	"	120	45.4	52	"	735.0
"	450	"	24.0	"	486.8	120	692	920	970	"	"	"	"	"	"
"	500	"	25.0	"	539.0	"	717	926	1000	"	"	"	"	"	"
"	600	"	27.0	"	643.4	130	777	949	1050	"	"	"	"	"	"
"	700	"	29.0	"	747.8	"	827	962	1100	"	"	"	"	"	"
"	800	"	31.0	"	852.2	140	887	1006	1150	"	140	"	"	"	"
"	900	"	34.0	"	956.6	"	937	1019	1200	"	"	"	"	"	"
"	1000	"	36.0	"	1061.0	150	994	1041	1250	"	"	"	"	"	"
"	1100	"	38.4	"	1165.4	"	1047	1054	1300	"	"	"	"	"	"
"	1200	"	"	"	1269.8	"	1097	1067	1350	"	"	"	"	"	"

管		鐔		枝		管		鐔		重量		公稱內徑	
R ₄	R ₃	$\frac{R}{d'}$	數	t ₁	k	m	r ₅	r ₄	r ₃	$\frac{R}{d'}$	數	D	d
480.0	443.0	30	20	31.0	32	4	353.0	319.5	286.0	27	12	1060	800
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1150	"
"	"	"	"	34.7	38	"	464.0	427.0	390.0	30	"	1250	"
"	"	"	"	35.7	41	5	517.0	480.0	443.0	"	20	1360	"
536.5	495.0	35	"	23.0	24	3	171.0	149.5	128.0	18	8	990	900
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	1030	"
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	1070	"
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1120	"
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1160	"
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1210	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1260	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1360	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1460	"
"	"	"	"	38.1	41	5	517.0	480.0	443.0	"	20	1600	"
"	"	"	"	"	44	"	578.0	536.5	495.0	35	"	1710	"
589.5	548.0	"	24	26.0	27	4	232.0	207.0	181.0	21	10	1310	1000
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1360	"
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1420	"
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1470	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1530	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1620	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1760	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	1900	"
"	"	"	"	40.6	44	"	578.0	536.5	495.0	35	"	2060	"
"	"	"	"	"	46	"	631.0	589.5	548.0	"	24	2180	"
641.5	600.0	"	"	29.0	30	4	291.0	262.0	233.0	24	12	1670	1100
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1720	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1790	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1910	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2050	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2190	"
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2370	"
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2520	"
"	"	"	"	"	49	"	683.0	641.5	600.0	"	"	2680	"
693.5	652.0	"	28	29.0	30	4	291.0	262.0	233.0	24	12	1940	1200
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	2020	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	2080	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	2220	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2370	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2540	"
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2710	"
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2890	"
"	"	"	"	45.4	49	"	683.0	641.5	600.0	"	"	3080	"
"	"	"	"	"	52	"	735.0	693.5	652.0	"	28	3240	"

第四號丁字管
第三表三承丁字管



$$H = F + \frac{d}{10} + R + \frac{D}{2} + 30$$

$$I = t + \frac{d}{10} + R + \frac{D}{2}$$

承口寸法ハ直管ニ同シ

三承丁字管

公稱內徑 D	管厚 d	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
75	75	11.2	11.2	95.4	95.4	50	200	170	34.0
100	"	11.8	11.8	121.4	"	"	"	180	42.0
"	100	"	"	"	121.4	"	210	"	45.7
125	75	12.4	12.4	147.6	95.4	"	"	190	50.0
"	100	"	"	"	121.4	"	230	200	54.2
"	125	"	"	"	147.6	"	230	"	57.6
150	75	13.0	13.0	173.6	95.4	"	210	"	60.5
"	100	"	"	"	121.4	"	220	210	64.9
"	125	"	"	"	147.6	"	230	"	68.4
"	150	"	"	"	173.6	"	250	220	74.3
200	100	14.2	14.2	225.8	121.4	"	230	230	85.9
"	125	"	"	"	147.6	"	240	240	90.3
"	150	"	"	"	173.6	60	260	250	97.6
"	200	"	"	"	225.8	"	290	260	109
250	100	15.4	15.4	278.0	121.4	50	240	"	113
"	125	"	"	"	147.6	60	260	270	120
"	150	"	"	"	173.6	"	270	280	127
"	200	"	"	"	225.8	"	300	"	139
"	250	"	"	"	278.0	"	320	290	153
300	100	16.6	16.0	330.2	121.4	50	240	280	137
"	125	"	"	"	147.6	60	260	300	145
"	150	"	16.6	"	173.6	"	280	"	154
"	200	"	"	"	225.8	"	300	310	166
"	250	"	"	"	278.0	70	340	330	187
"	300	"	"	"	330.2	"	360	"	200
350	100	17.8	16.0	382.4	121.4	60	260	320	173
"	125	"	"	"	147.6	"	270	"	179
"	150	"	17.0	"	173.6	"	280	330	187
"	200	"	17.8	"	225.8	"	310	"	203
"	250	"	"	"	278.0	70	340	350	223
"	300	"	"	"	330.2	"	370	360	240
"	350	"	"	"	382.4	"	390	"	257
400	100	19.0	16.0	434.6	121.4	60	270	340	215
"	125	"	"	"	147.6	"	280	350	222
"	150	"	17.0	"	173.6	"	300	"	233
"	200	"	18.0	"	225.8	70	330	370	252
"	250	"	19.0	"	278.0	"	350	380	271
"	300	"	"	"	330.2	80	390	390	294
"	350	"	"	"	382.4	"	410	400	313
"	400	"	"	"	434.6	90	450	420	344

三承丁字管

公稱內徑 D	管厚 d	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
450	100	20.2	16.0	486.8	121.4	60	270	370	255
	125	"	"	"	147.6	"	290	"	266
	150	"	17.0	"	173.6	70	310	390	280
	200	"	18.0	"	225.8	"	330	"	295
	250	"	19.0	"	278.0	80	370	410	324
	300	"	20.0	"	330.2	"	390	420	343
	350	"	20.2	"	382.4	"	420	"	366
	400	"	"	"	434.6	90	450	440	396
450	"	"	"	486.8	"	480	450	424	
500	100	21.5	16.0	539.0	121.4	60	280	390	300
	125	"	"	"	147.6	"	300	400	313
	150	"	17.0	"	173.6	70	320	410	328
	200	"	18.0	"	225.8	"	340	420	345
	250	"	19.0	"	278.0	80	380	440	377
	300	"	20.0	"	330.2	"	400	"	395
	350	"	21.0	"	382.4	"	430	450	423
	400	"	21.5	"	434.6	90	460	470	457
	450	"	"	"	486.8	"	490	"	490
	500	"	"	"	539.0	100	520	490	518
600	150	23.9	17.0	643.4	173.6	80	340	470	436
	200	"	18.0	"	225.8	"	370	480	467
	250	"	19.0	"	278.0	"	390	490	490
	300	"	20.0	"	330.2	90	430	500	525
	350	"	21.0	"	382.4	"	450	510	551
	400	"	23.0	"	434.6	"	480	520	589
	450	"	23.9	"	486.8	100	510	530	626
	500	"	"	"	539.0	"	540	540	661
	600	"	"	"	643.4	110	600	570	740
	700	150	26.3	17.0	747.8	173.6	80	350	520
200		"	18.0	"	225.8	"	380	530	604
250		"	19.0	"	278.0	90	410	550	641
300		"	20.0	"	330.2	"	440	"	674
350		"	21.0	"	382.4	"	460	560	702
400		"	23.0	"	434.6	100	500	580	756
450		"	24.0	"	486.8	"	520	"	787
500		"	25.0	"	539.0	"	550	600	833
600		"	26.3	"	643.4	110	610	620	925
700		"	"	"	747.8	"	660	630	1000
800	150	23.7	17.0	852.2	173.6	80	370	570	735
	200	"	18.0	"	225.8	"	390	580	763
	250	"	19.0	"	278.0	90	430	600	816
	300	"	20.0	"	330.2	"	450	"	844
	350	"	21.0	"	382.4	"	480	610	887

三承丁字管

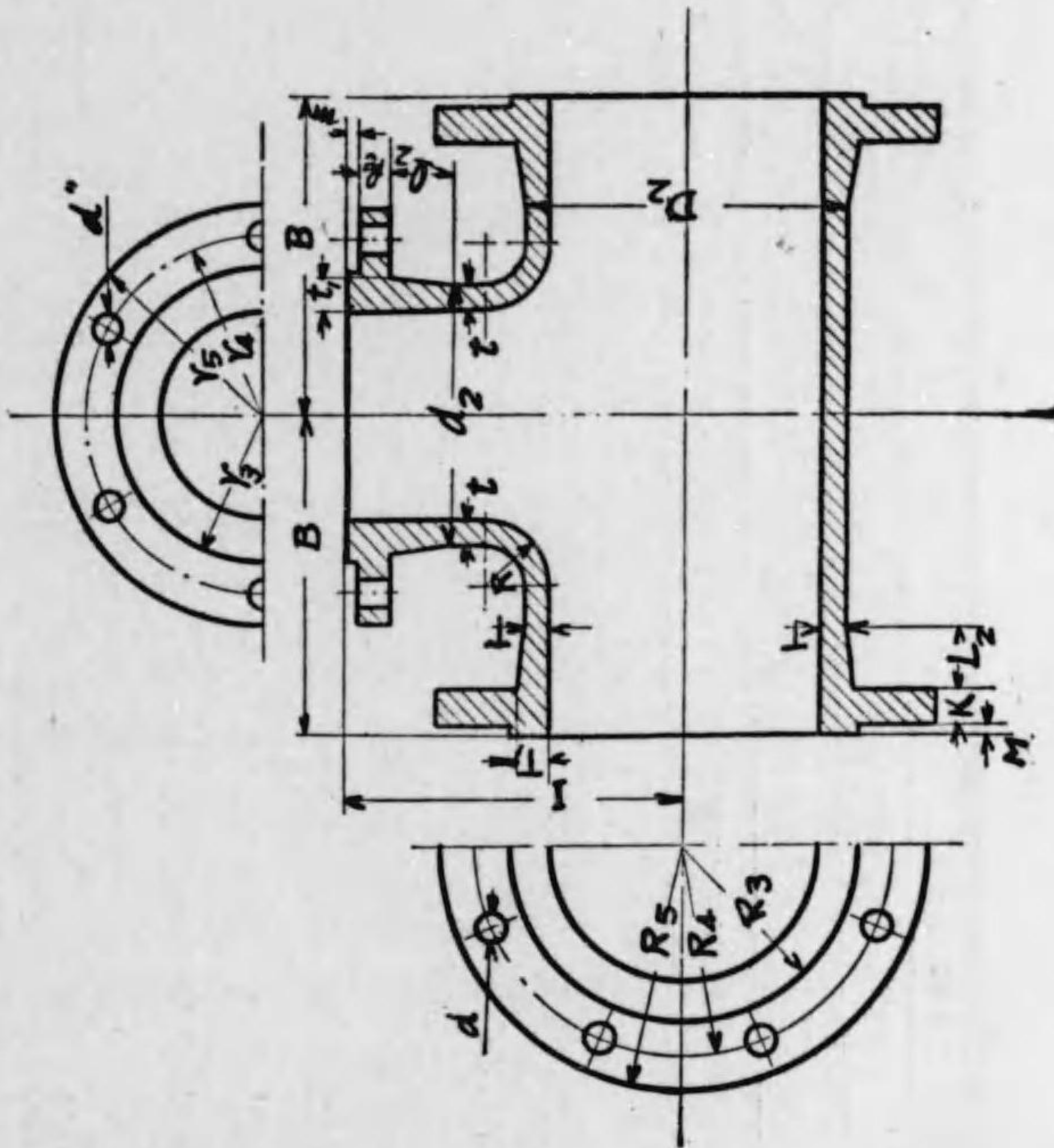
公稱內徑 D	管厚 d	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
800	400	23.7	23.0	852.2	434.6	100	510	630	937
	450	"	24.0	"	486.8	"	540	"	982
	500	"	25.0	"	539.0	110	570	650	1030
	600	"	27.0	"	643.4	"	620	670	1130
	700	"	28.7	"	747.8	120	680	690	1240
	800	"	"	"	852.2	"	730	700	1350
900	200	31.1	18.0	956.6	225.8	90	420	640	977
	250	"	19.0	"	278.0	"	440	650	1010
	300	"	20.0	"	330.2	"	470	"	1060
	350	"	21.0	"	382.4	100	500	670	1110
	400	"	23.0	"	434.6	"	530	680	1160
	450	"	24.0	"	486.8	110	560	690	1220
	500	"	25.0	"	539.0	"	590	700	1270
	600	"	27.0	"	643.4	120	650	730	1390
	700	"	29.0	"	747.8	"	700	740	1500
	800	"	31.1	"	852.2	130	760	760	1640
900	"	"	"	956.6	"	810	780	1770	
1000	300	33.6	20.0	1061.0	330.2	100	500	710	1310
	350	"	21.0	"	382.4	"	520	720	1350
	400	"	23.0	"	434.6	110	550	740	1420
	450	"	24.0	"	486.8	"	580	"	1470
	500	"	25.0	"	539.0	120	610	760	1540
	600	"	27.0	"	643.4	"	660	780	1650
	700	"	29.0	"	747.8	130	720	800	1790
	800	"	31.0	"	852.2	"	770	810	1920
	900	"	33.6	"	956.6	140	830	840	2110
	1000	"	"	"	1061.0	"	880	850	2250
1100	400	36.0	23.0	1165.4	434.6	110	570	790	1690
	450	"	24.0	"	486.8	"	600	"	1750
	500	"	25.0	"	539.0	120	630	810	1830
	600	"	27.0	"	643.4	"	680	830	1950
	700	"	29.0	"	747.8	130	740	850	2100
	800	"	31.0	"	852.2	"	790	860	2240
	900	"	34.0	"	956.6	140	850	890	2440
	1000	"	36.0	"	1061.0	"	900	900	2610
	1100	"	"	"	1165.4	150	960	930	2800
	1200	400	38.4	23.0	1269.8	434.6	110	580	840
450		"	24.0	"	486.8	120	610	850	2070
500		"	25.0	"	539.0	"	640	860	2140
600		"	27.0	"	643.4	130	700	890	2310

三承丁字管

公稱内徑 D	管厚 d	管厚		實外徑		R	管長		重量
		T	t	D ₂	d ₂		H	I	
1200	700	33.4	29.0	1269.8	747.8	130	750	900	2450
"	800	"	31.0	"	852.2	140	810	920	2630
"	900	"	34.0	"	956.6	"	860	940	2810
"	1000	"	36.0	"	1061.0	150	920	960	3020
"	1100	"	38.4	"	1165.4	"	970	980	3220
"	1200	"	"	"	1269.8	"	1020	990	3520

第四號丁字管

第四表 三銜丁字管



$$B = L_1 + M + K + \frac{D}{10} + R + \frac{d}{2} + 30$$

$$I = l_1 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$T_1 = T + a$$

$$t_1 = t + a$$

銜ノ寸法ハ直管=同シ

「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ
水平ニ爲シタル場合ニ其ノ銜面ノ垂直
中心線ニ對シ振分トス

三銲丁字管

公稱內徑		管 厚		實 外 徑		R	管 長				本			
D	d	T	t	D ₂	d ₂		B	I	L ₂	l ₂	T ₁	K	M	R ₃
75	75	11.2	11.2	95.4	95.4	50	249	219	100	100	16.2	21	3	105.5
100	100	11.8	11.8	121.4	121.4	"	252	231	"	"	16.8	22	"	119.0
"	"	"	"	"	"	"	265	235	"	"	"	"	"	"
125	75	12.4	12.4	147.6	95.4	"	255	244	"	"	17.4	"	"	131.5
"	100	"	"	"	121.4	"	267	247	"	"	"	"	"	"
"	125	"	"	"	147.6	"	280	250	"	"	"	"	"	"
150	75	13.0	13.0	173.6	95.4	"	253	256	"	"	18.0	23	"	145.0
"	100	"	"	"	121.4	"	271	260	"	"	"	"	"	"
"	125	"	"	"	147.6	"	284	262	"	"	"	"	"	"
"	150	"	"	"	173.6	"	296	266	"	"	"	"	"	"
200	100	14.2	14.2	225.8	121.4	"	277	285	"	"	19.2	24	"	171.0
"	125	"	"	"	147.6	"	289	287	"	"	"	"	"	"
"	150	"	"	"	173.6	60	312	301	"	"	"	"	"	"
"	200	"	"	"	225.8	"	337	307	"	"	"	"	"	"
250	100	15.4	15.4	278.0	121.4	50	284	310	"	"	20.4	26	"	205.0
"	125	"	"	"	147.6	60	306	322	"	"	"	"	"	"
"	150	"	"	"	173.6	"	319	326	"	"	"	"	"	"
"	200	"	"	"	225.8	"	340	332	"	"	"	"	"	"
"	250	"	"	"	278.0	"	369	339	"	"	"	"	"	"
300	100	16.6	16.0	330.2	121.4	50	311	335	120	"	22.6	27	4	232.0
"	125	"	"	"	147.6	60	333	347	"	"	"	"	"	"
"	150	"	16.6	"	173.6	"	346	351	"	"	"	"	"	"
"	200	"	"	"	225.8	"	371	357	"	"	"	"	"	"
"	250	"	"	"	278.0	70	406	374	"	"	"	"	"	"
"	300	"	"	"	330.2	"	431	401	"	120	"	"	"	"
350	100	17.8	16.0	382.4	121.4	60	327	370	"	100	23.8	28	"	265.0
"	125	"	"	"	147.6	"	339	372	"	"	"	"	"	"
"	150	"	17.0	"	173.6	"	352	376	"	"	"	"	"	"
"	200	"	17.8	"	225.8	"	377	382	"	"	"	"	"	"
"	250	"	"	"	278.0	70	412	399	"	"	"	"	"	"
"	300	"	"	"	330.2	"	437	426	"	120	"	"	"	"
"	350	"	"	"	382.4	"	462	432	"	"	"	"	"	"
400	100	19.0	16.0	434.6	121.4	60	334	395	"	100	25.0	30	"	291.0
"	125	"	"	"	147.6	"	346	397	"	"	"	"	"	"
"	150	"	17.0	"	173.6	"	359	401	"	"	"	"	"	"
"	200	"	18.0	"	225.8	70	394	417	"	"	"	"	"	"
"	250	"	19.0	"	278.0	"	419	424	"	"	"	"	"	"
"	300	"	"	"	330.2	80	454	461	"	120	"	"	"	"
"	350	"	"	"	382.4	"	479	467	"	"	"	"	"	"
"	400	"	"	"	434.6	90	514	487	"	"	"	"	"	"

管 銲		枝 管 銲		重量	公稱內徑										
R ₄	R ₃	ボルト孔 d' 數	t ₁		k	m	r ₅	r ₄	r ₃	ボルト孔 d' 數	D	d			
84.0	62.5	18	4	16.2	21	3	105.5	84.0	62.5	18	4	28.5	75	75	
97.5	76.0	"	"	16.8	"	"	"	"	"	"	"	"	35.1	100	"
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	"	38.2	"	100
110.0	88.5	"	6	17.4	21	"	105.5	84.0	62.5	"	"	"	41.3	125	75
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	"	44.6	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	47.6	"	125
125.0	102.0	"	"	18.0	21	"	105.5	84.0	62.5	"	4	"	48.7	150	75
"	"	"	"	"	22	"	119.0	97.5	76.0	"	"	"	52.8	"	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	55.5	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	"	58.5	"	150
149.5	128.0	"	8	19.2	22	"	119.0	97.5	76.0	"	4	"	69.5	200	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	73.2	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	"	79.0	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	"	87.5	"	200
180.0	154.0	21	"	20.4	22	"	119.0	97.5	76.0	"	4	"	93.3	250	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	99.9	"	125
"	"	"	"	"	23	"	145.0	123.5	102.0	"	"	"	105	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	"	115	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	"	127	"	250
207.0	181.0	"	10	21.0	22	"	119.0	97.5	76.0	18	4	"	123	300	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	131	"	125
"	"	"	"	21.6	23	"	145.0	123.5	102.0	"	"	"	137	"	150
"	"	"	"	"	24	"	171.0	149.5	128.0	"	8	"	148	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	"	165	"	250
"	"	"	"	22.6	27	4	232.0	207.0	181.0	"	10	"	182	"	300
236.0	207.0	24	"	21.0	22	3	119.0	97.5	76.0	18	4	"	157	350	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	162	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	"	169	"	150
"	"	"	"	22.8	24	"	171.0	149.5	128.0	"	8	"	183	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	"	202	"	250
"	"	"	"	23.8	27	4	232.0	207.0	181.0	"	10	"	220	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	"	237	"	350
262.0	233.0	"	12	21.0	22	3	119.0	97.5	76.0	18	4	"	189	400	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	"	195	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	"	203	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	"	222	"	200
"	"	"	"	"	26	"	205.0	180.0	154.0	21	"	"	236	"	250
"	"	"	"	25.0	27	4	232.0	207.0	181.0	"	10	"	263	"	300
"	"	"	"	"	28	"	265.0	236.0	207.0	24	"	"	282	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	"	306	"	400

三鍔丁字管

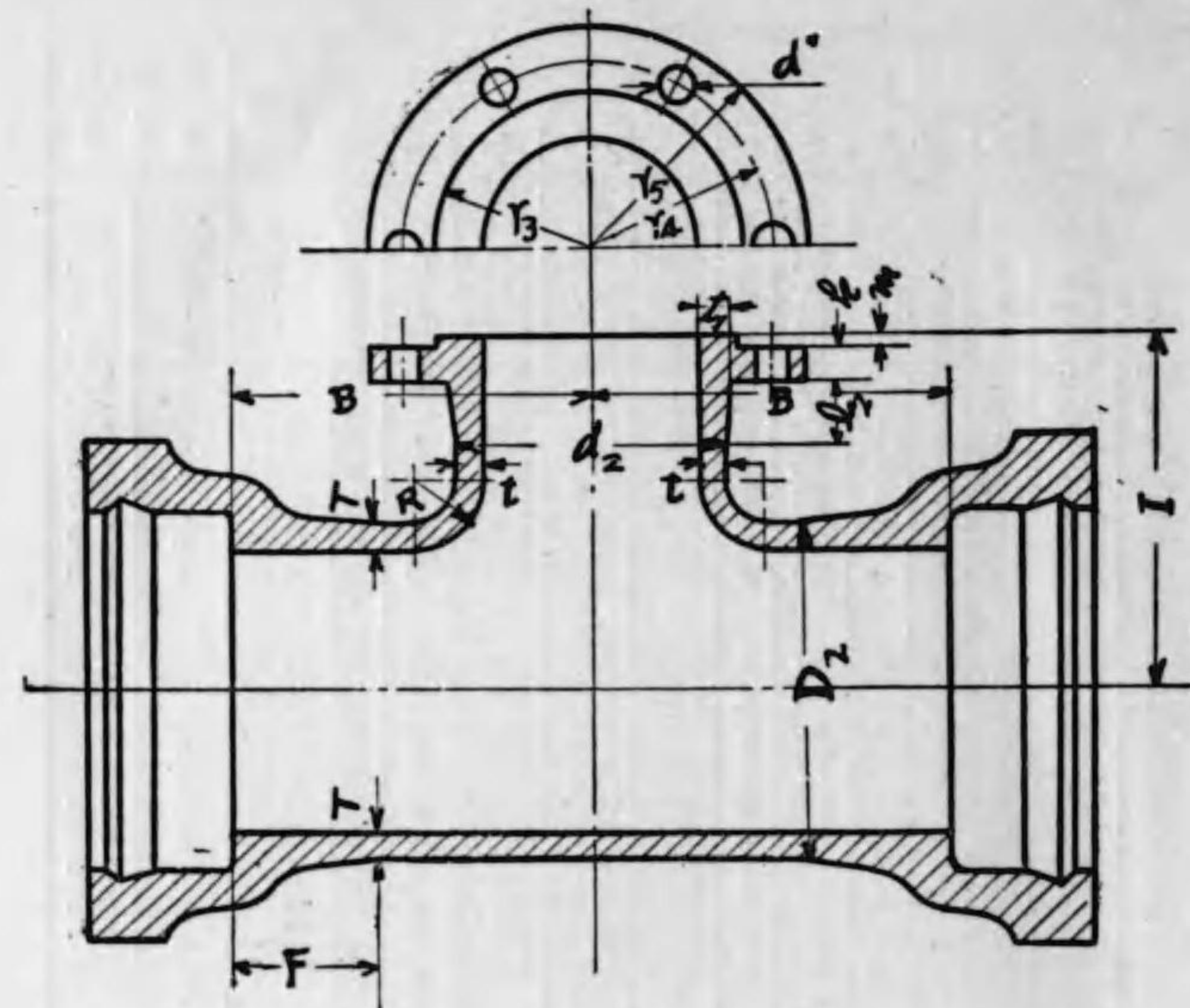
公稱內徑	管 厚		實 外 徑		R	管 長					本			
	D	d	T	t		D ₂	d ₂	B	I	L ₂	l ₁	T ₁	K	M
450	100	20.2	16.0	486.8	121.4	60	340	420	120	100	26.2	31	4	326.0
"	125	"	"	"	147.6	"	352	422	"	"	"	"	"	"
"	150	"	17.0	"	173.6	70	375	436	"	"	"	"	"	"
"	200	"	18.0	"	225.8	"	400	442	"	"	"	"	"	"
"	250	"	19.0	"	278.0	80	435	459	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	460	486	"	120	"	"	"	"
"	350	"	20.2	"	382.4	"	485	492	"	"	"	"	"	"
"	400	"	"	"	434.6	90	520	509	"	"	"	"	"	"
"	450	"	"	"	486.8	"	545	515	"	"	"	"	"	"
500	100	21.5	16.0	539.0	121.4	60	346	445	"	100	27.5	32	"	353.0
"	125	"	"	"	147.6	"	358	447	"	"	"	"	"	"
"	150	"	17.0	"	173.6	70	381	461	"	"	"	"	"	"
"	200	"	18.0	"	225.8	"	406	467	"	"	"	"	"	"
"	250	"	19.0	"	278.0	80	441	484	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	466	511	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	491	517	"	"	"	"	"	"
"	400	"	21.5	"	434.6	90	526	534	"	"	"	"	"	"
"	450	"	"	"	486.8	"	551	540	"	"	"	"	"	"
"	500	"	"	"	539.0	100	561	556	"	"	"	"	"	"
600	150	23.9	17.0	643.4	173.6	80	404	521	"	100	29.9	35	"	405.0
"	200	"	18.0	"	225.8	"	429	527	"	"	"	"	"	"
"	250	"	19.0	"	278.0	"	454	534	"	"	"	"	"	"
"	300	"	20.0	"	330.2	90	489	571	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	514	577	"	"	"	"	"	"
"	400	"	23.0	"	434.6	"	539	584	"	"	"	"	"	"
"	450	"	23.9	"	486.8	100	574	600	"	"	"	"	"	"
"	500	"	"	"	539.0	"	599	606	"	"	"	"	"	"
"	600	"	"	"	643.4	110	659	629	"	"	"	"	"	"
700	150	26.3	17.0	747.8	173.6	80	420	570	"	100	32.3	38	"	464.0
"	200	"	18.0	"	225.8	"	442	577	"	"	"	"	"	"
"	250	"	19.0	"	278.0	90	477	594	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	502	621	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	527	627	"	"	"	"	"	"
"	400	"	23.0	"	434.6	100	562	634	"	"	"	"	"	"
"	450	"	24.0	"	486.8	"	587	650	"	"	"	"	"	"
"	500	"	25.0	"	539.0	"	612	656	"	"	"	"	"	"
"	600	"	26.2	"	643.4	110	672	679	"	"	"	"	"	"
"	700	"	"	"	747.8	"	722	692	"	"	"	"	"	"
800	150	28.7	17.0	852.2	173.6	80	451	621	140	100	35.7	41	5	517.0
"	200	"	18.0	"	225.8	"	476	627	"	"	"	"	"	"
"	250	"	19.0	"	278.0	90	511	644	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	536	651	"	120	"	"	"	"
"	350	"	21.0	"	382.4	"	566	677	"	"	"	"	"	"
"	400	"	23.0	"	434.6	100	596	694	"	"	"	"	"	"
"	450	"	24.0	"	486.8	"	621	700	"	"	"	"	"	"
"	500	"	25.0	"	539.0	110	646	716	"	"	"	"	"	"
"	600	"	27.0	"	643.4	"	706	729	"	"	"	"	"	"
"	700	"	28.7	"	747.8	120	756	752	"	"	"	"	"	"
"	800	"	"	"	852.2	"	816	786	"	140	"	"	"	"

管 鍔		枝 管		鍔		重量	公稱內徑							
R ₄	R ₃	ボルト孔 d' 數	t ₁	k	m		r ₅	r ₄	r ₃	ボルト孔 d' 數	D	d		
292.5	259.0	27	12	21.0	22	3	119.0	97.5	76.0	18	4	230	450	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	237	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	250	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	266	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	291	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	314	"	300
"	"	"	"	26.2	28	"	265.0	236.0	207.0	24	"	334	"	350
"	"	"	"	"	30	"	291.0	262.0	233.0	"	12	362	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	27	"	386	"	450
319.5	286.0	"	"	21.0	22	3	119.0	97.5	76.0	18	4	269	500	100
"	"	"	"	"	"	"	131.5	110.0	88.5	"	6	277	"	125
"	"	"	"	22.0	23	"	145.0	123.5	102.0	"	"	292	"	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	310	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	337	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	362	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	386	"	350
"	"	"	"	27.5	30	"	291.0	262.0	233.0	"	12	417	"	400
"	"	"	"	"	31	"	326.0	292.5	259.0	27	"	443	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	462	"	500
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	462	"	500
371.5	338.0	"	16	22.0	23	3	145.0	123.5	102.0	18	6	388	600	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	409	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	434	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	470	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	498	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	528	"	400
"	"	"	"	29.9	31	"	326.0	292.5	259.0	27	"	569	"	450
"	"	"	"	"	32	"	353.0	319.5	286.0	"	"	595	"	500
"	"	"	"	"	35	"	405.0	371.5	338.0	"	16	664	"	600
"	"	"	"	"	35	"	405.0	371.5	338.0	"	16	664	"	600
427.0	390.0	30	"	22.0	23	3	145.0	123.5	102.0	18	6	516	700	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	540	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	579	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	611	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	643	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	686	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	725	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	760	"	500
"	"	"	"	32.3	35	"	405.0	371.5	338.0	"	16	843	"	600
"	"	"	"	"	38	"	464.0	427.0	390.0	30	"	917	"	700
"	"	"	"	"	38	"	464.0	427.0	390.0	30	"	917	"	700
480.0	443.0	"	20	22.0	23	3	145.0	123.5	102.0	18	6	680	800	150
"	"	"	"	23.0	24	"	171.0	149.5	128.0	"	8	712	"	200
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	759	"	250
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	793	"	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	838	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	885	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	926	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	969	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1060	"	600
"	"	"	"	34.7	38	"	464.0	427.0	390.0	30	"	1170	"	700
"	"	"	"	"	41	5	517.0	480.0	443.0	"	20	1280	"	800

三銑丁字管

公稱內徑 D	管 厚		實 外 徑		R	管 長				本				
	a	T	D ₂	d ₂		B	I	L ₁	L ₂	T ₁	K	M	R ₃	
900	200	31.1	18.0	956.6	225.8	90	469	687	140	100	38.1	44	5	578.0
"	250	"	19.0	"	278.0	"	524	694	"	"	"	"	"	"
"	300	"	20.0	"	330.2	"	549	721	"	120	"	"	"	"
"	350	"	21.0	"	382.4	100	584	737	"	"	"	"	"	"
"	400	"	23.0	"	434.6	"	609	744	"	"	"	"	"	"
"	450	"	24.0	"	486.8	110	644	760	"	"	"	"	"	"
"	500	"	25.0	"	539.0	"	669	766	"	"	"	"	"	"
"	600	"	27.0	"	643.4	120	729	789	"	"	"	"	"	"
"	700	"	29.0	"	747.8	"	779	802	"	"	"	"	"	"
"	800	"	31.1	"	852.2	130	839	846	"	140	"	"	"	"
"	900	"	"	"	956.6	"	889	859	"	"	"	"	"	"
1000	300	33.6	20.0	1061.0	330.2	100	571	781	"	120	49.6	46	"	631.0
"	350	"	21.0	"	382.4	"	596	787	"	"	"	"	"	"
"	400	"	23.0	"	434.6	110	631	804	"	"	"	"	"	"
"	450	"	24.0	"	486.8	"	656	810	"	"	"	"	"	"
"	500	"	25.0	"	539.0	120	691	826	"	"	"	"	"	"
"	600	"	27.0	"	643.4	"	731	839	"	"	"	"	"	"
"	700	"	29.0	"	747.8	130	801	862	"	"	"	"	"	"
"	800	"	31.0	"	852.2	"	851	896	"	140	"	"	"	"
"	900	"	33.6	"	956.6	140	911	916	"	"	"	"	"	"
"	1000	"	"	"	1061.0	"	961	931	"	"	"	"	"	"
1100	400	36.0	23.0	1165.4	434.6	110	644	854	"	120	43.0	49	"	683.0
"	450	"	24.0	"	486.8	"	669	860	"	"	"	"	"	"
"	500	"	25.0	"	539.0	120	704	866	"	"	"	"	"	"
"	600	"	27.0	"	643.4	"	754	889	"	"	"	"	"	"
"	700	"	29.0	"	747.8	130	814	912	"	"	"	"	"	"
"	800	"	31.0	"	852.2	"	864	946	"	140	"	"	"	"
"	900	"	34.0	"	956.6	140	924	969	"	"	"	"	"	"
"	1000	"	36.0	"	1061.0	"	974	981	"	"	"	"	"	"
"	1100	"	"	"	1165.4	150	1034	1004	"	"	"	"	"	"
1200	400	38.4	23.0	1269.8	434.6	110	657	904	"	120	45.4	52	"	735.0
"	450	"	24.0	"	486.8	120	692	920	"	"	"	"	"	"
"	500	"	25.0	"	539.0	"	717	926	"	"	"	"	"	"
"	600	"	27.0	"	643.4	130	777	949	"	"	"	"	"	"
"	700	"	29.0	"	747.8	"	827	962	"	"	"	"	"	"
"	800	"	31.0	"	852.2	140	887	1006	"	140	"	"	"	"
"	900	"	34.0	"	956.6	"	937	1019	"	"	"	"	"	"
"	1000	"	36.0	"	1061.0	150	994	1041	"	"	"	"	"	"
"	1100	"	38.4	"	1165.4	"	1047	1054	"	"	"	"	"	"
"	1200	"	"	"	1269.8	"	1097	1067	"	"	"	"	"	"

管 銑		孔		枝 管			管 銑			重量		公稱內徑	
R ₁	R ₃	孔數	d'	t ₁	k	m	r ₅	r ₄	r ₃	重量	D	d	
536.5	495.0	35	20	23.0	24	3	171.0	149.5	123.0	18	8	859	900
"	"	"	"	24.0	26	"	205.0	180.0	154.0	21	"	897	"
"	"	"	"	26.0	27	4	232.0	207.0	181.0	"	10	937	"
"	"	"	"	27.0	28	"	265.0	236.0	207.0	"	24	991	"
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1030	"
"	"	"	"	30.0	31	"	326.0	292.5	259.0	"	27	1090	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1130	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1240	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	"	30	1340	"
"	"	"	"	38.1	41	5	517.0	480.0	443.0	"	20	1480	"
"	"	"	"	"	44	"	578.0	536.5	495.0	"	35	1600	"
589.5	548.0	"	24	26.0	27	4	232.0	207.0	181.0	21	10	1190	1000
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1230	"
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1300	"
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1350	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1420	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1510	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1660	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	1800	"
"	"	"	"	40.6	44	"	578.0	536.5	495.0	"	35	1970	"
"	"	"	"	"	46	"	631.0	589.5	548.0	"	24	2090	"
641.5	600.0	"	"	29.0	30	4	291.0	262.0	233.0	24	12	1530	1100
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1590	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1660	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1780	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1930	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2080	"
"	"	"	"	41.0	44	"	578.0	536.5	495.0	"	35	2260	"
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2420	"
"	"	"	"	"	49	"	683.0	641.5	600.0	"	"	2590	"
693.5	652.0	"	28	29.0	30	4	291.0	262.0	233.0	24	12	1800	1200
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1880	"
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1950	"
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	2100	"
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2240	"
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2420	"
"	"	"	"	41.0	44	"	578.0	536.5	495.0	"	35	2590	"
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2800	"
"	"	"	"	45.4	49	"	683.0	641.5	600.0	"	"	2970	"
"	"	"	"	"	52	"	735.0	693.5	652.0	"	28	3140	"



二承一銲丁字管

公稱内徑		管厚		實徑		R	管長		
D	d	T	t	D ₂	d ₂		H	I	l _r
75	75	11.2	11.2	95.4	95.4	50	200	219	100
100	100	11.8	11.8	131.4	121.4	"	210	235	"
125	75	12.4	12.4	147.6	95.4	"	220	244	"
"	100	"	"	"	121.4	"	230	247	"
"	125	"	"	"	147.6	"	250	250	"
150	75	13.0	13.0	173.6	95.4	"	210	256	"
"	100	"	"	"	121.4	"	220	260	"
"	125	"	"	"	147.6	"	230	262	"
"	150	"	"	"	173.6	"	250	266	"

第四號丁字管

第五表 二承一銲丁字管

$$I = l_2 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$H = F + \frac{D}{10} + R + \frac{d}{2} + 30$$

銲及承口ノ寸法ハ直管ニ同シ

「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平

ニ爲シタル場合ニ其ノ銲面ノ垂直中心線ニ

對シ振分トス

枝		管			銲		重量	公稱内徑		
t ₁	k	m	r ₅	r ₄	r ₃	ボルト孔數		D	d	
16.2	21	3	150.5	84.0	62.5	18	4	32.2	75	75
16.8	22	"	119.0	97.5	76.0	"	"	40.3	100	"
"	"	"	"	"	"	"	"	43.2	"	100
17.4	21	"	105.5	84.0	62.5	"	"	48.4	125	75
"	22	"	119.0	97.5	76.0	"	"	51.5	"	100
"	"	"	131.5	110.0	88.5	"	6	54.3	"	125
18.0	21	"	105.5	84.0	62.5	"	4	59.0	150	75
"	22	"	119.0	97.5	76.0	"	"	62.0	"	100
"	"	"	131.5	110.0	88.5	"	6	64.9	"	125
"	23	"	145.0	123.5	102.0	"	"	68.7	"	150

二承一鍔丁字管

公稱內徑		管 厚		實 外 徑		R	管 長		
D	d	T	t	D ₂	d ₂		H	I	l ₂
200	100	14.2	14.2	225.8	121.4	50	230	285	100
	125	"	"	"	147.6	"	240	287	"
	150	"	"	"	173.6	60	260	301	"
	200	"	"	"	225.8	"	290	307	"
250	100	15.4	15.4	278.0	121.4	50	240	310	"
	125	"	"	"	147.6	60	260	322	"
	150	"	"	"	173.6	"	270	326	"
	200	"	"	"	225.8	"	300	332	"
250	"	"	"	278.0	"	320	339	"	
300	100	16.6	16.0	330.2	121.4	50	240	335	"
	125	"	16.6	"	147.6	60	260	347	"
	150	"	"	"	173.6	"	280	351	"
	200	"	"	"	225.8	"	300	357	"
	250	"	"	"	278.0	70	340	374	"
	300	"	"	"	330.2	"	360	401	120
350	100	17.8	16.0	382.4	121.4	60	260	370	100
	125	"	"	"	147.6	"	270	372	"
	150	"	17.0	"	173.6	"	280	376	"
	200	"	17.8	"	225.8	"	310	382	"
	250	"	"	"	278.0	70	340	399	"
	300	"	"	"	330.2	"	370	426	120
	350	"	"	"	382.4	"	390	432	"
400	100	19.0	16.0	434.6	121.4	60	270	395	100
	125	"	"	"	147.6	"	280	397	"
	150	"	17.0	"	173.6	"	300	401	"
	200	"	18.0	"	225.8	70	330	417	"
	250	"	19.0	"	278.0	"	350	424	"
	300	"	"	"	330.2	80	390	461	120
	350	"	"	"	382.4	"	410	467	"
	400	"	"	"	434.6	90	450	487	"
450	100	20.2	16.0	486.8	121.4	60	270	420	100
	125	"	"	"	147.6	"	290	422	"
	150	"	17.0	"	173.6	70	310	436	"
	200	"	18.0	"	225.8	"	330	442	"
	250	"	19.0	"	278.0	80	370	459	"
	300	"	20.0	"	330.2	"	390	486	120
	350	"	20.2	"	382.4	"	420	492	"
	400	"	"	"	434.6	90	450	500	"
	450	"	"	"	486.8	"	480	515	"
500	100	21.5	16.0	539.0	121.4	60	280	445	100
	125	"	"	"	147.6	"	300	447	"
	150	"	17.0	"	173.6	70	320	461	"

枝 管						鍔		重量	公稱內徑		
t ₁	k	m	r ₅	r ₄	r ₃	孔數	d ₁		D	d	
19.2	23	3	119.0	97.5	76.0	18	4	83.7	200	100	
	"	"	131.5	110.0	88.5	"	6	87.0		125	
	23	"	145.0	123.5	102.0	"	"	92.5		150	
	24	"	171.0	149.5	128.0	"	8	102		200	
20.4	22	"	119.0	97.5	76.0	"	4	111	250	100	
	"	"	131.5	110.0	88.5	"	6	117		125	
	23	"	145.0	123.5	102.0	"	"	122		150	
	24	"	171.0	149.5	128.0	"	8	133		200	
	26	"	205.0	180.0	154.0	21	"	144		250	
21.0	22	"	119.0	97.5	76.0	18	4	135	300	100	
	"	"	131.5	110.0	88.5	"	6	142		125	
	23	"	145.0	123.5	102.0	"	"	151		150	
	24	"	171.0	149.5	128.0	"	8	160		200	
	26	"	205.0	180.0	154.0	21	"	179		250	
	22.6	27	4	232.0	207.0	181.0	"	10		194	300
21.0	22	3	119.0	97.5	76.0	18	4	171	350	100	
	"	"	131.5	110.0	88.5	"	6	176		125	
	22.0	23	"	145.0	123.5	102.0	"	"		182	150
	22.8	24	"	171.0	149.5	128.0	"	8		197	200
	"	26	"	205.0	180.0	154.0	21	"		215	250
	23.8	27	4	232.0	207.0	181.0	"	10		234	300
	"	28	"	265.0	236.0	207.0	24	"		250	350
	21.0	22	3	119.0	97.5	76.0	18	4		213	400
"	"	"	131.5	110.0	88.5	"	6	219	125		
22.0	23	"	145.0	123.5	102.0	"	"	229	150		
23.0	24	"	171.0	149.5	128.0	"	8	246	200		
24.0	26	"	205.0	180.0	154.0	21	"	263	250		
25.0	27	4	232.0	207.0	181.0	"	10	288	300		
"	28	"	265.0	236.0	207.0	24	"	305	350		
"	30	"	291.0	262.0	233.0	"	12	331	400		
21.0	22	3	119.0	97.5	76.0	18	4	253	450	100	
	"	"	131.5	110.0	88.5	"	6	263		125	
	22.0	23	"	145.0	123.5	102.0	"	"		275	150
	23.0	24	"	171.0	149.5	128.0	"	8		290	200
	24.0	26	"	205.0	180.0	154.0	21	"		317	250
	26.0	27	4	232.0	207.0	181.0	"	10		337	300
	26.2	28	"	265.0	236.0	207.0	24	"		360	350
	"	30	"	291.0	262.0	233.0	"	12		385	400
	"	31	"	326.0	292.5	259.0	27	"		411	450
21.0	22	3	119.0	97.5	76.0	18	4	298	500	100	
	"	"	131.5	110.0	88.5	"	6	310		125	
	22.0	23	"	145.0	123.5	102.0	"	"		323	150

二承一銜丁字管

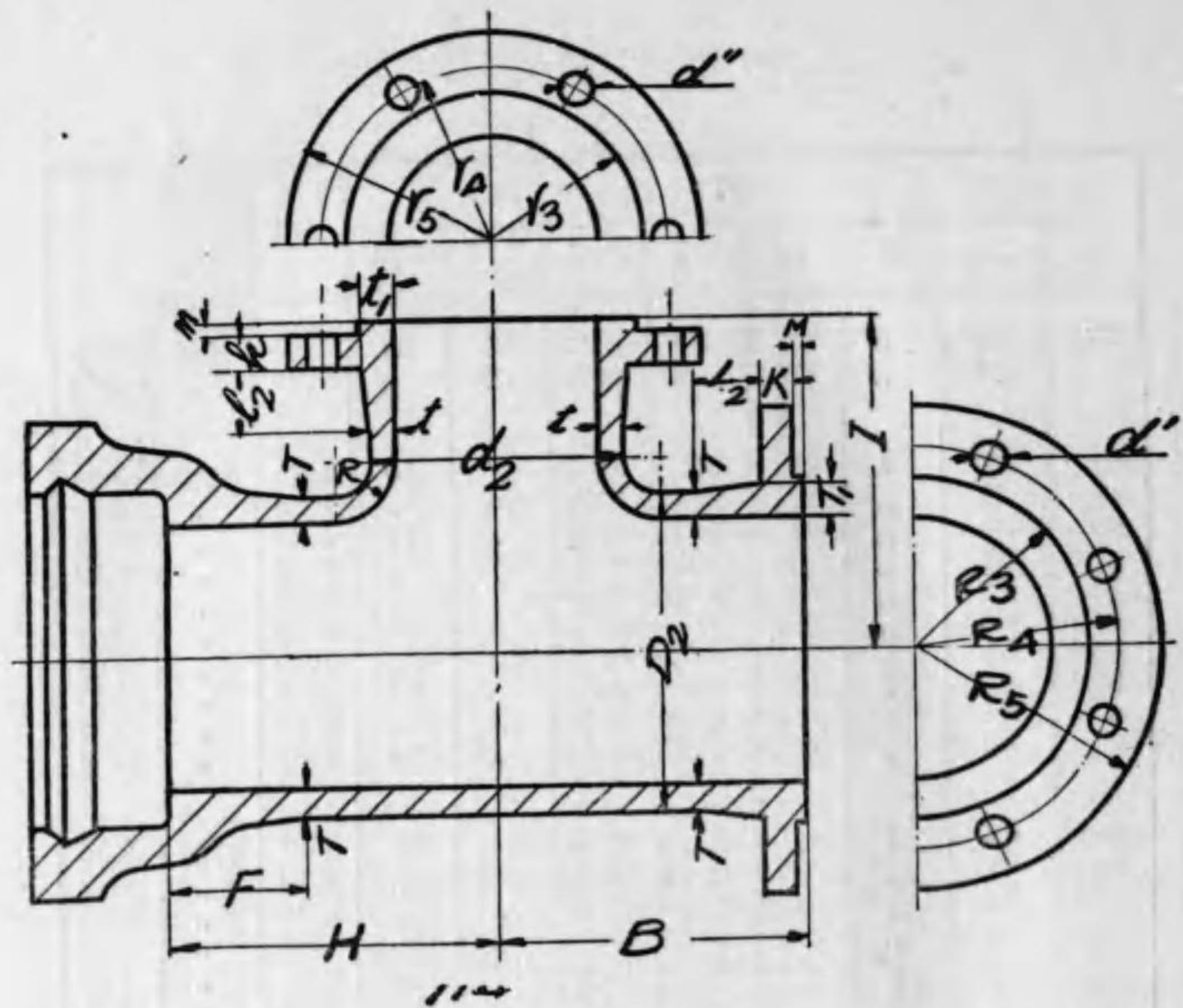
公稱內徑		管 厚		實 外 徑		R	管 長			
D	d	T	t	D ₂	d ₂		H	I	l ₂	
500	200	21.5	18.0	539.0	225.8	70	340	467	100	
	250	"	19.0	"	278.0	80	330	484	"	
	300	"	20.0	"	330.2	"	400	511	120	
	350	"	21.0	"	382.4	"	430	517	"	
	400	"	21.5	"	434.6	90	460	534	"	
	450	"	"	"	486.8	"	490	540	"	
"	500	"	"	539.0	100	520	556	"		
600	150	23.9	17.0	643.4	173.6	80	340	521	100	
	200	"	18.0	"	225.8	"	370	527	"	
	250	"	19.0	"	278.0	"	390	534	"	
	300	"	20.0	"	330.2	90	430	571	120	
	350	"	21.0	"	382.4	"	450	577	"	
	400	"	23.0	"	434.6	"	480	584	"	
	450	"	23.9	"	486.8	100	510	600	"	
	500	"	"	"	539.0	"	540	606	"	
	"	600	"	"	643.4	110	600	629	"	
	"	700	"	"	747.8	"	660	692	"	
700	150	26.3	17.0	747.8	173.6	80	350	570	100	
	200	"	18.0	"	225.8	"	380	577	"	
	250	"	19.0	"	278.0	90	410	594	"	
	300	"	20.0	"	330.2	"	440	621	120	
	350	"	21.0	"	382.4	"	460	627	"	
	400	"	23.0	"	434.6	100	500	634	"	
	450	"	24.0	"	486.8	"	520	650	"	
	500	"	25.0	"	539.0	"	550	656	"	
	600	"	26.3	"	643.4	110	610	679	"	
	700	"	"	"	747.8	"	660	692	"	
	"	800	"	"	852.2	"	730	786	140	
	800	150	28.7	17.0	852.2	173.6	80	370	621	100
		200	"	18.0	"	225.8	"	390	627	"
		250	"	19.0	"	278.0	90	430	644	"
300		"	20.0	"	330.2	"	450	651	120	
350		"	21.0	"	382.4	"	480	677	"	
400		"	23.0	"	434.6	100	510	694	"	
450		"	24.0	"	486.8	"	540	700	"	
500		"	25.0	"	539.0	110	570	716	"	
600		"	27.0	"	643.4	"	620	729	"	
700		"	28.7	"	747.8	120	680	752	"	
800		"	"	"	852.2	"	730	786	140	
900		200	31.1	18.0	956.6	225.8	90	420	687	100
		250	"	19.0	"	278.0	"	440	694	"
		300	"	20.0	"	330.2	"	470	721	120
	350	"	21.0	"	382.4	100	500	737	"	
	400	"	23.0	"	434.6	"	530	744	"	
	450	"	24.0	"	486.8	110	560	760	"	
	500	"	25.0	"	539.0	"	590	766	"	
	600	"	27.0	"	643.4	120	650	789	"	
	700	"	29.0	"	747.8	"	700	802	"	

枝 管 銜							重量	公稱內徑		
t ₁	k	m	r ₅	r ₄	r ₃	ボルト孔		D	d	
							d ₁	數		
23.0	24	3	171.0	149.5	128.0	18	8	339	500	200
24.0	26	"	205.0	180.0	154.0	21	"	369	"	250
26.0	27	4	232.0	207.0	181.0	24	10	391	"	300
27.0	28	"	265.0	236.0	207.0	"	"	418	"	350
27.5	30	"	291.0	262.0	233.0	"	12	446	"	400
"	31	"	326.0	292.5	259.0	27	"	475	"	450
"	32	"	353.0	319.5	286.0	"	"	503	"	500
22.0	23	3	145.0	123.5	102.0	18	6	435	600	150
23.0	24	"	171.0	149.5	128.0	"	8	459	"	200
24.0	26	"	205.0	180.0	154.0	21	"	482	"	250
26.0	27	4	232.0	207.0	181.0	"	10	521	"	300
27.0	28	"	265.0	236.0	207.0	24	"	545	"	350
29.0	30	"	291.0	262.0	233.0	"	12	579	"	400
29.9	31	"	326.0	292.5	259.0	27	"	617	"	450
"	32	"	353.0	319.5	286.0	"	"	648	"	500
"	35	"	405.0	371.5	333.0	"	16	715	"	600
22.0	23	3	145.0	123.5	102.0	18	6	567	700	150
23.0	24	"	171.0	149.5	128.0	"	8	598	"	200
24.0	26	"	205.0	180.0	144.0	21	"	633	"	250
26.0	27	4	232.0	207.0	181.0	"	10	669	"	300
27.0	28	"	265.0	236.0	207.0	24	"	697	"	350
29.0	30	"	291.0	262.0	233.0	"	12	744	"	400
30.0	31	"	326.0	292.5	259.0	27	"	778	"	450
31.0	32	"	353.0	319.5	286.0	"	"	818	"	500
32.3	35	"	405.0	371.5	333.0	"	16	901	"	600
"	38	"	464.0	427.0	390.0	30	"	975	"	700
22.0	23	3	145.0	123.5	102.0	18	6	731	800	150
23.0	24	"	171.0	149.5	128.0	"	8	757	"	200
24.0	26	"	205.0	180.0	154.0	21	"	808	"	250
26.0	27	4	232.0	207.0	181.0	"	10	837	"	300
27.0	28	"	265.0	236.0	207.0	24	"	881	"	350
29.0	30	"	291.0	262.0	233.0	"	12	927	"	400
30.0	31	"	326.0	292.5	259.0	27	"	973	"	450
31.0	32	"	353.0	319.5	286.0	"	"	1020	"	500
33.0	35	"	405.0	371.5	333.0	"	16	1100	"	600
34.7	38	"	464.0	427.0	390.0	30	"	1220	"	700
35.7	41	5	517.0	480.0	443.0	"	20	1320	"	800
23.0	24	3	171.0	149.5	128.0	18	8	971	900	200
24.0	26	"	205.0	180.0	154.0	21	"	1010	"	250
26.0	27	4	232.0	207.0	181.0	"	10	1050	"	300
27.0	28	"	265.0	236.0	207.0	24	"	1100	"	350
29.0	30	"	291.0	262.0	233.0	"	12	1150	"	400
30.0	31	"	326.0	292.5	259.0	27	"	1210	"	450
31.0	32	"	353.0	319.5	286.0	"	"	1260	"	500
33.0	35	"	405.0	371.5	333.0	"	16	1370	"	600
35.0	38	"	464.0	427.0	390.0	30	"	1470	"	700

二承一鈔丁字管

公稱內徑		管 厚		實 外 徑		R	管 長		
D	d	T	t	D ₂	d ₂		H	I	l ₂
900	800	31.1	31.1	956.6	852.2	130	760	846	140
	900	"	"	"	956.6		810	859	"
1000	300	33.6	20.0	1061.0	330.2	100	500	781	120
	350	"	21.0	"	382.4		520	787	"
	400	"	23.0	"	434.6		550	804	"
	450	"	24.0	"	486.8		580	810	"
	500	"	25.0	"	539.0		610	826	"
	600	"	27.0	"	643.4		660	839	"
	700	"	29.0	"	747.8		720	862	"
	800	"	31.0	"	852.2		770	896	140
	900	"	33.6	"	956.6		830	919	"
	1000	"	"	"	1061.0		880	931	"
1100	400	36.0	23.0	1165.4	434.6	110	570	854	120
	450	"	24.0	"	486.8		600	860	"
	500	"	25.0	"	539.0		630	866	"
	600	"	27.0	"	643.4		680	889	"
	700	"	29.0	"	747.8		740	912	"
	800	"	31.0	"	852.2		790	946	140
	900	"	34.0	"	956.6		850	969	"
	1000	"	36.0	"	1061.0		900	981	"
	1100	"	"	"	1165.4		960	1004	"
	1200	400	38.4	23.0	1269.8		434.6	110	580
450		"	24.0	"	486.8	610	920		"
500		"	25.0	"	539.0	640	926		"
600		"	27.0	"	643.4	700	949		"
700		"	29.0	"	747.8	750	962		"
800		"	31.0	"	852.2	810	1006		140
900		"	34.0	"	956.6	860	1019		"
1000		"	36.0	"	1061.0	920	1041		"
1100		"	38.4	"	1165.4	970	1054		"
1200		"	"	"	1269.8	1020	1067		"

枝 管 鈔							重量	公稱內徑		
t ₁	k	m	r ₅	r ₄	r ₃	孔數		D	d	
38.1	41	5	517.0	480.0	443.0	30	20	1620	900	800
"	44	"	578.0	536.5	495.0	35	"	1740	"	900
26.0	27	4	232.0	207.0	181.0	21	10	1310	1000	300
27.0	28	"	265.0	236.0	207.0	24	"	1350	"	350
29.0	30	"	291.0	262.0	233.0	"	12	1410	"	400
30.0	31	"	326.0	292.5	259.0	27	"	1460	"	450
31.0	32	"	353.0	319.5	286.0	"	"	1520	"	500
33.0	35	"	405.0	371.5	338.0	"	16	1630	"	600
35.0	38	"	464.0	427.0	390.0	30	"	1760	"	700
38.0	41	5	517.0	480.0	443.0	"	20	1900	"	800
40.6	44	"	578.0	536.5	495.0	35	"	2070	"	900
"	46	"	631.0	589.5	548.0	"	24	2190	"	1000
29.0	30	4	291.0	262.0	233.0	24	12	1680	1100	400
30.0	31	"	326.0	292.5	259.0	27	"	1750	"	450
31.0	32	"	353.0	319.5	286.0	"	"	1810	"	500
33.0	35	"	405.0	371.5	338.0	"	16	1940	"	600
35.0	38	"	464.0	427.0	390.0	30	"	2080	"	700
38.0	41	5	517.0	480.0	443.0	"	20	2220	"	800
41.0	44	"	578.0	536.5	495.0	35	"	2410	"	900
43.0	46	"	631.0	589.5	548.0	"	24	2560	"	1000
"	49	"	683.0	641.5	600.0	"	"	2730	"	1100
29.0	30	4	291.0	262.0	233.0	24	12	1980	1200	400
30.0	31	"	326.0	292.5	259.0	27	"	2060	"	450
31.0	32	"	353.0	319.5	286.0	"	"	2130	"	500
33.0	35	"	405.0	371.5	338.0	"	16	2280	"	600
35.0	38	"	464.0	427.0	390.0	30	"	2420	"	700
38.0	41	5	517.0	480.0	443.0	"	20	2610	"	800
41.0	44	"	578.0	536.5	495.0	35	"	2800	"	900
43.0	46	"	631.0	589.5	548.0	"	24	2970	"	1000
45.4	49	"	683.0	641.5	600.0	"	"	3160	"	1100
"	52	"	735.0	693.5	652.0	"	28	3430	"	1200



一承二銲丁字管

公稱内徑	管厚	實外徑		R	管長						本管				
		D ₂	d ₂		B	I	H	L ₁	L ₂	T ₁	K	M	R ₅		
75	75	11.2	11.2	95.4	95.4	50	249	219	200	100	100	16.2	21	3	105.5
100	100	11.8	11.8	121.4	"	"	252	231	"	"	"	16.8	22	"	119.0
		"	"	"	121.4	"	"	265	235	210	"	"	"	"	"
125	75	12.4	12.4	147.6	95.4	"	255	244	"	"	"	17.4	"	"	131.5
	100	"	"	"	121.4	"	267	247	220	"	"	"	"	"	"
	125	"	"	"	147.6	"	280	250	230	"	"	"	"	"	"
150	75	13.0	13.0	173.6	95.4	"	253	256	210	"	"	18.0	23	"	145.0
	100	"	"	"	121.4	"	271	260	220	"	"	"	"	"	"
	125	"	"	"	147.6	"	284	262	230	"	"	"	"	"	"
	150	"	"	"	173.6	"	296	266	250	"	"	"	"	"	"

第四號 丁字管

第六表 一承二銲丁字管

$$B = L_2 + M + K + \frac{D}{10} + R + \frac{d}{2} + 30$$

$$I = L_2 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$H = F + \frac{D}{10} + R + \frac{d}{2} + 30$$

銲及承口ノ寸法ハ直管ニ同シ

「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平ト爲シタル場合ニ其ノ銲面ノ垂直中心線ニ對シ振分トス

銲		枝管						銲		重量	公稱内徑			
R ₄	R ₅	ボルト孔 d' 數		t ₁	k	m	r ₅	r ₄	r ₃		ボルト孔 d' 數		D	d
84.0	62.5	18	4	16.2	21	3	105.5	84.0	62.5	18	4	30.3	75	75
97.5	76.0	"	"	16.8	"	"	"	"	"	"	"	37.7	100	"
												40.7	"	100
110.0	88.5	"	6	17.4	21	"	105.5	84.0	62.5	"	"	44.9	125	75
												48.1	"	100
												50.9	"	125
123.5	102.0	"	"	18.0	21	"	105.5	84.0	62.5	"	4	53.8	150	75
												57.4	"	100
												60.2	"	125
												63.6	"	150

一承二鑄丁字管

公稱內徑		管厚		實外徑		R	管長							本管			
D	d	T	t	D ₂	d ₂		B	l	H	L ₂	l ₂	T ₁	K	M	R ₅		
500	200	21.5	18.0	539.0	255.8	70	406	467	340	120	100	27.5	32	4	353.0		
	250	"	19.0	"	278.0	80	441	484	330	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	466	511	400	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	491	517	430	"	"	"	"	"	"		
	400	"	21.5	"	434.6	90	526	534	460	"	"	"	"	"	"		
	450	"	"	"	486.8	"	551	540	490	"	"	"	"	"	"		
500	"	"	"	539.0	100	561	556	520	"	"	"	"	"	"			
600	150	23.9	17.0	643.4	173.6	80	404	521	340	"	100	29.9	35	"	405.0		
	200	"	18.0	"	225.8	"	429	527	370	"	"	"	"	"	"		
	250	"	19.0	"	278.0	"	454	534	390	"	"	"	"	"	"		
	300	"	20.0	"	330.2	90	489	571	430	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	514	577	450	"	"	"	"	"	"		
	400	"	23.0	"	434.6	"	539	584	480	"	"	"	"	"	"		
450	"	23.9	"	486.8	100	574	600	510	"	"	"	"	"	"			
500	"	"	"	539.0	"	599	606	540	"	"	"	"	"	"			
600	"	"	"	643.4	110	659	629	600	"	"	"	"	"	"			
700	150	26.3	17.0	747.8	173.6	80	420	570	350	"	100	32.3	38	"	464.0		
	200	"	18.0	"	225.8	"	442	577	380	"	"	"	"	"	"		
	250	"	19.0	"	278.0	90	477	594	410	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	502	621	440	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	527	627	460	"	"	"	"	"	"		
	400	"	23.0	"	434.6	100	562	634	500	"	"	"	"	"	"		
450	"	24.0	"	486.8	"	587	650	520	"	"	"	"	"	"			
500	"	25.0	"	539.0	"	612	656	550	"	"	"	"	"	"			
600	"	26.3	"	643.4	110	672	679	610	"	"	"	"	"	"			
700	"	"	"	747.8	"	722	692	660	"	"	"	"	"	"			
800	150	28.7	17.0	852.2	173.6	80	451	621	370	140	100	35.7	41	5	517.0		
	200	"	18.0	"	225.8	"	476	627	390	"	"	"	"	"	"		
	250	"	19.0	"	278.0	90	511	644	430	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	536	651	450	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	566	677	480	"	"	"	"	"	"		
	400	"	23.0	"	434.6	100	596	694	510	"	"	"	"	"	"		
450	"	24.0	"	486.8	"	621	700	540	"	"	"	"	"	"			
500	"	25.0	"	539.0	110	646	716	570	"	"	"	"	"	"			
600	"	27.0	"	643.4	"	706	729	620	"	"	"	"	"	"			
700	"	28.7	"	747.8	220	756	752	680	"	"	"	"	"	"			
800	"	"	"	852.2	"	816	786	730	"	140	"	"	"	"			
900	200	31.1	18.0	956.6	225.8	90	469	687	420	"	100	38.1	44	"	578.0		
	250	"	19.0	"	278.0	"	524	694	440	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	549	721	470	"	120	"	"	"	"		
	350	"	21.0	"	382.4	100	584	737	500	"	"	"	"	"	"		
	400	"	23.0	"	434.6	"	609	744	530	"	"	"	"	"	"		

公稱內徑		管厚		實外徑		R	管長							本管			
D	d	T	t	D ₂	d ₂		B	l	H	L ₂	l ₂	T ₁	K	M	R ₅		
500	200	21.5	18.0	539.0	255.8	70	406	467	340	120	100	27.5	32	4	353.0		
	250	"	19.0	"	278.0	80	441	484	330	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	466	511	400	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	491	517	430	"	"	"	"	"	"		
	400	"	21.5	"	434.6	90	526	534	460	"	"	"	"	"	"		
	450	"	"	"	486.8	"	551	540	490	"	"	"	"	"	"		
500	"	"	"	539.0	100	561	556	520	"	"	"	"	"	"			
600	150	23.9	17.0	643.4	173.6	80	404	521	340	"	100	29.9	35	"	405.0		
	200	"	18.0	"	225.8	"	429	527	370	"	"	"	"	"	"		
	250	"	19.0	"	278.0	"	454	534	390	"	"	"	"	"	"		
	300	"	20.0	"	330.2	90	489	571	430	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	514	577	450	"	"	"	"	"	"		
	400	"	23.0	"	434.6	"	539	584	480	"	"	"	"	"	"		
450	"	23.9	"	486.8	100	574	600	510	"	"	"	"	"	"			
500	"	"	"	539.0	"	599	606	540	"	"	"	"	"	"			
600	"	"	"	643.4	110	659	629	600	"	"	"	"	"	"			
700	150	26.3	17.0	747.8	173.6	80	420	570	350	"	100	32.3	38	"	464.0		
	200	"	18.0	"	225.8	"	442	577	380	"	"	"	"	"	"		
	250	"	19.0	"	278.0	90	477	594	410	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	502	621	440	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	527	627	460	"	"	"	"	"	"		
	400	"	23.0	"	434.6	100	562	634	500	"	"	"	"	"	"		
450	"	24.0	"	486.8	"	587	650	520	"	"	"	"	"	"			
500	"	25.0	"	539.0	"	612	656	550	"	"	"	"	"	"			
600	"	26.3	"	643.4	110	672	679	610	"	"	"	"	"	"			
700	"	"	"	747.8	"	722	692	660	"	"	"	"	"	"			
800	150	28.7	17.0	852.2	173.6	80	451	621	370	140	100	35.7	41	5	517.0		
	200	"	18.0	"	225.8	"	476	627	390	"	"	"	"	"	"		
	250	"	19.0	"	278.0	90	511	644	430	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	536	651	450	"	120	"	"	"	"		
	350	"	21.0	"	382.4	"	566	677	480	"	"	"	"	"	"		
	400	"	23.0	"	434.6	100	596	694	510	"	"	"	"	"	"		
450	"	24.0	"	486.8	"	621	700	540	"	"	"	"	"	"			
500	"	25.0	"	539.0	110	646	716	570	"	"	"	"	"	"			
600	"	27.0	"	643.4	"	706	729	620	"	"	"	"	"	"			
700	"	28.7	"	747.8	220	756	752	680	"	"	"	"	"	"			
800	"	"	"	852.2	"	816	786	730	"	140	"	"	"	"			
900	200	31.1	18.0	956.6	225.8	90	469	687	420	"	100	38.1	44	"	578.0		
	250	"	19.0	"	278.0	"	524	694	440	"	"	"	"	"	"		
	300	"	20.0	"	330.2	"	549	721	470	"	120	"	"	"	"		
	350	"	21.0	"	382.4	100	584	737	500	"	"	"	"	"	"		
	400	"	23.0	"	434.6	"	609	744	530	"	"	"	"	"	"		

一承二鐔丁字管

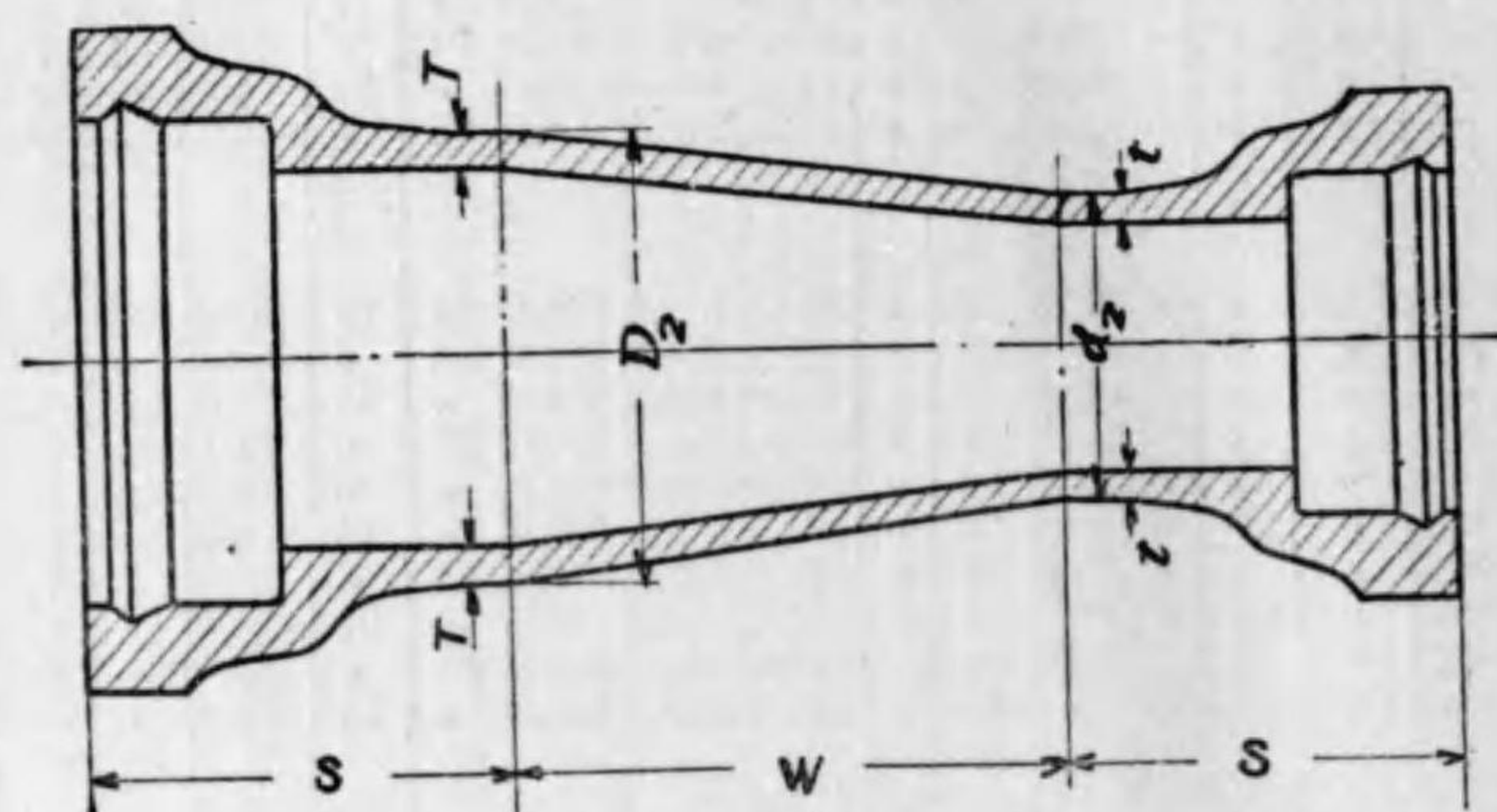
公稱內徑		管厚		實外徑		R	管長					本管				
D	d	T	t	D ₂	d ₂		B	I	H	L ₂	l ₂	T ₁	K	M	R ₃	
900	450	31.1	24.0	956.6	486.8	110	644	760	560	140	120	38.1	44	5	578.0	
	500	"	25.0	"	539.0	"	669	766	590	"	"	"	"	"	"	
	600	"	27.0	"	643.4	120	729	789	650	"	"	"	"	"	"	
	700	"	29.0	"	747.8	"	779	802	700	"	"	"	"	"	"	
	800	"	31.1	"	852.2	130	839	846	760	"	140	"	"	"	"	
	900	"	"	"	956.6	"	889	859	810	"	"	"	"	"	"	
1000	300	33.6	20.0	1061.0	330.2	100	571	781	500	"	120	40.6	46	"	631.0	
	350	"	21.0	"	382.4	"	596	787	520	"	"	"	"	"	"	
	400	"	23.0	"	434.6	110	631	804	550	"	"	"	"	"	"	
	450	"	24.0	"	486.8	"	656	810	580	"	"	"	"	"	"	
	500	"	25.0	"	539.0	120	691	826	610	"	"	"	"	"	"	
	600	"	27.0	"	643.4	"	731	839	660	"	"	"	"	"	"	
	700	"	29.0	"	747.8	130	801	862	720	"	"	"	"	"	"	
	800	"	31.0	"	852.2	"	851	896	770	"	140	"	"	"	"	
	900	"	33.6	"	956.6	140	911	919	830	"	"	"	"	"	"	
	1000	"	"	"	1061.0	"	961	931	880	"	"	"	"	"	"	
	1100	"	"	"	1165.4	"	1034	1004	960	"	"	"	"	"	"	
1100	400	36.0	23.0	1165.4	434.6	110	644	854	570	"	120	43.0	49	"	683.0	
	450	"	24.0	"	486.8	"	669	860	600	"	"	"	"	"	"	
	500	"	25.0	"	539.0	120	704	866	630	"	"	"	"	"	"	
	600	"	27.0	"	643.4	"	754	889	680	"	"	"	"	"	"	
	700	"	29.0	"	747.8	130	814	912	740	"	"	"	"	"	"	
	800	"	31.0	"	852.2	"	864	946	790	"	140	"	"	"	"	
	900	"	34.0	"	956.6	140	924	969	850	"	"	"	"	"	"	
	1000	"	36.0	"	1061.0	"	974	981	900	"	"	"	"	"	"	
	1100	"	"	"	1165.4	150	1034	1004	960	"	"	"	"	"	"	
	1200	"	"	"	1269.8	"	1097	1067	1020	"	"	"	"	"	"	
	1200	400	38.4	23.0	1269.8	434.6	110	657	904	580	"	120	45.4	52	"	735.0
	450	"	24.0	"	486.2	120	692	920	610	"	"	"	"	"	"	
500	"	25.0	"	539.0	"	717	926	640	"	"	"	"	"	"		
600	"	27.0	"	643.4	130	777	949	700	"	"	"	"	"	"		
700	"	29.0	"	747.8	"	827	962	750	"	"	"	"	"	"		
800	"	31.0	"	852.2	140	887	1006	810	"	140	"	"	"	"		
900	"	34.0	"	956.6	"	937	1019	860	"	"	"	"	"	"		
1000	"	36.0	"	1061.0	150	994	1041	920	"	"	"	"	"	"		
1100	"	38.4	"	1165.4	"	1047	1054	970	"	"	"	"	"	"		
1200	"	"	"	1269.8	"	1097	1067	1020	"	"	"	"	"	"		

鐔		管					鐔		重量	公稱內徑				
R ₁	R ₂	t ₁	k	m	r ₅	r ₄	r ₃	D		d				
536.5	495.0	35	20	30.0	31	4	326.0	292.5	259.0	27	12	1150	900	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1200	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1300	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1410	"	700
"	"	"	"	38.1	41	5	517.0	480.0	443.0	"	20	1550	"	800
"	"	"	"	"	44	"	578.0	536.5	495.0	35	"	1670	"	900
589.5	548.0	"	24	26.0	27	4	232.0	207.0	181.0	21	10	1250	1000	300
"	"	"	"	27.0	28	"	265.0	236.0	207.0	24	"	1290	"	350
"	"	"	"	29.0	30	"	291.0	262.0	233.0	"	12	1350	"	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1410	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1470	"	500
"	"	"	"	32.0	35	"	405.0	371.5	338.0	"	16	1570	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	1700	"	700
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	1850	"	800
"	"	"	"	40.6	44	"	578.0	536.5	495.0	35	"	2020	"	900
"	"	"	"	"	46	"	631.0	589.5	548.0	"	24	2140	"	1000
641.5	600.0	"	"	29.0	30	4	291.0	262.0	233.0	24	12	1610	1100	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1660	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	1740	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	1860	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2000	"	700
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2150	"	800
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2340	"	900
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2490	"	1000
"	"	"	"	"	49	"	683.0	641.5	600.0	"	"	2660	"	1100
693.5	652.0	"	28	29.0	30	4	291.0	262.0	233.0	24	12	1890	1200	400
"	"	"	"	30.0	31	"	326.0	292.5	259.0	27	"	1970	"	450
"	"	"	"	31.0	32	"	353.0	319.5	286.0	"	"	2040	"	500
"	"	"	"	33.0	35	"	405.0	371.5	338.0	"	16	2190	"	600
"	"	"	"	35.0	38	"	464.0	427.0	390.0	30	"	2330	"	700
"	"	"	"	38.0	41	5	517.0	480.0	443.0	"	20	2510	"	800
"	"	"	"	41.0	44	"	578.0	536.5	495.0	35	"	2690	"	900
"	"	"	"	43.0	46	"	631.0	589.5	548.0	"	24	2830	"	1000
"	"	"	"	45.4	49	"	683.0	641.5	600.0	"	"	3060	"	1100
"	"	"	"	"	52	"	735.0	693.5	652.0	"	28	3280	"	1200

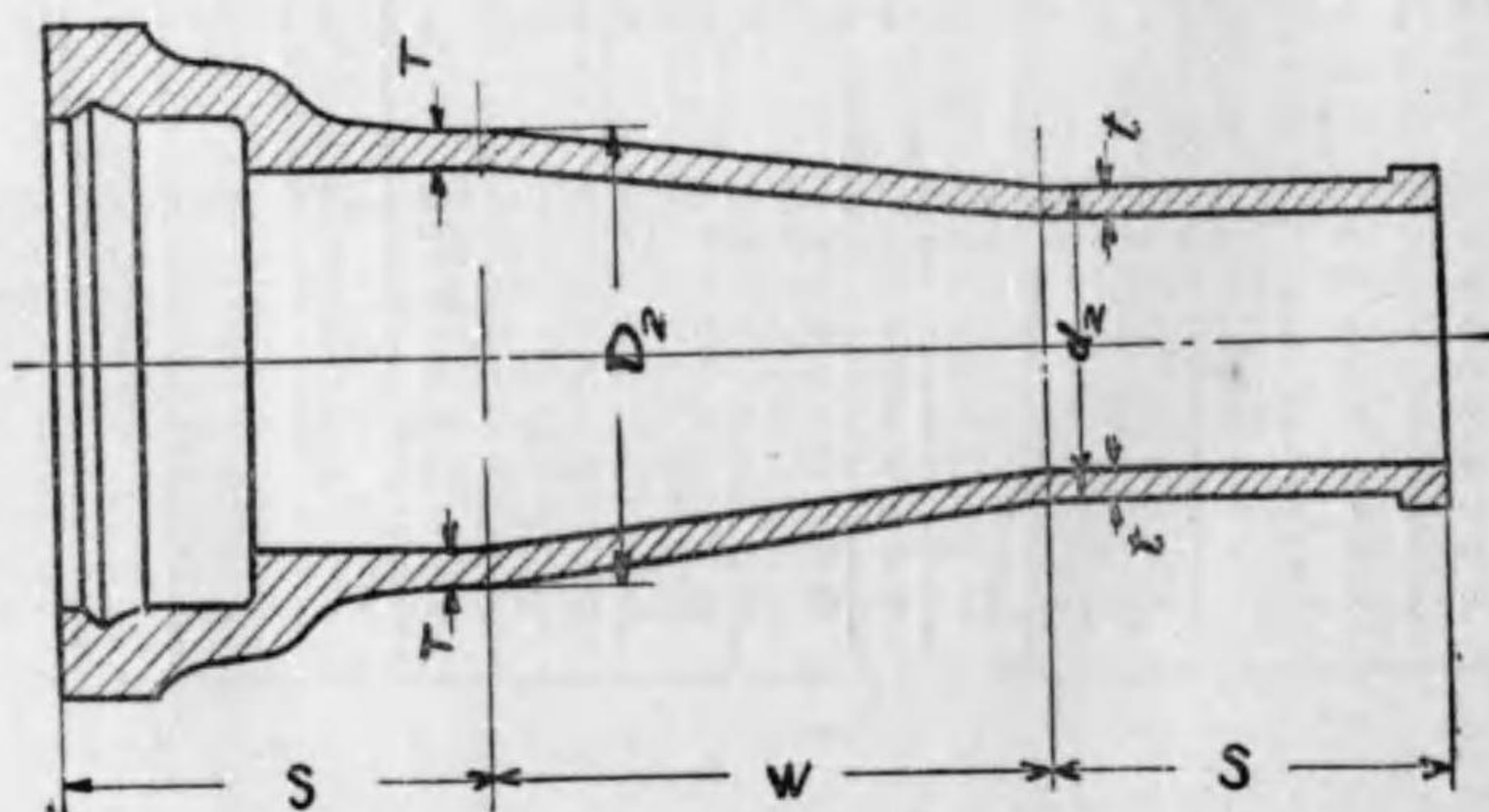
第五號片落

第一表

兩承片落管

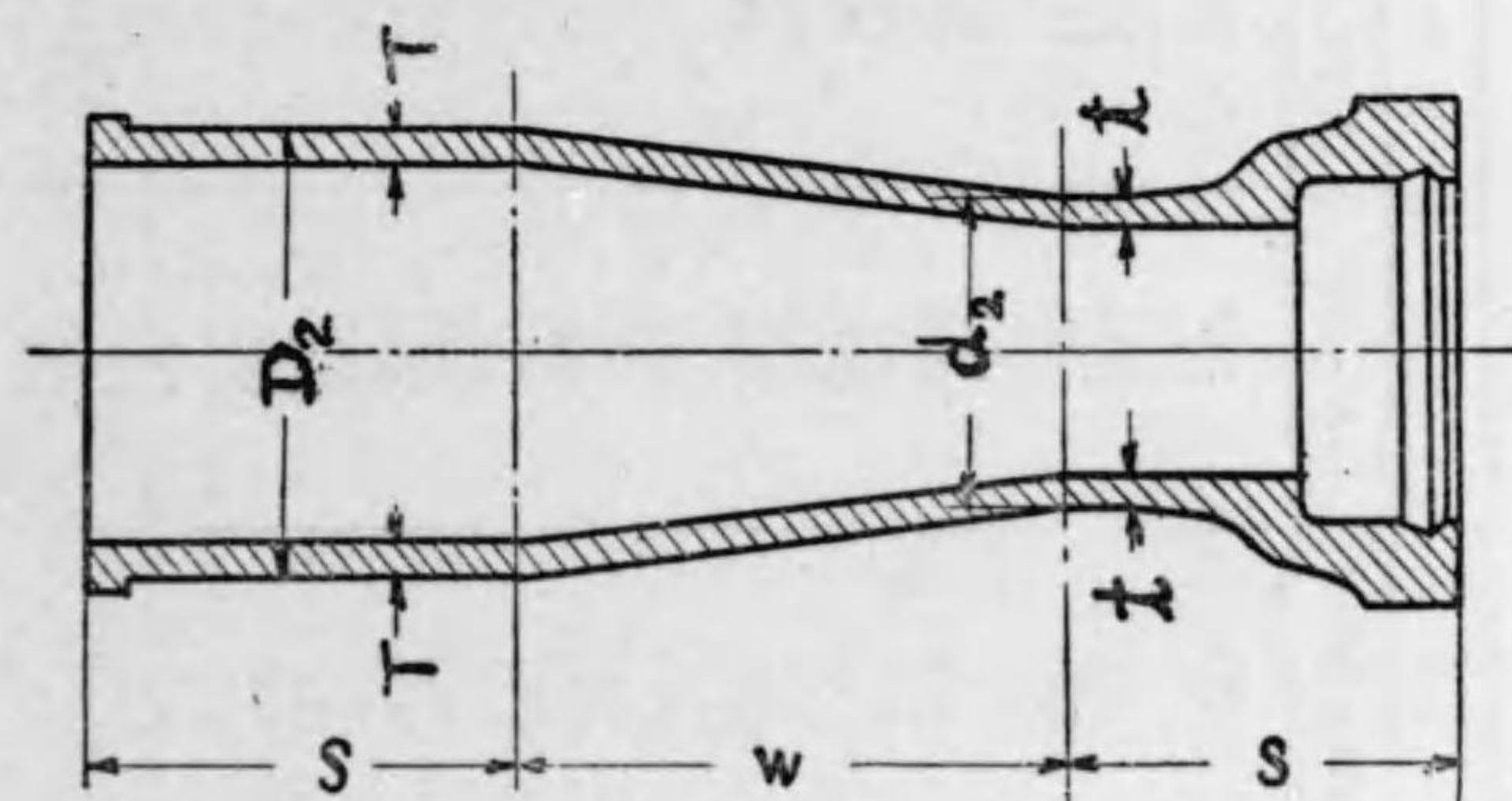


承插片落管

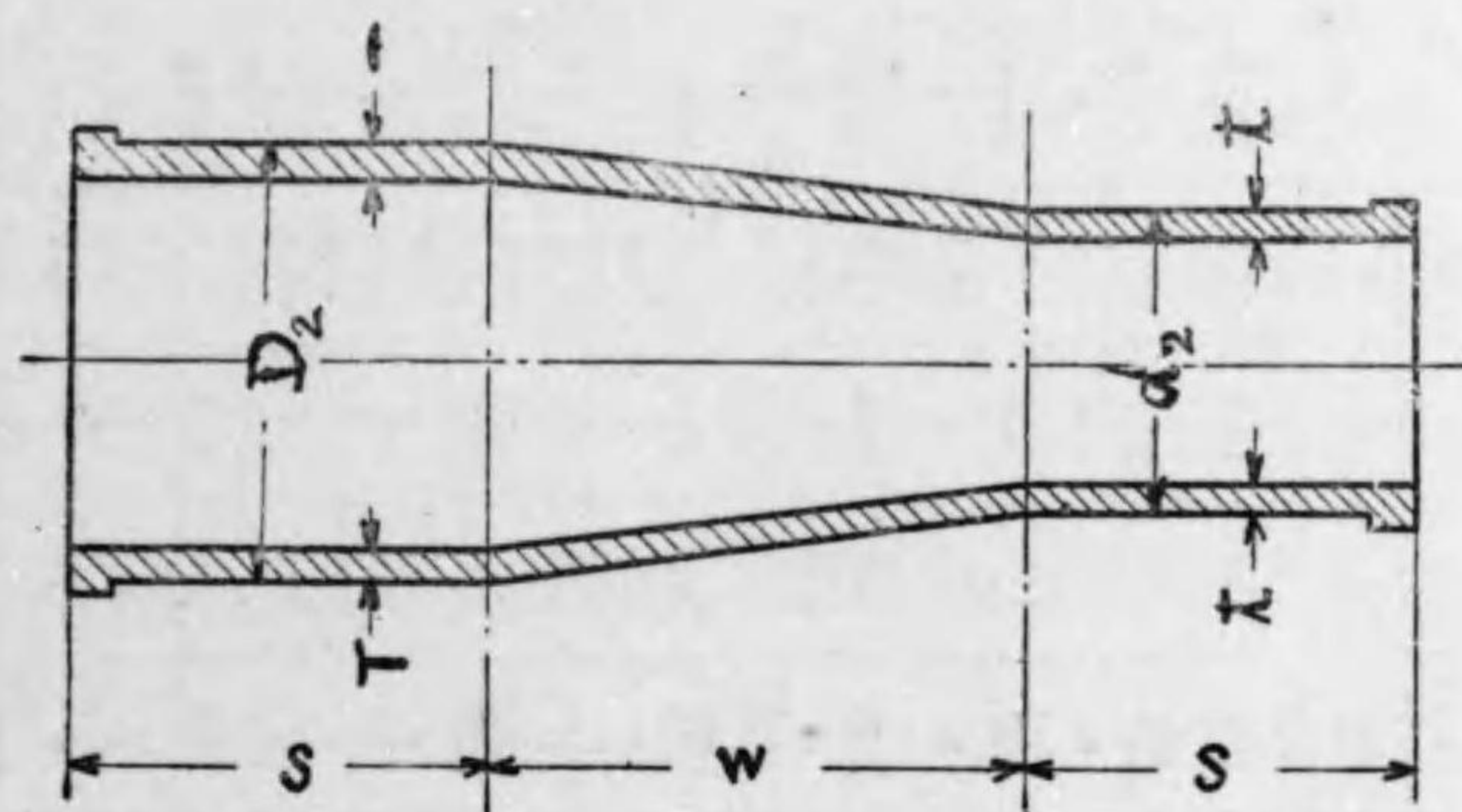


管

插承片落管



兩插片落短管



片 落 管

公稱內徑 D	管 厚		實 外 徑		管 長		重 量			
	T	t	D ₂	d ₂	W	S	兩承片落管	承插片落管	插承片落管	兩插片落管
100	11.8	11.2	121.4	95.4	500	200	36.1	30.4	28.9	23.3
125	12.4	11.8	147.6	121.4	"	"	41.0	35.1	32.6	27.0
150	13.0	12.4	173.6	147.6	"	"	52.3	45.1	42.0	34.8
"	"	"	"	173.6	"	"	57.4	49.2	47.1	38.9
200	14.2	11.8	223.8	121.4	"	"	64.5	57.3	51.0	43.9
"	"	12.4	"	147.6	"	"	69.7	61.6	56.3	48.1
"	"	13.0	"	173.6	"	"	76.2	65.9	62.7	52.4
250	15.4	11.8	278.0	121.4	"	"	79.0	71.9	61.3	54.2
"	"	12.4	"	147.6	"	"	84.4	76.2	66.7	58.5
"	"	13.0	"	173.6	"	"	90.9	80.6	73.2	62.9
"	"	14.2	"	223.8	"	"	104.0	90.4	86.1	72.7
300	16.6	11.8	330.2	121.4	"	"	92.9	85.8	72.4	65.3
"	"	12.4	"	147.6	"	"	98.4	90.5	77.9	69.8
"	"	13.0	"	173.6	"	"	105	94.7	84.6	74.3
"	"	14.2	"	223.8	"	"	118	105	97.7	84.3
"	"	15.4	"	278.0	"	"	134	116	113	95.5
350	17.8	13.0	382.4	173.6	"	"	121	111	96.7	86.3
"	"	14.2	"	223.8	"	"	135	121	110	96.6
"	"	15.4	"	278.0	"	"	150	133	126	108
"	"	16.6	"	330.2	"	"	165	145	141	120

片 落 管

公稱內徑 D	管 厚		實 外 徑		管 長		重 量			
	T	t	D ₂	d ₂	W	S	兩承片落管	承插片落管	插承片落管	兩插片落管
400	19.0	13.0	434.6	173.6	500	230	153	143	132	113
"	"	14.2	"	223.8	"	"	168	154	137	123
"	"	15.4	"	278.0	"	"	185	167	154	136
"	"	16.6	"	330.2	"	"	201	181	170	159
"	"	17.8	"	382.4	"	"	221	196	189	165
450	21.2	14.2	486.8	223.8	"	"	189	175	163	139
"	"	15.4	"	278.0	"	"	207	188	170	145
"	"	16.6	"	330.2	"	"	223	203	187	167
"	"	17.8	"	382.4	"	"	242	218	206	183
"	"	19.0	"	434.6	"	"	266	235	230	199
500	21.5	15.4	539.0	278.0	"	"	229	211	189	171
"	"	16.6	"	330.2	"	"	246	225	205	185
"	"	17.8	"	382.4	"	"	265	241	225	201
"	"	19.0	"	434.6	"	"	289	258	239	218
"	"	20.2	"	486.8	"	"	312	276	272	236
600	23.9	16.6	643.4	330.2	620	240	227	206	272	251
"	"	17.8	"	382.4	"	"	243	219	239	264
"	"	19.0	"	434.6	"	"	270	239	215	234
"	"	20.2	"	486.8	"	"	296	259	241	204
"	"	21.5	"	539.0	"	"	470	423	415	373
700	26.3	19.0	747.8	434.6	"	"	436	404	365	333
"	"	20.2	"	486.8	"	"	462	425	391	354
"	"	21.5	"	539.0	"	"	490	448	419	377
"	"	23.9	"	643.4	"	"	550	496	479	425

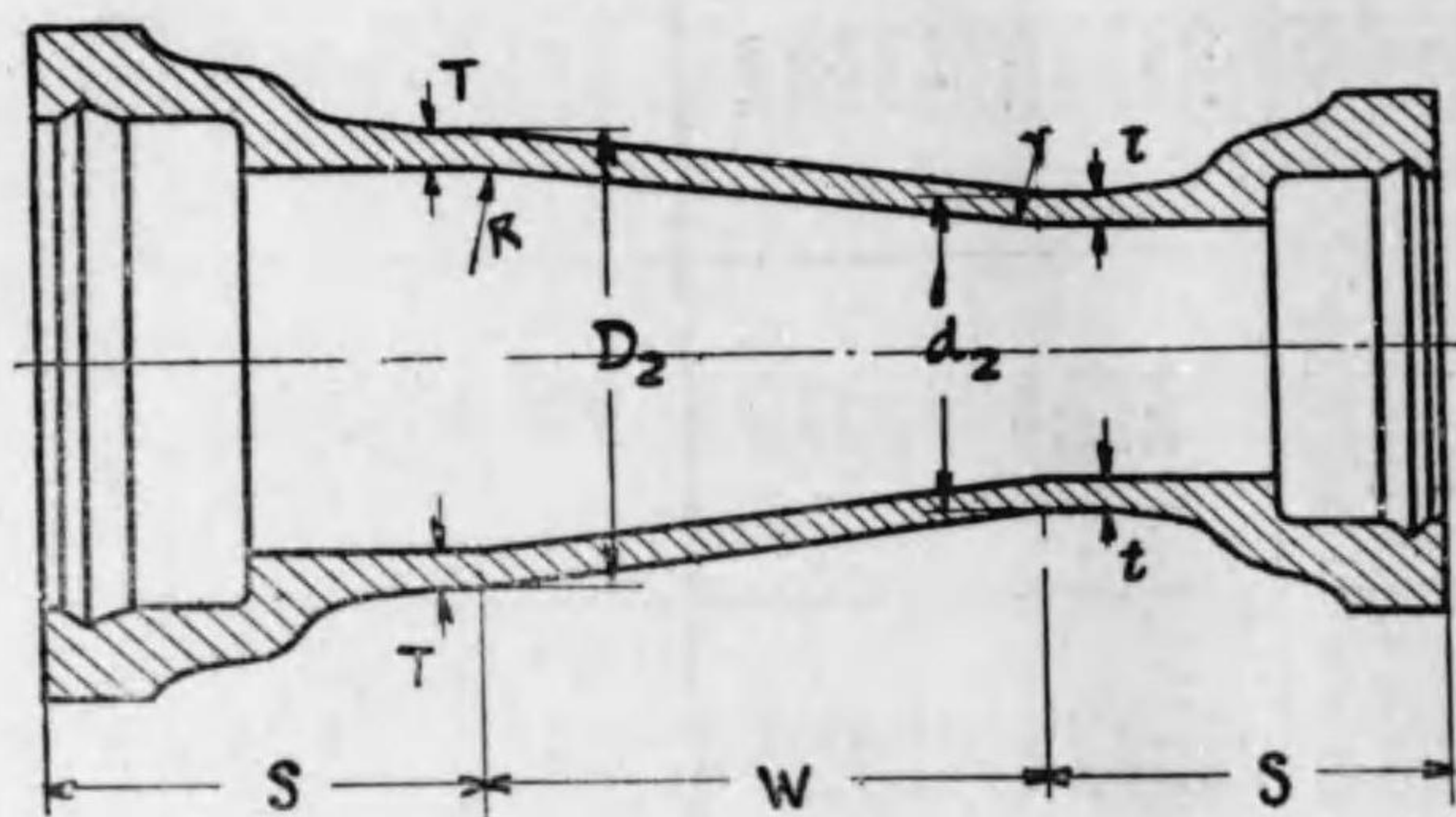
片 落 管

公稱內徑 D	管 厚		實 外 徑		管 長		重 量			
	T	t	D ₂	d ₂	W	S	兩承片落管	承插片落管	插承片落管	兩插片落管
800	450	20.2	852.2	486.8	630	200	570	533	482	446
	500	21.5	"	539.0	"	"	600	558	513	471
	600	23.9	"	643.4	"	"	666	612	579	534
	700	26.3	"	747.8	"	"	740	670	652	583
900	500	21.5	956.6	559.0	"	"	690	648	579	537
	600	23.9	"	643.4	"	"	738	702	646	591
	700	26.3	"	747.8	"	"	831	763	721	652
	800	28.7	"	852.2	"	"	915	828	804	717
1000	500	21.5	1061.0	589.0	740	230	833	792	701	659
	600	23.9	"	643.4	"	"	901	846	769	714
	700	26.3	"	747.8	"	"	987	918	856	787
	800	28.7	"	852.2	"	"	1100	990	946	859
1100	900	31.1	"	956.6	"	"	1180	1070	1050	937
	600	23.9	1165.4	643.4	"	"	1010	957	858	803
	700	26.3	"	747.8	"	"	1090	1029	940	871
	800	28.7	"	852.2	"	"	1190	1100	1030	944
1200	900	31.1	"	956.6	"	"	1290	1180	1130	1020
	1000	33.6	"	1061.0	"	"	1400	1260	1240	1110
	700	26.3	1269.8	747.8	800	300	1390	1230	1110	1040
	800	28.7	"	852.2	"	"	1360	1300	1210	1120
1300	900	31.1	"	956.6	"	"	1500	1380	1320	1210
	1000	33.6	"	1061.0	"	"	1610	1480	1430	1300
	1100	36.0	"	1165.4	"	"	1730	1580	1550	1400

片 落 管

公稱內徑 D	管 厚		實 外 徑		管 長		重 量			
	T	t	D ₂	d ₂	W	S	兩承片落管	承插片落管	插承片落管	兩插片落管
1350	800	28.7	1426.4	852.2	800	300	1590	1510	1380	1300
	900	31.1	"	956.6	"	"	1710	1600	1500	1390
	1000	33.6	"	1061.0	"	"	1800	1690	1610	1490
	1100	36.0	"	1165.4	"	"	1950	1790	1740	1580
1500	1200	38.4	"	1269.8	"	"	2080	1900	1870	1690
	900	31.1	1533.0	956.6	800	320	2060	1950	1800	1690
	1000	33.6	"	1061.0	"	"	2190	2060	1930	1800
	1100	36.0	"	1165.4	"	"	2330	2170	2070	1910
1350	1200	38.4	"	1269.8	"	"	2480	2300	2220	2040
	1350	42.0	"	1426.4	"	"	2720	2510	2460	2250

第六號片落
第一
兩承片落短管

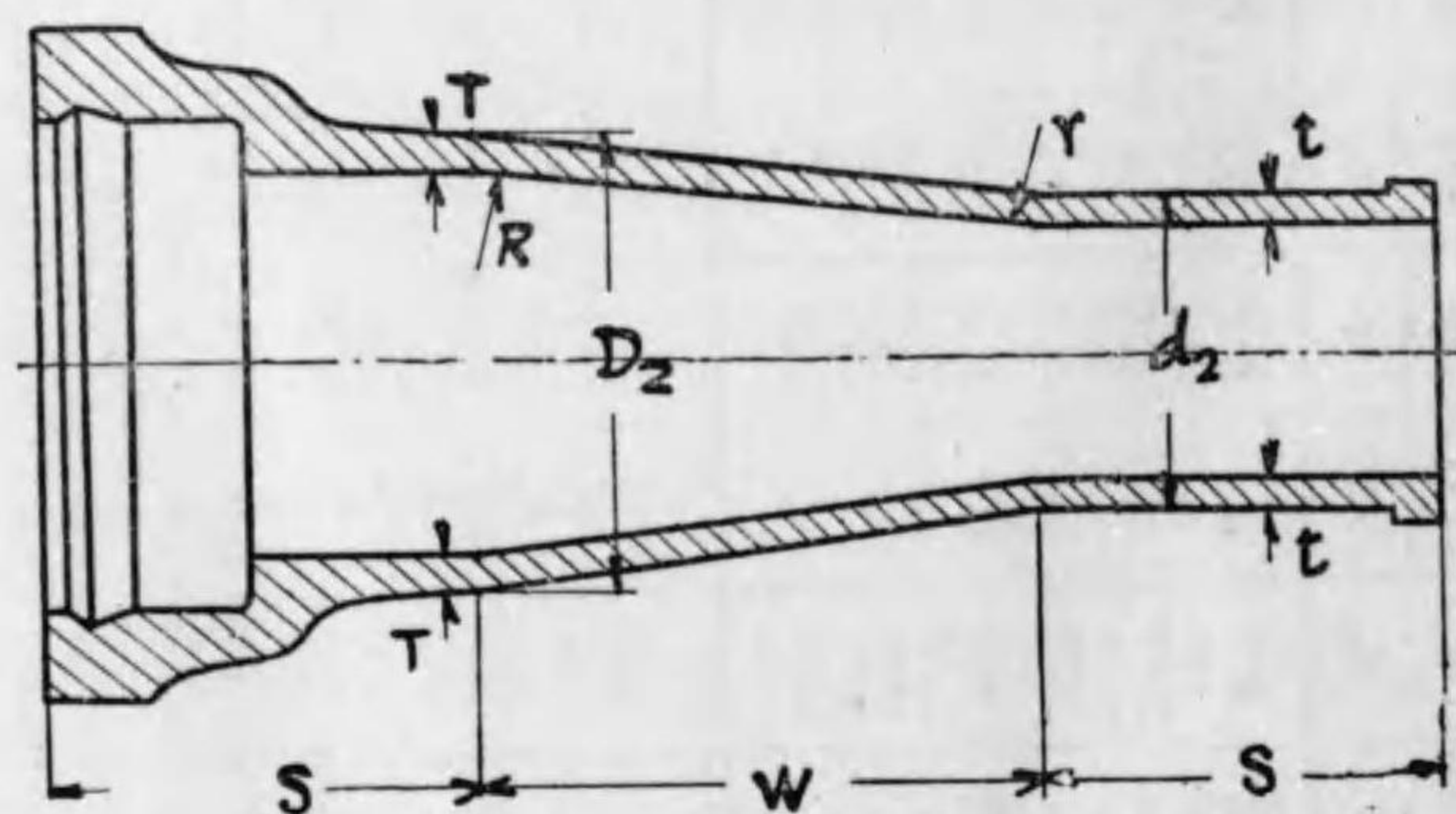


承插片落短管

$$R = \frac{D}{4}$$

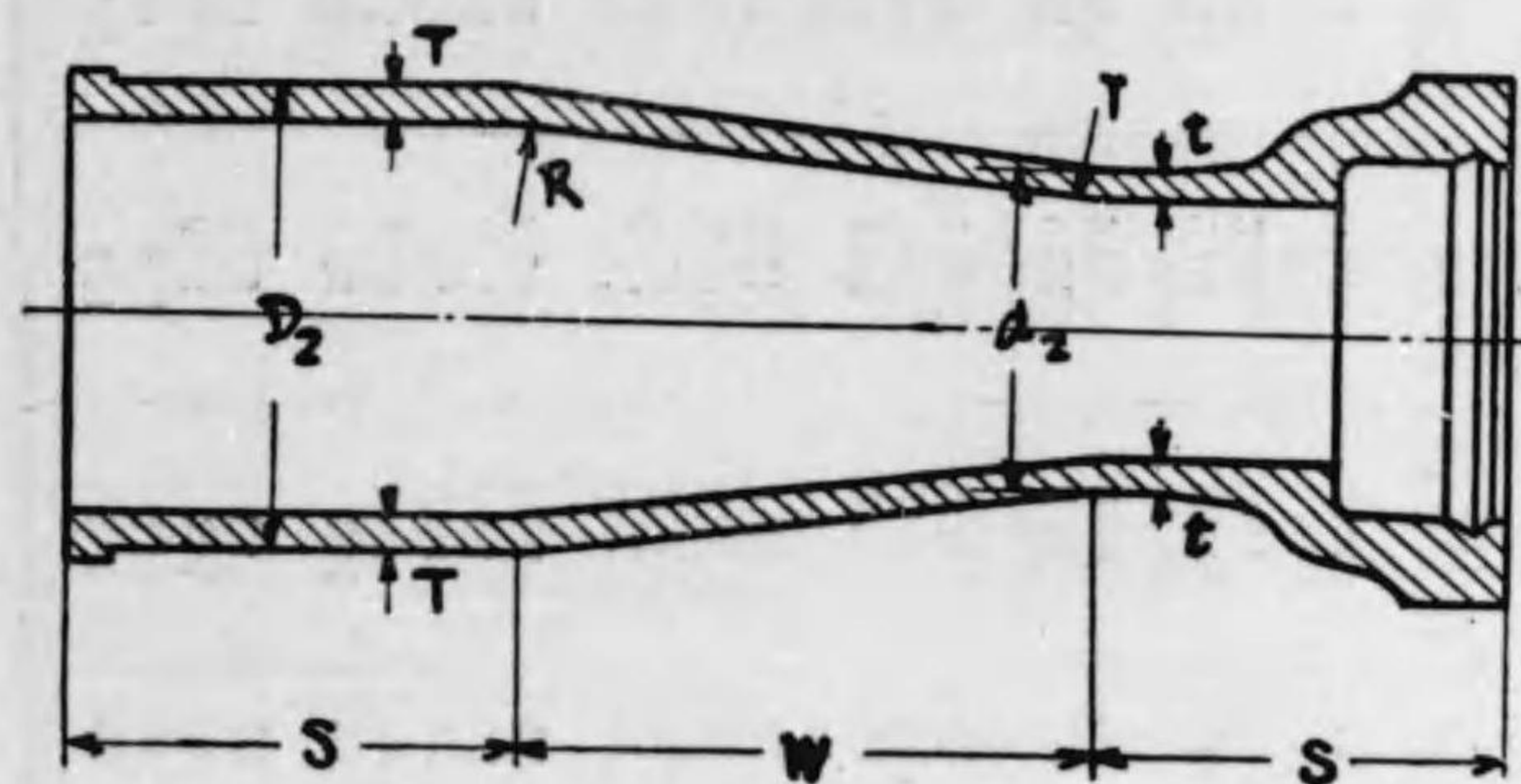
$$r = \frac{d}{4}$$

承口及挿口ノ寸



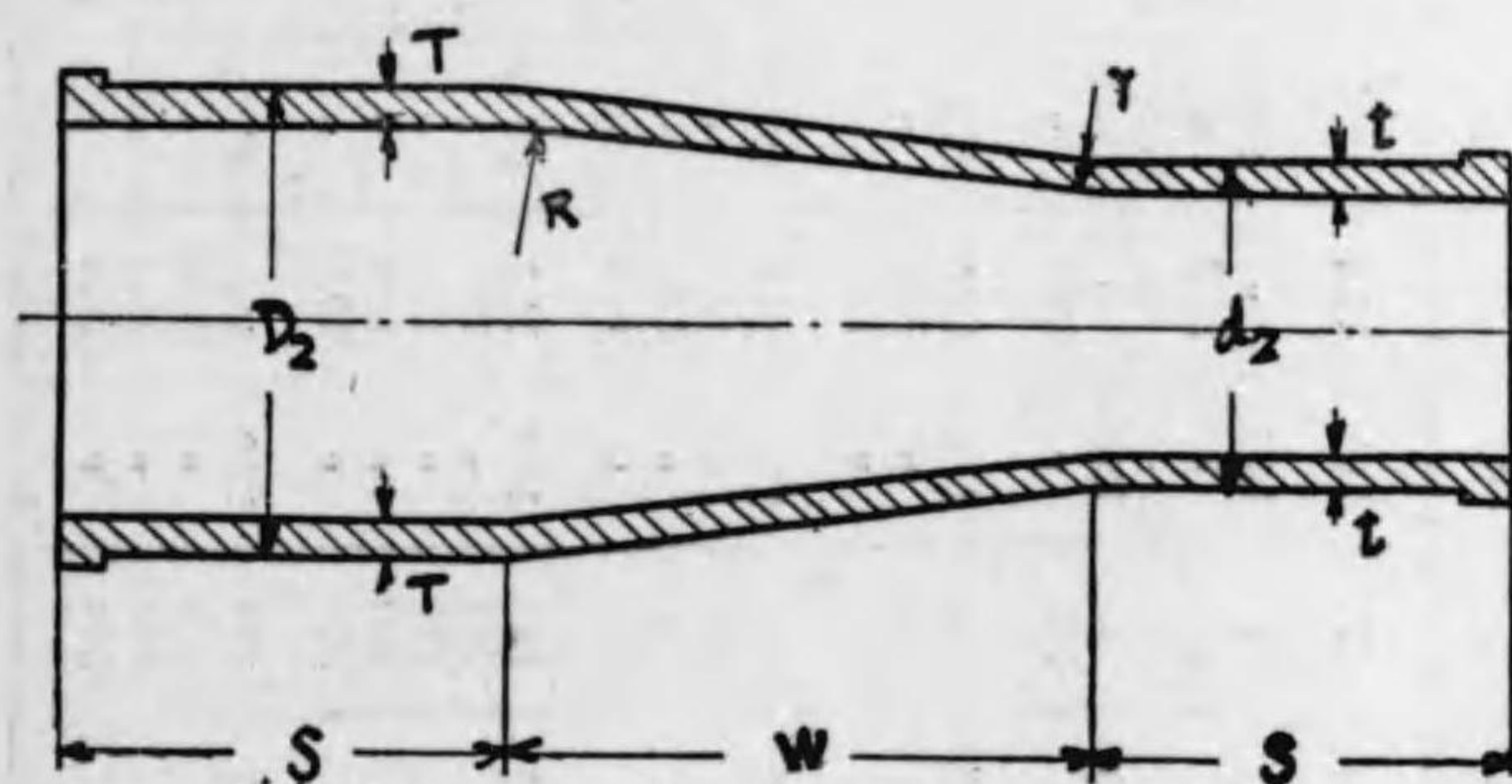
短管
表

挿承片落短管



兩挿片落管

法ハ直管 = 同シ



片落短管

公稱內徑 D	管厚		實外徑		管長				重量														
	d	T	t	D ₂	W	S	R	r	兩 落	承 短	片 管	承 短	片 管	兩 落	承 短	片 管	承 短	片 管	兩 落	承 短	片 管		
100	75	11.8	11.2	121.4	95.4	250	200	25	19	29.7	24.0	22.5	24.0	22.5	24.0	22.5	24.0	22.5	24.0	22.5	24.0	22.5	16.9
125	"	12.4	"	147.6	"	"	"	32	"	33.6	27.8	25.2	27.8	25.2	27.8	25.2	27.8	25.2	27.8	25.2	27.8	25.2	19.6
"	100	"	11.8	"	121.4	"	"	"	25	37.6	30.5	29.5	30.5	29.5	30.5	29.5	30.5	29.5	30.5	29.5	30.5	29.5	22.3
150	"	13.0	12.4	173.6	147.6	"	"	38	"	42.8	35.6	32.5	35.6	32.5	35.6	32.5	35.6	32.5	35.6	32.5	35.6	32.5	25.3
"	125	"	"	"	147.6	"	"	"	22	46.7	38.6	36.4	38.6	36.4	38.6	36.4	38.6	36.4	38.6	36.4	38.6	36.4	28.3
200	100	14.2	11.8	225.8	121.4	"	"	50	25	52.6	45.4	39.1	45.4	39.1	45.4	39.1	45.4	39.1	45.4	39.1	45.4	39.1	32.0
"	125	"	12.4	"	147.6	"	"	"	32	56.6	48.4	43.2	48.4	43.2	48.4	43.2	48.4	43.2	48.4	43.2	48.4	43.2	35.0
"	150	"	13.0	"	173.6	"	"	"	38	61.8	51.5	48.4	51.5	48.4	51.5	48.4	51.5	48.4	51.5	48.4	51.5	48.4	38.1
250	100	15.4	11.8	278.0	121.4	"	"	63	25	64.4	57.3	46.7	57.3	46.7	57.3	46.7	57.3	46.7	57.3	46.7	57.3	46.7	39.6
"	125	"	12.4	"	147.6	"	"	"	32	68.5	60.4	50.8	60.4	50.8	60.4	50.8	60.4	50.8	60.4	50.8	60.4	50.8	42.7
"	150	"	13.0	"	173.6	"	"	"	38	73.8	63.5	56.1	63.5	56.1	63.5	56.1	63.5	56.1	63.5	56.1	63.5	56.1	45.8
"	200	"	14.2	"	225.8	"	"	"	50	83.9	70.5	66.2	70.5	66.2	70.5	66.2	70.5	66.2	70.5	66.2	70.5	66.2	52.8
300	100	16.6	11.8	330.2	121.4	"	"	75	25	75.4	68.3	55.0	68.3	55.0	68.3	55.0	68.3	55.0	68.3	55.0	68.3	55.0	47.9
"	125	"	12.4	"	147.6	"	"	"	32	79.6	71.7	59.1	71.7	59.1	71.7	59.1	71.7	59.1	71.7	59.1	71.7	59.1	51.0
"	150	"	13.0	"	173.6	"	"	"	38	84.9	74.6	64.5	74.6	64.5	74.6	64.5	74.6	64.5	74.6	64.5	74.6	64.5	54.2
"	200	"	14.2	"	225.8	"	"	"	50	95.2	81.8	74.7	81.8	74.7	81.8	74.7	81.8	74.7	81.8	74.7	81.8	74.7	61.3
"	250	"	15.4	"	278.0	"	"	"	63	108	89.8	87.1	89.8	87.1	89.8	87.1	89.8	87.1	89.8	87.1	89.8	87.1	69.4
350	150	17.8	13.0	382.4	173.6	"	"	88	38	98	87.7	73.5	87.7	73.5	87.7	73.5	87.7	73.5	87.7	73.5	87.7	73.5	63.2
"	200	"	14.2	"	225.8	"	"	"	50	108	94.9	83.8	94.9	83.8	94.9	83.8	94.9	83.8	94.9	83.8	94.9	83.8	70.4
"	250	"	15.4	"	278.0	"	"	"	63	121	103	96.4	103	96.4	103	96.4	103	96.4	103	96.4	103	96.4	78.7
"	300	"	16.6	"	330.2	"	"	"	75	132	112	108	112	108	112	108	112	108	112	108	112	108	87.4

片落短管

公稱內徑 D	管厚		實外徑		管長				重量														
	d	T	t	D ₂	W	S	R	r	兩 落	承 短	片 管	承 短	片 管	承 短	片 管	承 短	片 管	承 短	片 管	承 短	片 管	承 短	片 管
400	150	19.0	13.0	454.6	173.6	280	220	100	38	123	113	91.8	113	91.8	113	91.8	113	91.8	113	91.8	113	91.8	81.5
"	200	"	14.2	"	225.8	"	"	"	50	134	121	103	121	103	134	121	103	121	103	134	121	103	89.7
"	250	"	15.4	"	278.0	"	"	"	63	148	130	117	130	117	148	130	117	130	117	148	130	117	98.8
"	300	"	16.6	"	330.2	"	"	"	75	160	140	129	140	129	160	140	129	140	129	160	140	129	109
"	350	"	17.8	"	382.4	"	"	"	88	175	151	144	151	144	175	151	144	151	144	175	151	144	119
450	200	20.2	14.2	486.8	225.8	"	"	113	50	151	138	115	138	115	151	138	115	138	115	151	138	115	102
"	250	"	15.4	"	278.0	"	"	"	63	165	147	129	147	129	165	147	129	147	129	165	147	129	111
"	300	"	16.6	"	330.2	"	"	"	75	177	157	142	157	142	177	157	142	157	142	177	157	142	121
"	350	"	17.8	"	382.4	"	"	"	88	192	168	156	168	156	192	168	156	168	156	192	168	156	132
"	400	"	19.0	"	434.6	"	"	"	100	211	180	176	180	176	211	180	176	180	176	211	180	176	144
500	250	21.5	15.4	539.0	278.0	"	"	125	63	182	164	142	164	142	182	164	142	164	142	182	164	142	124
"	300	"	16.6	"	330.2	"	"	"	75	195	175	154	175	154	195	175	154	175	154	195	175	154	129
"	350	"	17.8	"	382.4	"	"	"	88	210	186	170	186	170	210	186	170	186	170	210	186	170	145
"	400	"	19.0	"	434.6	"	"	"	100	229	198	189	198	189	229	198	189	198	189	229	198	189	158
"	450	"	20.2	"	486.8	"	"	"	113	247	211	207	211	207	247	211	207	211	207	247	211	207	171
600	300	23.9	16.6	643.4	330.2	310	240	150	75	257	236	202	236	202	257	236	202	236	202	257	236	202	182
"	350	"	17.8	"	382.4	"	"	"	88	271	246	216	246	216	271	246	216	246	216	271	246	216	191
"	400	"	19.0	"	434.6	"	"	"	100	292	266	237	266	237	292	266	237	266	237	292	266	237	205
"	450	"	20.2	"	486.8	"	"	"	113	311	275	257	275	257	311	275	257	275	257	311	275	257	220
"	500	"	21.5	"	539.0	"	"	"	125	336	314	301	314	301	336	314	301	314	301	336	314	301	259
700	400	26.3	19.0	747.8	434.6	"	"	175	100	344	304	273	304	273	344	304	273	304	273	344	304	273	242
"	450	"	20.2	"	486.8	"	"	"	113	364	327	303	327	303	364	327	303	327	303	364	327	303	256
"	500	"	21.5	"	539.0	"	"	"	125	386	343	314	343	314	386	343	314	343	314	386	343	314	272
"	600	"	23.9	"	643.4	"	"	"	150	432	378	361	378	361	432	378	361	378	361	432	378	361	306

片落短管

公稱內徑 D	管厚		實外徑		管長				重量			
	T	t	D ₂	d ₂	W	S	R	r	兩承片 落短管	承插片 管	插承片 管	兩插片 落短管
800	28.7	20.2	852.2	486.8	340	260	200	113	446	410	359	322
"	"	21.5	"	539.0	"	"	"	125	469	427	382	340
"	"	23.9	"	643.4	"	"	"	159	520	465	433	378
"	"	26.3	"	747.8	"	"	"	175	576	507	489	420
900	31.1	21.5	956.6	539.0	"	"	225	125	541	499	430	388
"	"	23.9	"	643.4	"	"	"	159	593	537	481	427
"	"	26.3	"	747.8	"	"	"	175	649	580	538	469
"	"	28.7	"	852.2	"	"	"	200	714	627	603	516
1000	33.6	21.5	1061.0	539.0	370	280	250	125	651	609	519	477
"	"	23.9	"	643.4	"	"	"	159	703	648	571	516
"	"	26.3	"	747.8	"	"	"	175	766	697	635	566
"	"	28.7	"	852.2	"	"	"	200	836	748	704	617
"	"	31.1	"	956.6	"	"	"	225	915	804	783	672
"	"	33.6	"	1061.0	"	"	"	259	1080	950	928	796
1100	36.0	23.9	1165.4	643.4	"	"	275	159	788	733	634	579
"	"	26.3	"	747.8	"	"	"	175	859	780	696	627
"	"	28.7	"	852.2	"	"	"	200	918	832	766	678
"	"	31.1	"	956.6	"	"	"	225	999	888	846	755
"	"	33.6	"	1061.0	"	"	"	259	1080	950	928	796
1200	38.4	26.3	1269.8	747.8	400	300	300	175	996	926	816	747
"	"	28.7	"	852.2	"	"	"	200	1070	983	891	793
"	"	31.1	"	956.6	"	"	"	225	1150	1040	975	865
"	"	33.6	"	1061.0	"	"	"	259	1240	1130	1060	932
"	"	36.0	"	1165.4	"	"	"	275	1380	1180	1150	1000

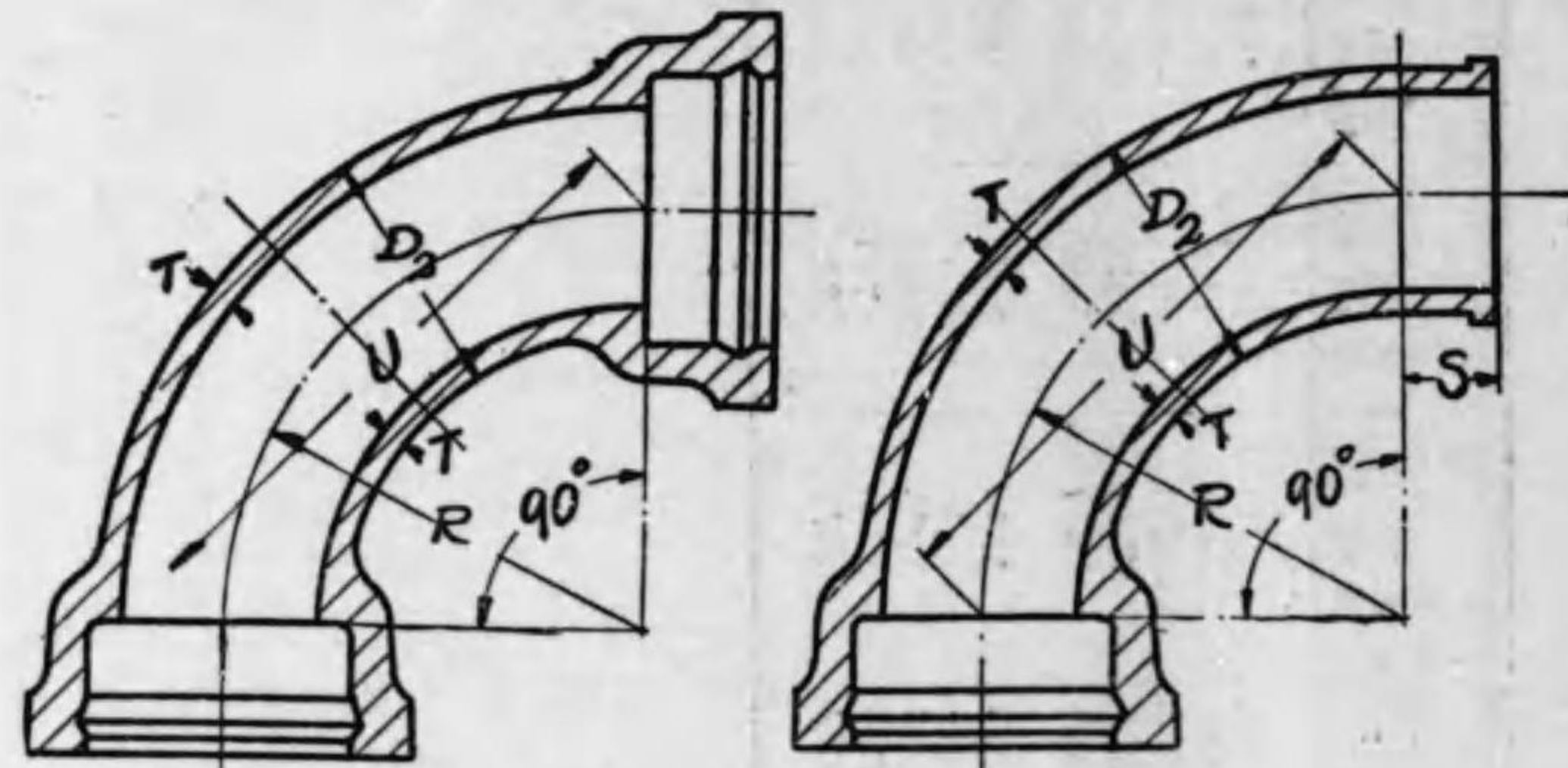
片落短管

公稱內徑 D	管厚		實外徑		管長				重量			
	T	t	D ₂	d ₂	W	S	R	r	兩承片 落短管	承插片 管	插承片 管	兩插片 落短管
1350	42.0	28.7	1335.4	852.2	400	300	348	200	1330	1150	1020	938
"	"	31.1	"	956.6	"	"	"	225	1320	1210	1110	1000
"	"	33.6	"	1061.0	"	"	"	259	1410	1280	1200	1070
"	"	36.0	"	1165.4	"	"	"	275	1500	1350	1290	1140
"	"	38.4	"	1269.8	"	"	"	300	1610	1430	1400	1220
1500	45.7	31.1	1533.0	956.6	445	320	380	225	1530	1470	1320	1210
"	"	33.6	"	1061.0	"	"	"	259	1630	1550	1420	1280
"	"	36.0	"	1165.4	"	"	"	275	1730	1620	1520	1360
"	"	38.4	"	1269.8	"	"	"	300	1890	1710	1630	1450
"	"	42.0	"	1423.4	"	"	"	348	2070	1860	1810	1600

第七號 曲 管 (90°)

第一 表

90° 兩 承 曲 管 90° 曲 管

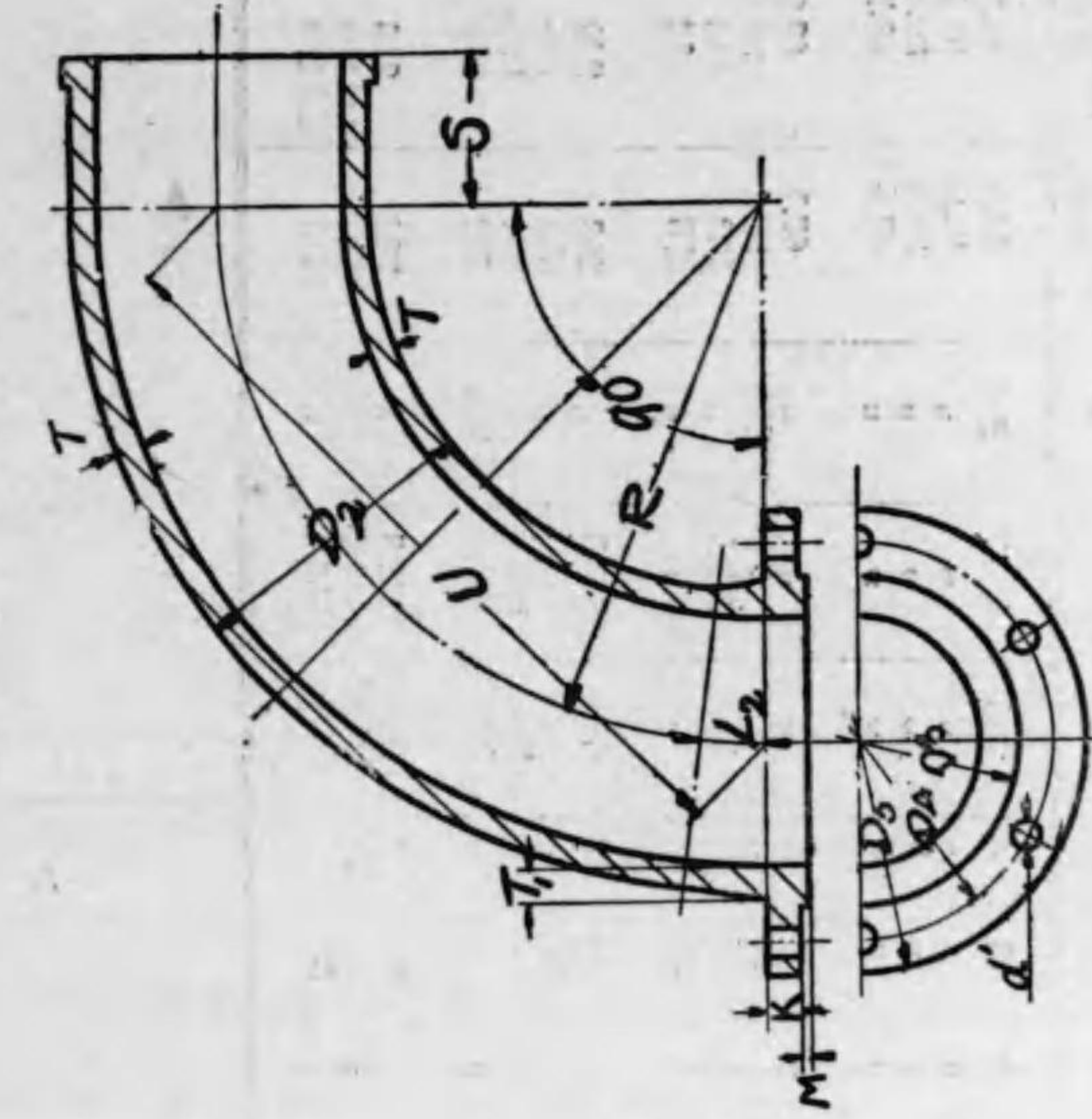


承口及挿口ノ寸法ハ直管ニ同シ $U = 2R \sin 45^\circ$

90° 兩 承 曲 管 及 90° 曲 管

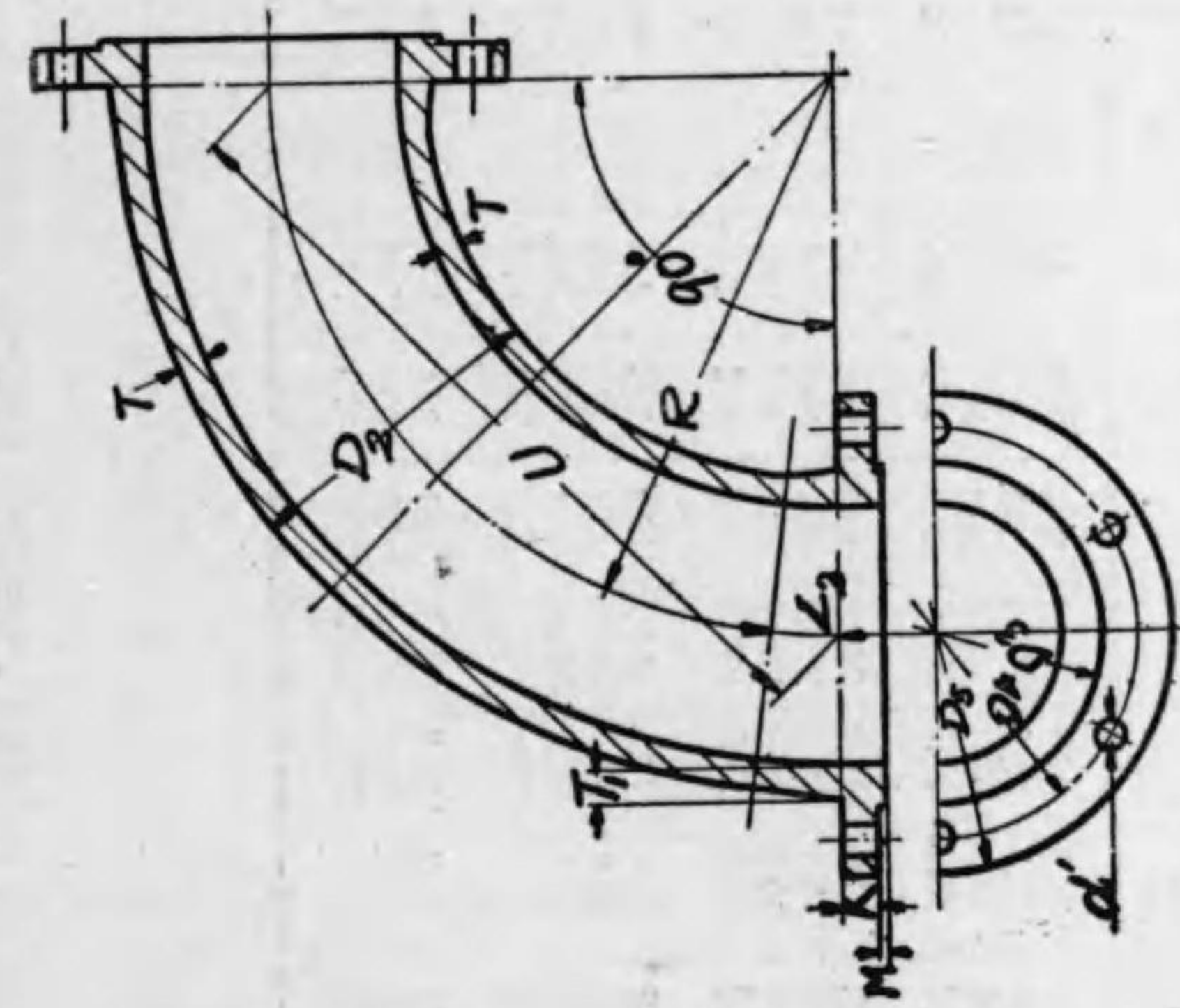
公稱 內徑 D	管 厚 T	實外徑 D ₂	各 部 寸 法			重 量	
			R	U	S	90° 兩 承 曲 管	90° 曲 管
75	11.2	95.4	400	565.7	200	28.8	25.5
100	11.8	121.4	"	"	"	38.6	34.6
125	12.4	147.6	"	"	"	47.9	43.7
150	13.0	173.6	"	"	"	60.3	54.7
200	14.2	225.8	"	"	"	84.0	77.3
250	15.4	278.0	"	"	250	113	104
300	16.6	330.2	500	707.1	"	160	156
350	17.8	382.4	"	"	"	198	194
400	19.0	434.6	600	848.5	"	273	267
450	20.2	486.8	"	"	"	327	319
500	21.5	539.0	700	990.0	"	421	413
600	23.9	643.4	800	1131.4	300	615	639
700	26.3	747.8	900	1272.8	"	857	863
800	28.7	852.2	1000	1414.2	"	1160	1160
900	31.1	956.6	1100	1555.6	"	1530	1530

第九號 曲 管 (90°) 片 鋸 曲 管 表



「ボルト」孔ノ配置ハ管ノ總テノ軸
線ヲ水平ニ爲シタル場合ニ其ノ鋸
面ノ垂直中心線ニ對シ振分トス

第七號 曲 管 (90°) 兩 鋸 曲 管



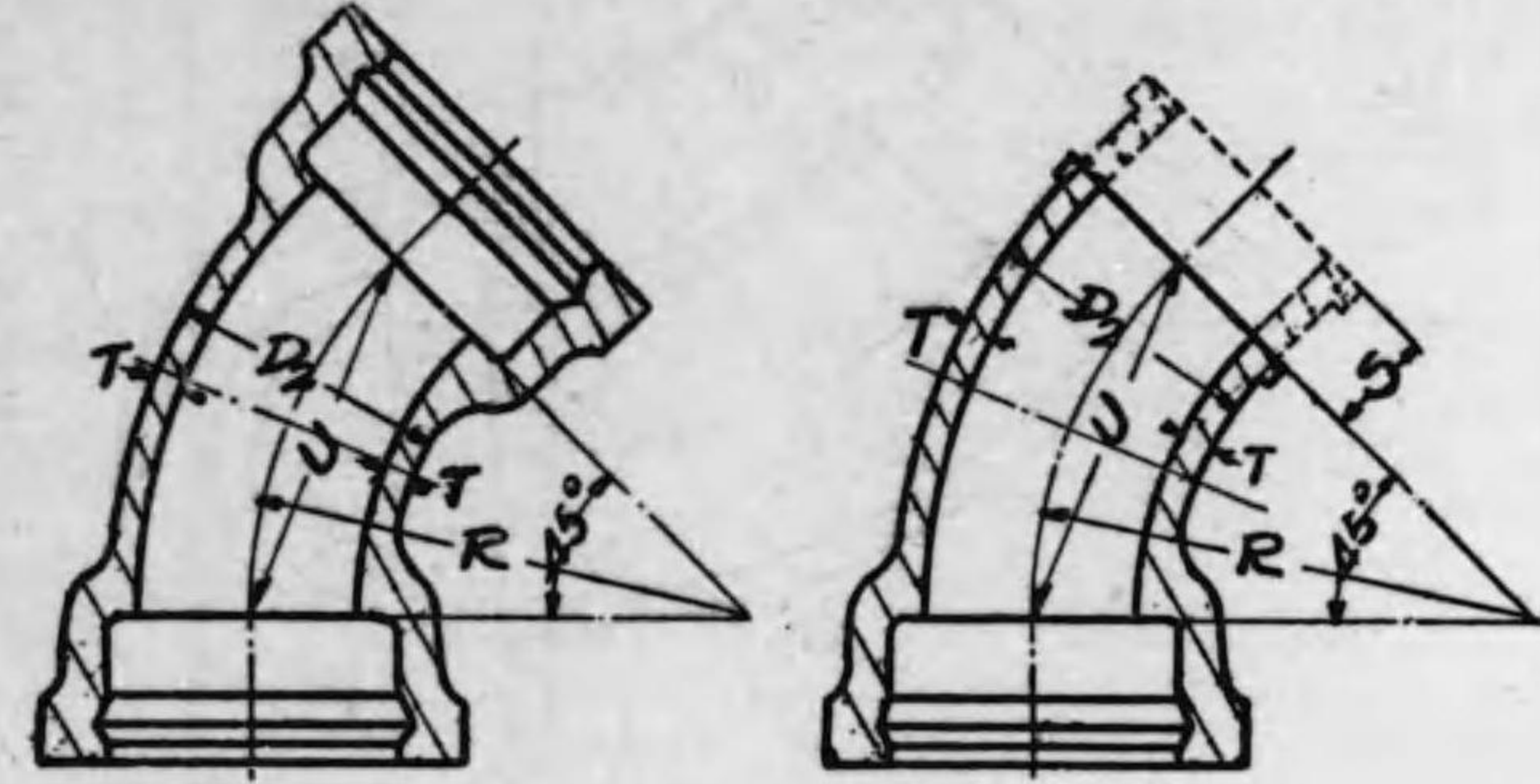
鋸及挿口ノ寸法ハ直管ニ同シ
 $U = 2R \sin 45^\circ$

90°兩銑曲管及90°片銑曲管

公稱 內徑 D	管 厚		實外徑		銑 寸					法		各 部 寸 法		重 量		
	T	T ₁	D ₂	D ₃	D ₅	D ₁	D ₃	L ₂	K	M	$\frac{R}{d}$	互 數	R	U	S	90°兩銑 曲管
75	11.2	16.2	95.4	211	168	125	100	21	3	18	4	400	565.7	200	24.0	23.1
100	11.8	16.8	121.4	238	195	152	"	22	"	"	"	"	"	"	31.9	31.2
125	12.4	17.4	147.6	263	220	177	"	23	"	"	"	"	"	"	39.3	39.4
150	13.0	18.0	173.6	290	247	204	"	24	"	"	"	"	"	"	48.4	48.7
200	14.2	19.2	235.8	342	299	256	"	24	"	21	8	"	"	250	67.1	68.9
250	15.4	20.4	278.0	410	360	308	"	25	"	21	"	"	707.1	"	92.8	94.1
300	16.6	22.6	330.2	464	414	362	120	27	"	24	10	500	"	"	138	146
350	17.8	23.8	382.4	530	472	414	"	28	"	"	"	"	"	"	173	182
400	19.0	25.0	434.6	582	524	466	"	30	"	"	12	600	848.5	"	238	249
450	20.2	26.2	486.8	652	585	518	"	31	"	"	"	700	990.0	"	289	300
500	21.5	27.5	539.0	706	639	572	"	32	"	"	"	800	1131.4	"	372	391
600	23.9	29.9	643.4	810	743	676	"	35	"	"	16	"	"	300	552	589
700	26.3	32.3	747.8	923	854	780	"	38	"	"	20	900	1272.8	"	782	816
800	28.7	35.7	852.2	1034	960	886	140	41	"	"	"	1000	1414.2	"	1060	1110
900	31.1	38.1	956.6	1156	1073	990	"	44	"	"	"	1100	1555.6	"	1410	1470
1000	33.6	40.6	1061.0	"	"	"	"	"	"	"	"	"	"	"	"	"

第八號 曲管 (45°)
第一表

45°兩承曲管 45°曲 管



承口及挿口ノ寸法ハ直管ニ同シ $U = 2R \sin 22\frac{1}{2}^\circ$

45°兩承曲管及45°曲管

公稱內徑 D	管 厚 T	實外徑 D ₂	各 部 寸 法			重 量	
			R	U	S	45°兩承 曲管	45°曲管
75	11.2	95.4	600	459.2	200	25.5	22.2
100	11.8	121.4	"	"	"	34.1	30.0
125	12.4	147.6	"	"	"	41.9	37.7
150	13.0	173.6	"	"	"	52.9	47.3
200	14.2	225.8	"	"	"	73.3	66.7
250	15.4	278.0	"	"	"	99.0	90.0
300	16.6	330.2	700	535.8	"	132	123
350	17.8	382.4	800	612.3	"	175	164
400	19.0	434.6	900	688.3	"	231	216
450	20.2	486.8	1000	765.4	"	294	275
500	21.5	539.0	1100	841.9	"	363	342
600	23.9	643.4	1300	995.0	"	536	507
700	26.3	747.8	1500	1148.1	"	756	719
800	28.7	852.2	1700	1301.1	1030	877
900	31.1	956.6	1900	1454.2	1330	1130
1000	33.6	1061.0	2100	1607.3	1780	1540
1100	36.0	1165.4	2300	1760.3	2240	1960
1200	38.4	1269.8	"	"	2620	2230
1350	42.0	1426.4	"	"	3240	2810
1500	45.7	1583.0	"	"	3910	3390

第九號 曲 管 (22½°)
第一表 22½° 曲 管



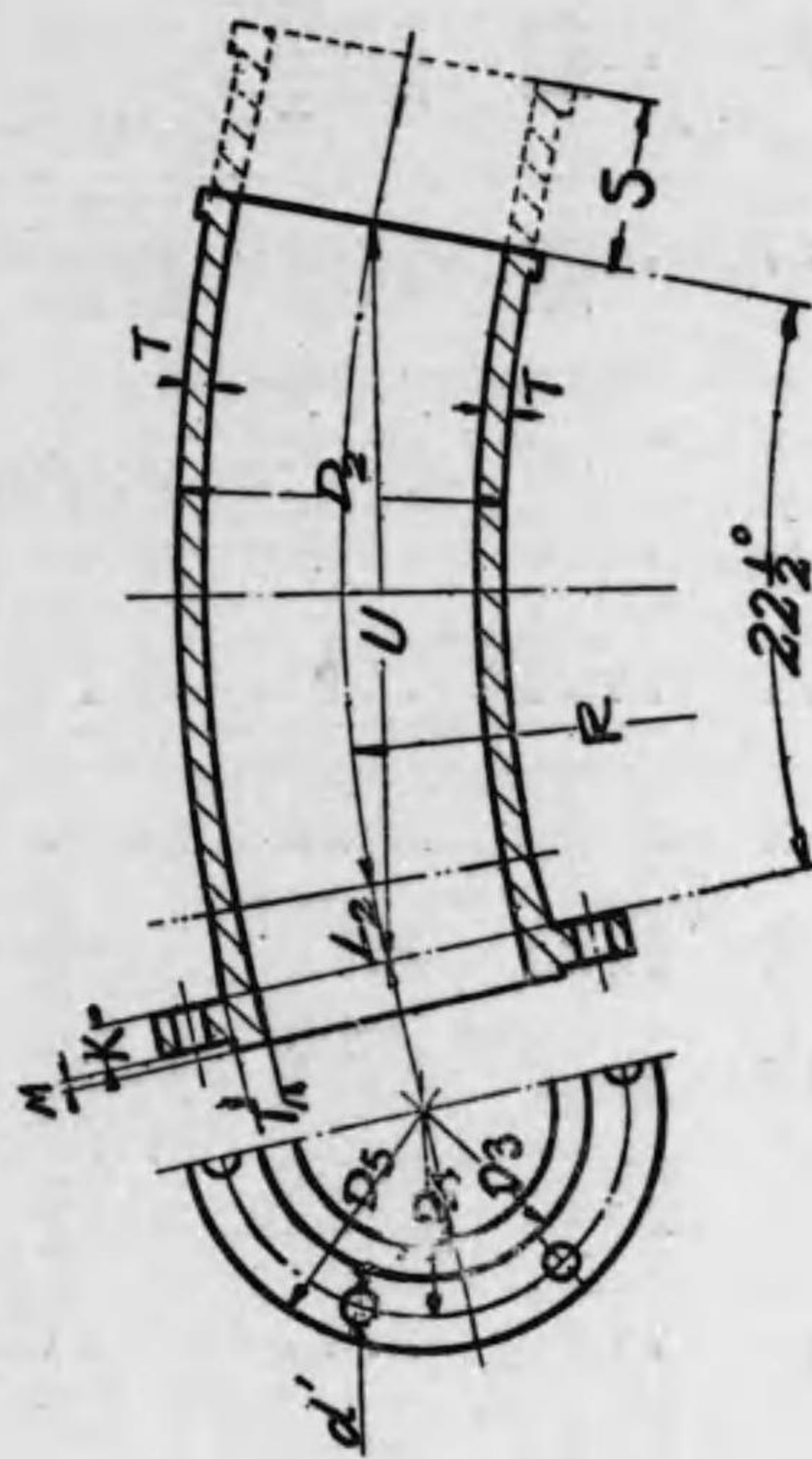
承口及挿口ノ寸法ハ直管ニ同シ

$$U = 2R \sin 11\frac{1}{4}^\circ$$

22½° 曲 管

公稱内徑 D	管 厚 T	實外徑 D ₂	各 部 寸 法			重 量
			R	U	S	
75	11.2	95.4	1200	468.2	150	21.1
100	11.8	121.4	"	"	"	28.5
125	12.4	147.6	"	"	"	35.8
150	13.0	173.6	"	"	"	45.0
200	14.2	225.8	"	"	"	63.3
250	15.4	278.0	"	"	"	85.4
300	16.6	330.2	1400	546.3	"	117
350	17.8	382.4	1600	624.3	"	135
400	19.0	434.6	1800	702.3	"	180
450	20.2	486.8	2000	780.4	"	233
500	21.5	539.0	2200	858.4	"	292
600	23.9	643.4	2600	1014.5	"	441
700	26.3	747.8	3000	1170.5	"	634
800	28.7	852.2	3400	1326.6	"	876
900	31.1	956.6	3800	1482.7	"	1180
1000	33.6	1061.0	4200	1638.8	"	1540
1100	36.0	1165.4	4500	1755.8	"	1920
1200	38.4	1269.8	"	"	"	2240
1350	42.0	1426.4	"	"	"	2760
1500	45.7	1583.0	"	"	"	3340

第九號 曲 管 (22½°)
第二表 22½° 片 鈔 曲 管



「ボルト」孔ノ配置ハ管ノ總子ノ軸
線ヲ水平ニ爲シタル場合ニ共ノ鈔
面ノ垂直中心線ニ對シ振分トス

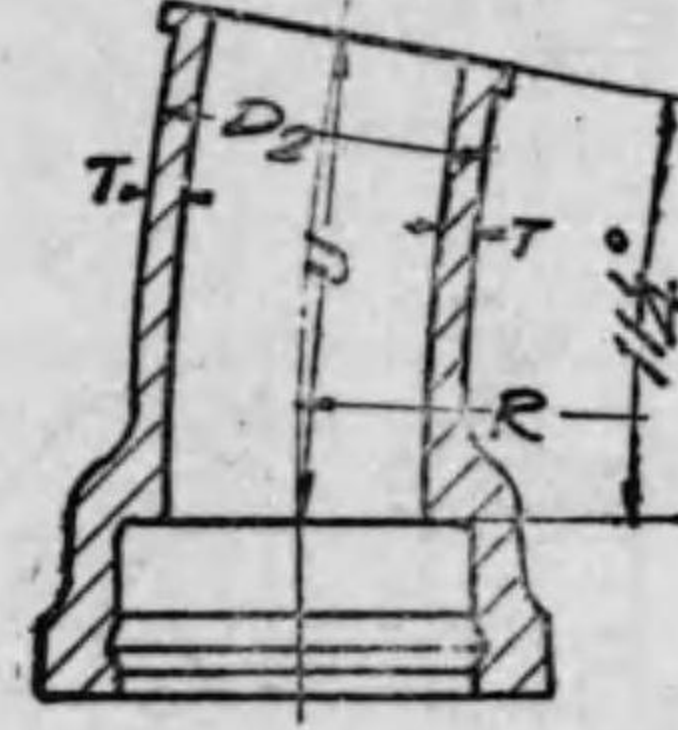
$$U = 2R \sin 11\frac{1}{4}^\circ$$

鈔及挿口ノ寸法ハ直管ニ同シ

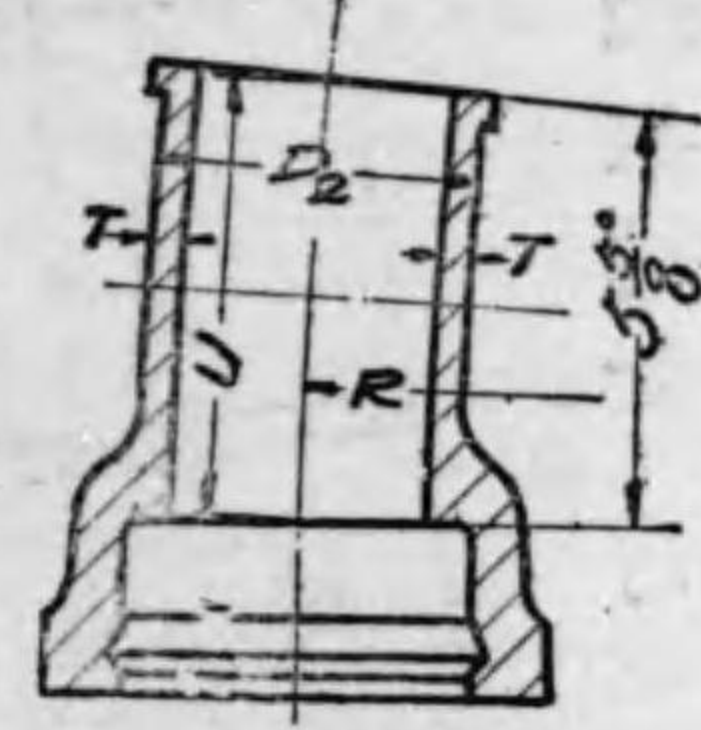
22 1/2° 片 鋸 曲 管

公稱 內徑 D	管 厚		實外徑		鈔 寸										法 寸		各 部 寸		重 量
	T	t ₁	D ₂	L ₂	D ₁	D ₄	D ₃	K	M	α	β	γ	δ	ε	R	U	S	重	
75	11.2	16.2	95.4	100	211	168	125	21	3	18	4	1200	408.2	150	18.7				
100	11.8	16.8	131.4	"	238	152	152	22	"	"	"	"	"	"	25.1				
125	12.4	17.4	147.6	"	263	157	177	23	"	"	"	"	"	"	31.5				
150	13.0	18.0	173.6	"	290	204	204	23	"	"	"	"	"	"	39.0				
200	14.2	19.2	225.8	"	342	256	256	24	"	8	"	"	"	"	55.0				
250	15.4	20.4	278.0	"	410	308	308	26	4	21	"	"	"	"	75.1				
300	16.6	22.6	330.2	120	464	362	362	27	"	24	"	"	546.3	106					
350	17.8	23.8	382.4	"	530	414	414	28	"	"	"	"	624.3	123					
400	19.0	25.0	434.6	"	582	466	466	30	"	12	"	"	702.3	163					
450	20.2	26.2	486.8	"	652	518	518	31	"	"	"	"	780.4	213					
500	21.5	27.5	539.0	"	706	585	572	32	"	27	"	"	858.4	270					
600	23.9	29.9	643.4	"	810	743	676	35	"	"	"	"	1014.5	410					
700	26.3	32.3	747.8	"	928	854	780	38	"	30	"	"	1170.5	596					
800	28.7	35.7	852.2	140	1024	960	886	41	"	35	"	"	1526.6	829					
900	31.1	38.1	956.6	"	1156	1073	990	44	"	"	"	"	1482.7	1120					
1000	33.6	40.6	1061.0	"	1262	1179	1096	46	"	"	"	"	1638.8	1460					
1100	36.0	43.0	1165.4	"	1366	1200	1200	49	"	"	"	"	1755.8	1830					
1200	38.4	45.4	1269.8	"	1470	1304	1304	52	"	"	"	"	"	2120					
1350	42.0	50.0	1426.4	160	1642	1462	1462	56	"	38	"	"	"	2630					
1500	45.7	53.7	1583.0	"	1800	1620	1620	60	"	"	"	"	"	3180					

第十號曲管 (11 1/4°)
第一表 11 1/4° 曲管



第十一號曲管 (5 5/8°)
第一表 5 5/8° 曲管

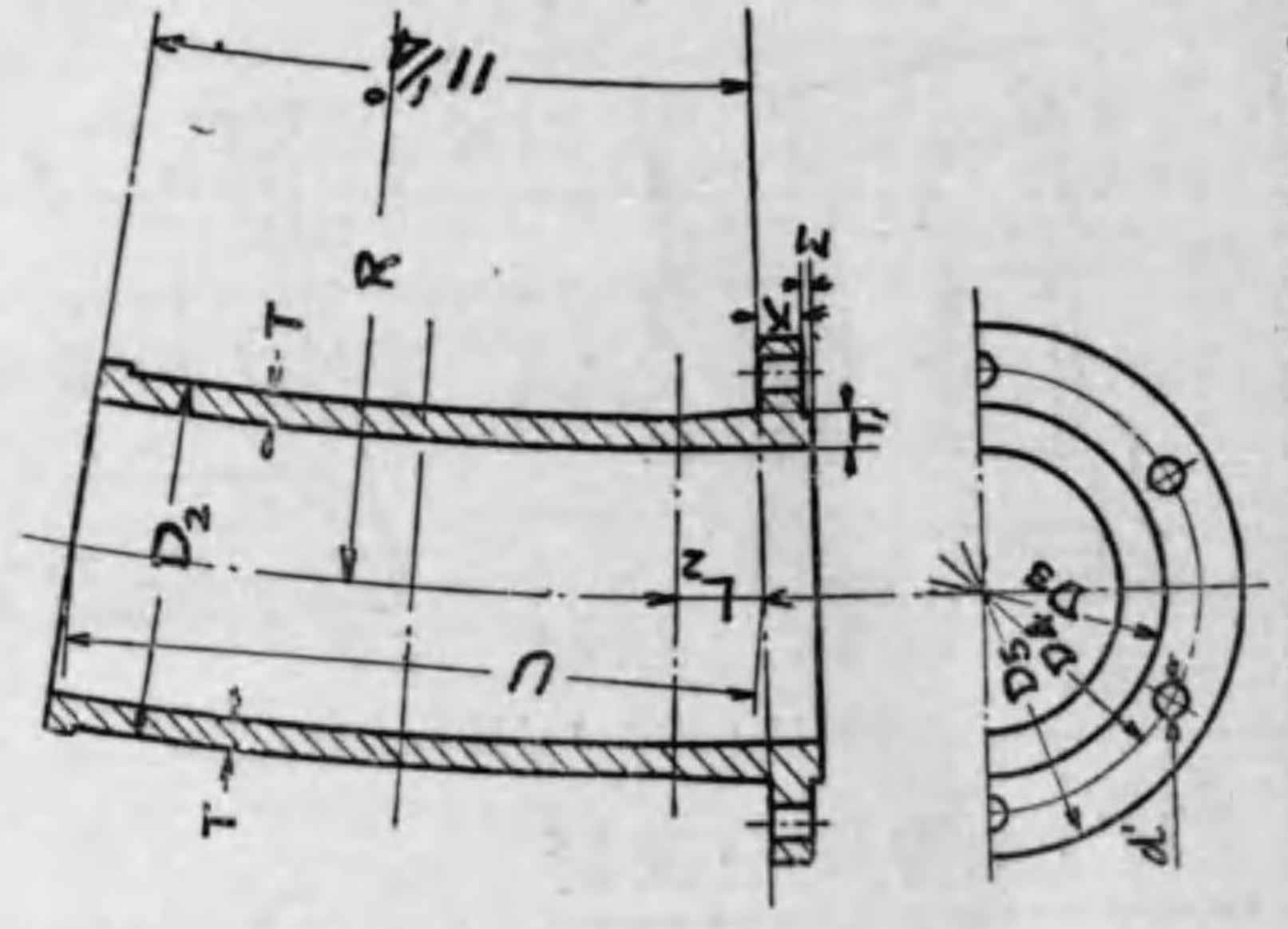


承口及挿口ノ寸法ハ直管ニ同シ

11 1/4° 曲管及 5 5/8° 曲管

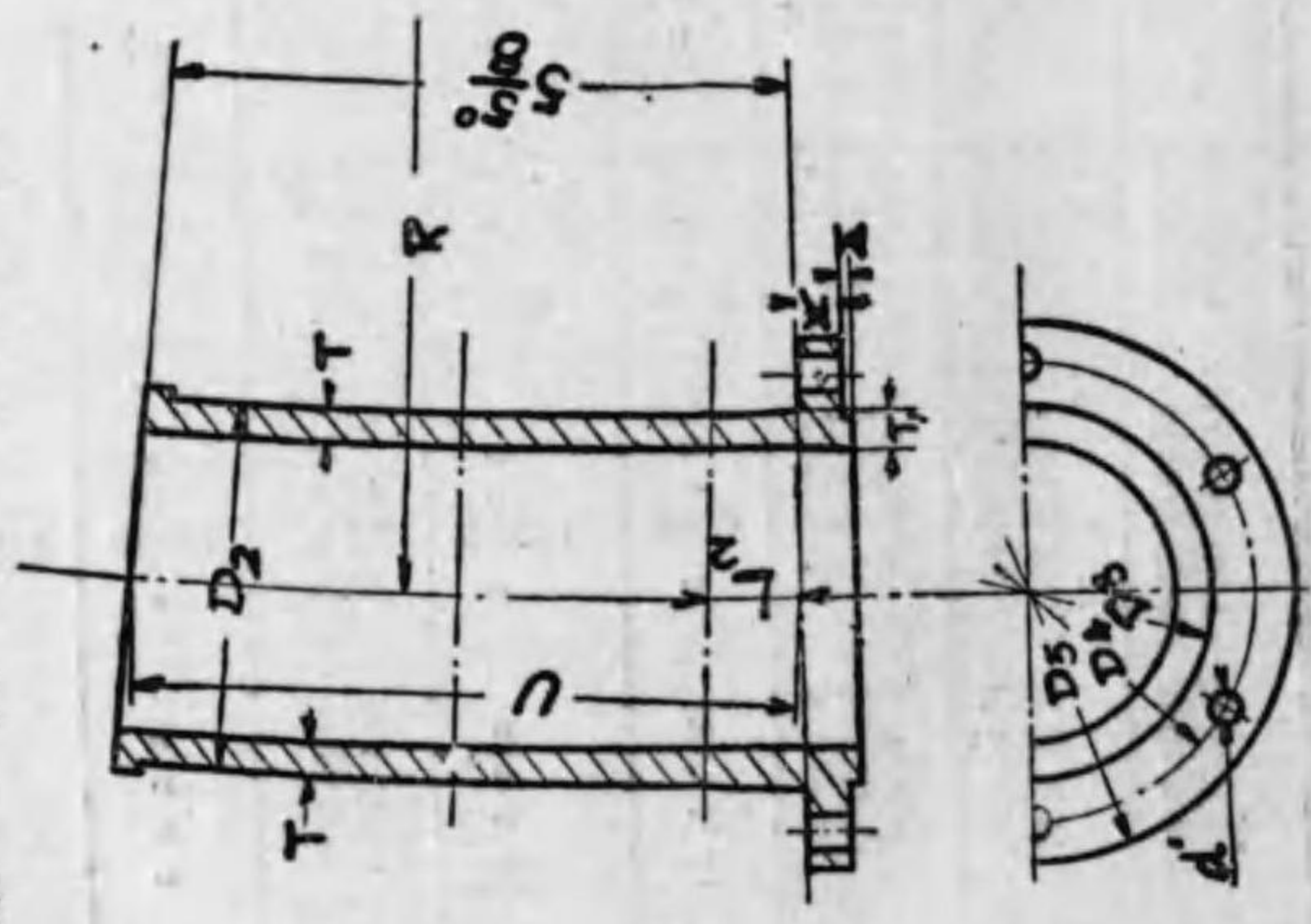
公稱 內徑 D	管 厚 T	實外徑 D ₂	11 1/4° 曲 管		5 5/8° 曲 管	
			R	U	R	U
75	11.2	95.4	3000	588.1	20.4
100	11.8	121.4	"	"	27.6
125	12.4	147.6	"	"	34.6
150	13.0	173.6	"	"	43.4
200	14.2	225.8	4000	784.1	74.4
250	15.4	278.0	"	"	100
300	16.6	330.2	"	"	127	10000
350	17.8	382.4	5000	980.2	187	981.4
400	19.0	434.6	"	"	229	"
450	20.2	486.8	"	"	274	"
500	21.5	539.0	6000	1176.2	371	12000
600	23.9	643.4	"	"	494	1177.6
700	26.3	747.8	"	"	634	"
800	28.7	852.2	"	"	792	"
900	31.1	956.6	"	"	972	"
1000	33.6	1061.0	"	"	1170	1170
1100	36.0	1165.4	"	"	1380	"
1200	38.4	1269.8	"	"	1610	"
1350	42.0	1426.4	"	"	1990	"
1500	45.7	1583.0	"	"	2410	2410

第十一號 曲管 (5 1/8°)
 第一表 5 1/8° 片 鑄 曲 管



「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平ニ爲シ
 タル場合ニ共ノ鑄面ノ垂直中心線ニ對シ振分トス

第十號 曲管 (11 1/8°)
 第一表 11 1/8° 片 鑄 曲 管



鑄及挿口ノ寸法ハ直管ニ同シ

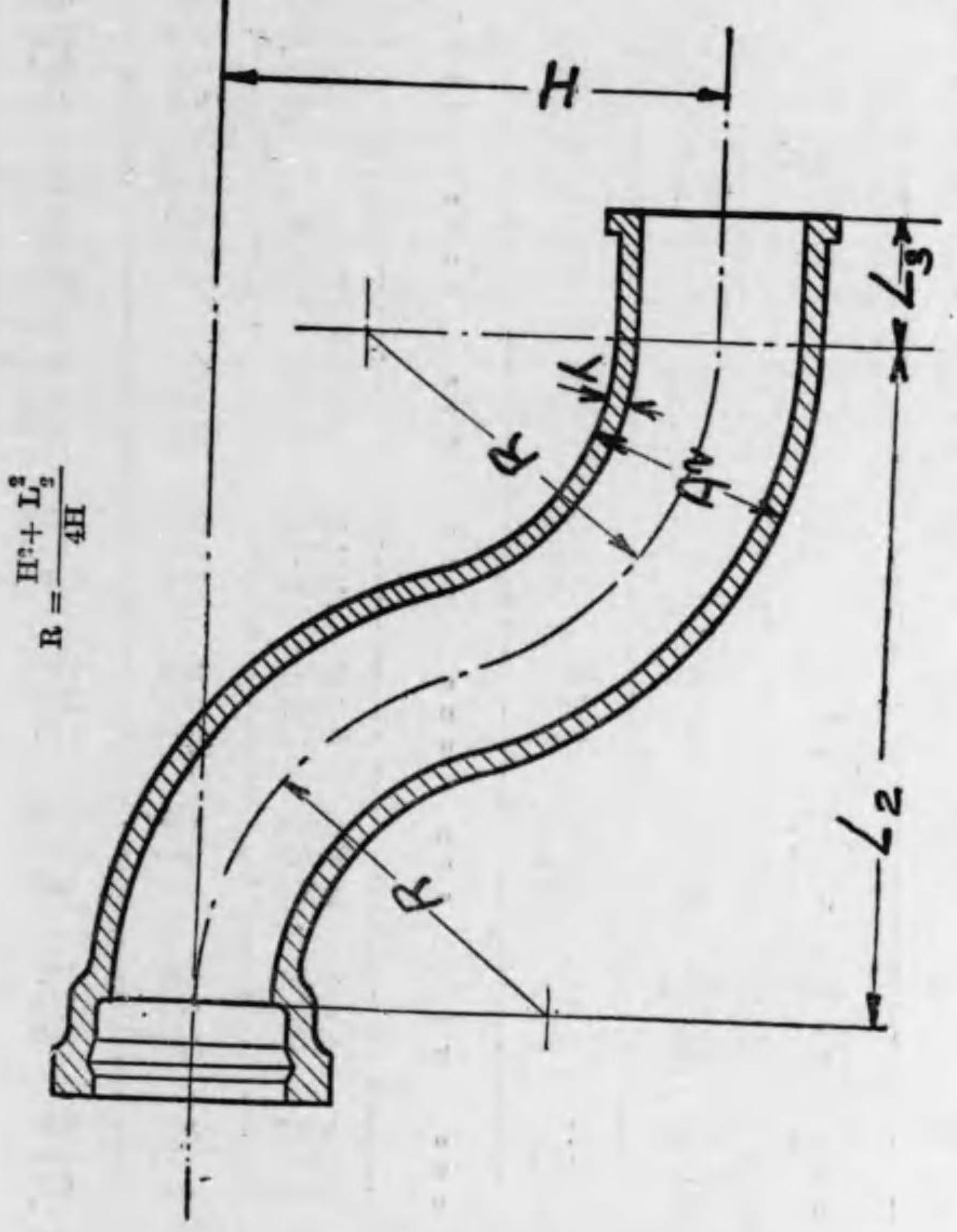
11 1/8° 片 鑄 曲 管

公 稱 內 徑	管 厚	實 外 徑		寸						法			各 部 寸 法		量 重
		T ₁	D ₂	D ₃	D ₄	D ₅	K	M	ボルト數	R	U				
75	11.2	16.2	95.4	211	168	125	100	21	3	18	4	3000	588.1	18.0	
100	11.8	16.8	121.4	238	195	152	"	22	"	"	"	"	"	24.2	
125	12.4	17.4	147.6	263	220	177	"	23	"	"	"	"	"	30.3	
150	13.0	18.0	173.6	290	247	204	"	"	"	"	"	"	"	37.4	
200	14.2	19.2	225.8	342	299	256	"	24	"	21	8	4000	784.1	65.9	
250	15.4	20.4	278.0	410	360	308	120	26	"	21	"	"	"	90.2	
300	16.6	22.6	330.2	464	414	362	"	27	4	24	10	5000	"	116	
350	17.8	23.8	382.4	530	472	414	"	28	"	"	"	"	980.2	175	
400	19.0	25.0	434.6	582	524	466	"	30	"	27	12	"	"	212	
450	20.2	26.2	486.8	632	585	518	"	31	"	"	"	"	"	255	
500	21.5	27.5	539.0	706	639	572	"	32	"	"	"	6000	1176.2	349	
600	23.9	29.9	642.4	810	743	676	"	35	"	"	16	"	"	462	
700	26.2	32.2	747.8	928	851	780	"	38	"	30	20	"	"	596	
800	28.7	35.7	852.2	1034	960	886	140	41	5	35	24	"	"	745	
900	31.1	38.1	956.6	1156	1073	990	"	44	"	"	"	"	"	915	
1000	33.6	40.6	1061.0	1262	1179	1096	"	46	"	"	"	"	"	1090	
1100	36.0	43.0	1165.4	1366	1238	1200	"	49	"	"	"	"	"	1390	
1200	38.4	45.4	1269.8	1470	1387	1304	"	52	"	"	28	"	"	1490	
1350	42.0	50.0	1426.4	1642	1552	1462	160	56	6	38	"	"	"	1860	
1500	45.7	53.7	1583.0	1800	1710	1620	"	60	"	"	32	"	"	2240	

5 1/2° 片鋸曲管

公稱 內徑 D	管 厚		實外徑		鈔					寸				法			名 部 寸 法		重 量
	T	T ₁	D ₂	D ₅	D ₄	D ₃	L ₂	K	M	α	孔 數	R	U	重 量					
300	16.6	22.6	330.2	464	414	362	120	27	4	21	10	10000	481.4	140					
350	17.8	23.8	382.4	530	472	414	"	28	"	24	"	"	"	175					
400	19.0	25.0	434.6	582	524	466	"	30	"	27	"	"	"	212					
450	20.2	26.2	486.8	652	585	518	"	31	"	"	"	"	"	255					
500	21.5	27.5	539.0	706	639	572	"	32	"	"	16	12000	1177.6	349					
600	23.9	29.9	643.4	810	743	676	"	35	"	30	20	"	"	462					
700	26.3	32.3	747.8	928	854	780	140	38	5	"	"	"	"	596					
800	28.7	35.7	852.2	1034	960	886	"	41	"	"	"	"	"	745					
900	31.1	38.1	956.6	1156	1073	990	"	44	"	35	24	"	"	915					
1000	33.6	40.6	1061.0	1262	1179	1096	"	46	"	"	"	"	"	1090					
1100	36.0	43.0	1165.4	1366	1238	1200	"	49	"	"	"	"	"	1290					
1200	38.4	45.4	1269.8	1470	1387	1304	"	52	"	"	"	"	"	1490					
1350	42.0	50.0	1426.4	1642	1552	1462	160	56	6	53	32	"	"	1860					
1500	45.7	53.7	1583.0	1800	1710	1620	"	60	"	"	"	"	"	2240					

第十二號 乙字管

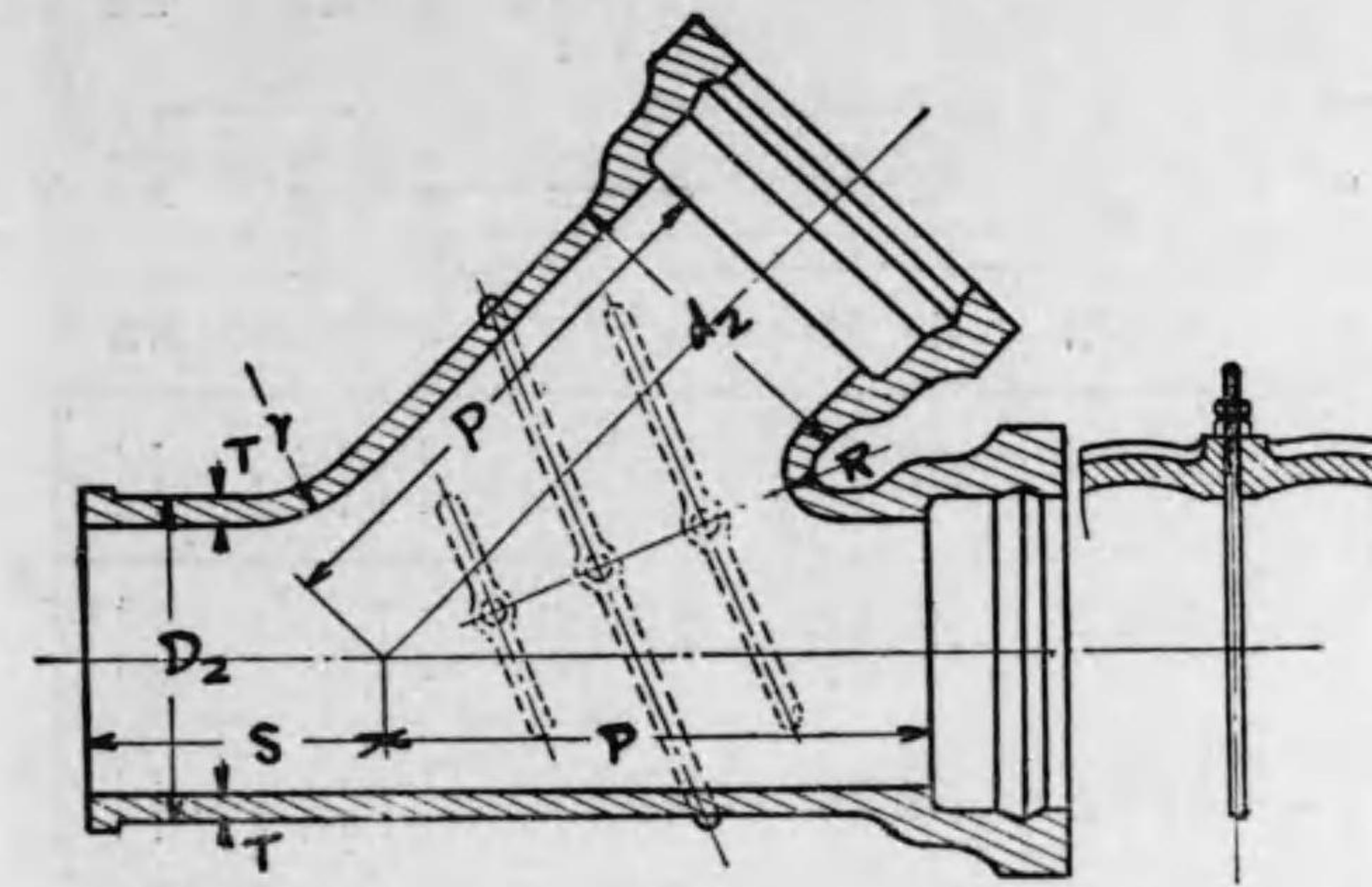


承口及挿口ノ寸法ハ直管ニ同シ

乙字管

公称内径	管厚	实外径	各部寸法				重量
			D ₂	L ₂	L ₃	R	
75	11.2	95.4	300	200	162.5	200	20.3
"	"	"	350	"	177.0	300	22.9
"	"	"	400	"	200.0	450	26.6
100	11.8	121.4	350	"	203.1	200	23.5
"	"	"	400	"	208.3	300	31.9
"	"	"	450	"	225.0	450	36.8
"	"	"	500	"	250.0	600	42.1
125	12.4	147.6	400	"	"	200	37.4
"	"	"	480	"	267.0	300	42.5
"	"	"	550	"	280.5	450	49.0
"	"	"	600	"	300.0	600	55.6
150	13.0	173.6	480	"	267.0	300	53.2
"	"	"	550	"	280.5	450	61.4
"	"	"	600	"	300.0	600	69.5
200	14.2	225.8	550	"	327.0	300	79.0
"	"	"	650	"	347.2	450	91.7
"	"	"	700	"	354.1	600	103
250	15.4	278.0	600	"	375.0	300	111
"	"	"	700	"	384.7	450	128
"	"	"	800	"	416.6	600	145
300	16.6	330.2	680	"	460.3	300	148
"	"	"	800	"	468.0	450	171
"	"	"	900	"	487.5	600	193
350	17.8	382.4	680	220	460.3	300	187
"	"	"	800	"	468.0	450	216
"	"	"	900	"	487.5	600	243
400	19.0	434.6	750	"	543.7	300	241
"	"	"	900	"	562.5	450	280
"	"	"	1000	"	566.6	600	312

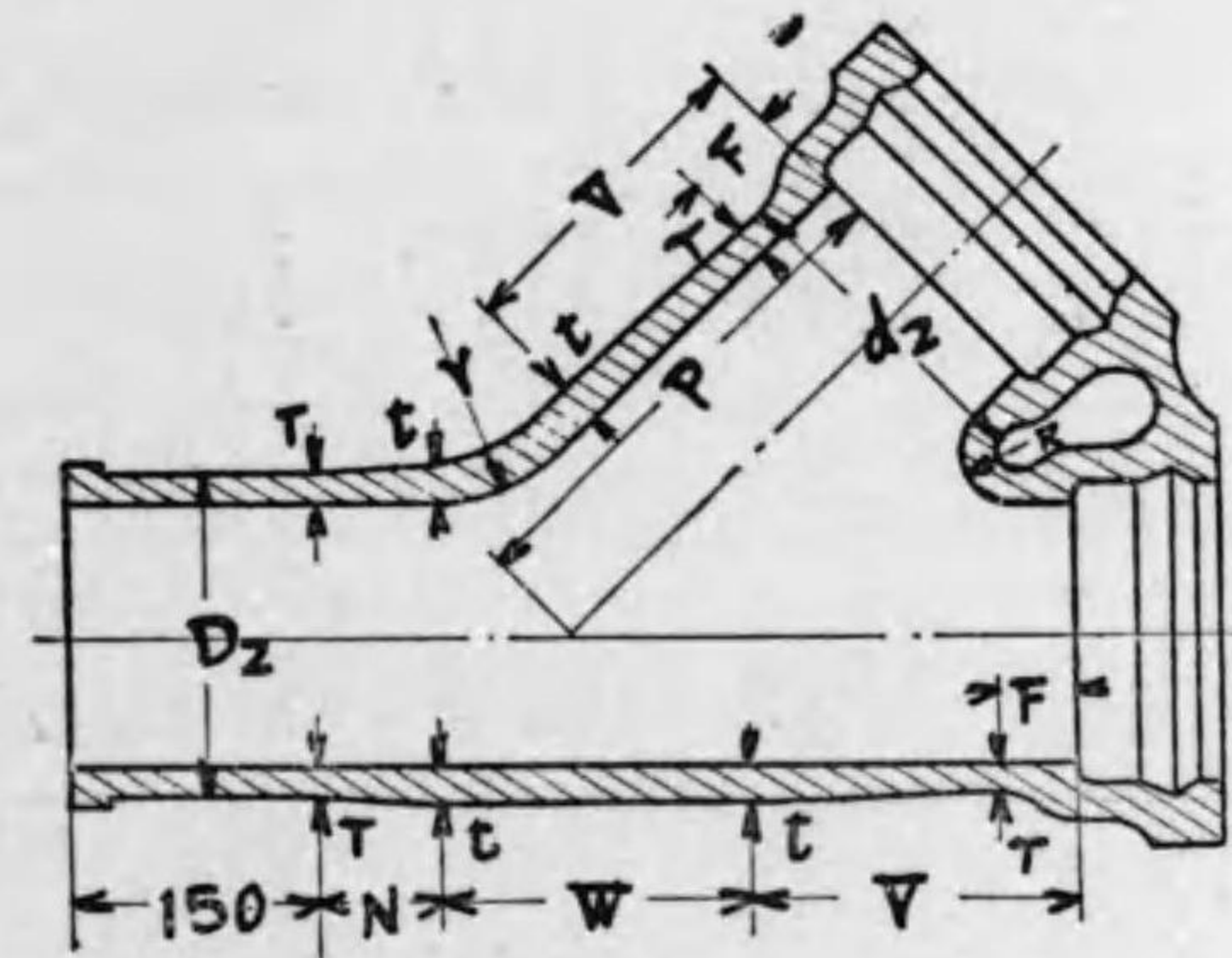
第十三號 叉管



$$P+S=V+W+N+150$$

$$R=1.5T$$

$$r=10T$$



承口及挿口ノ寸法=直管=同シ
D500以下ノ管ニハ「ボルト」及「リツブ」ヲ附セス

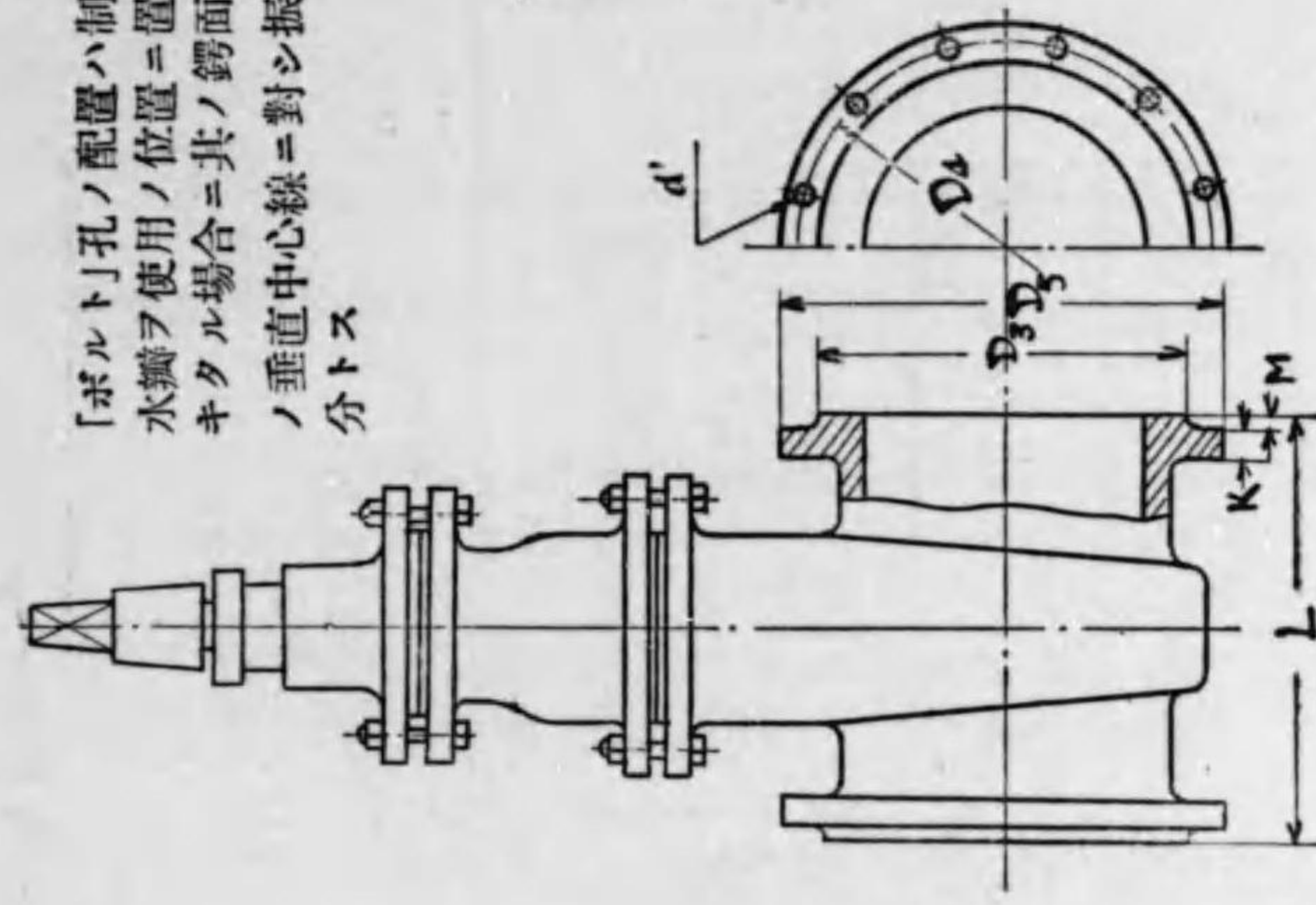
又 管

公称内径 D	管 内 径		管 厚 t	管 外 径		管 長					R	r	重 量 〔リツプ〕重 量ヲ含マス
	d	T		D ₂	d ₂	P	S	V	W	N			
75	75	12.5	15.0	95.4	240	270	157	159	44	19	125	33.0	
100	100	13.2	16.3	121.4	270	290	182	169	59	20	135	46.9	
125	125	14.0	16.6	147.6	300	310	207	180	73	21	140	60.9	
150	150	14.7	17.0	173.6	330	330	236	190	84	22	145	79.2	
200	200	15.4	18.3	225.8	410	360	300	211	109	23	155	121	
250	250	16.2	19.5	278.0	470	390	356	232	114	24	165	172	
300	300	16.9	20.2	330.2	550	410	419	252	119	25	170	227	
350	350	17.8	21.3	382.4	610	440	472	273	125	27	180	295	
400	400	19.0	23.2	434.6	700	440	640	295	145	29	190	456	
450	450	20.2	23.5	486.8	800	470	711	305	164	30	200	583	
500	500	21.5	30.5	539.0	940	480	780	318	172	32	215	724	
600	600	23.9	33.6	643.4	1100	500	36	240	914	
700	700	26.3	36.3	747.8	1200	530	40	265	1230	
800	800	28.7	38.7	852.2	1350	570	43	280	1670	
900	900	31.1	31.1	956.6	1500	610	47	310	2220	
1000	1000	33.6	33.6	1061.0	1700	630	50	335	2840	
1100	1100	36.0	36.0	1165.4	1800	650	54	360	3560	
1200	1200	38.4	38.4	1269.8	1900	670	58	385	4400	

制水瓣 第十四號 制水瓣

公称内径 D	寸		法	管 間 隔		公称内径 D
	D ₃	D ₄		L	重量	
75	211	168	4	21	240	45
100	238	195	"	22	250	55
125	263	220	"	23	260	75
150	290	247	"	23	280	100
200	342	299	"	24	300	160
250	410	360	"	26	380	250
300	464	414	"	27	400	340
350	530	472	"	28	430	450
400	582	524	"	30	470	550
450	652	585	"	31	500	760
500	706	639	"	32	530	980
600	810	743	"	35	560	1500
700	928	854	"	38	610	2000
800	1034	960	"	41	690	2800
900	1156	1073	"	44	740	3600
1000	1262	1179	"	46	770	4500
1100	1366	1283	"	49	800	5400
1200	1470	1387	"	52	820	7000
1350	1643	1552	"	56	850
1500	1800	1710	"	60	900

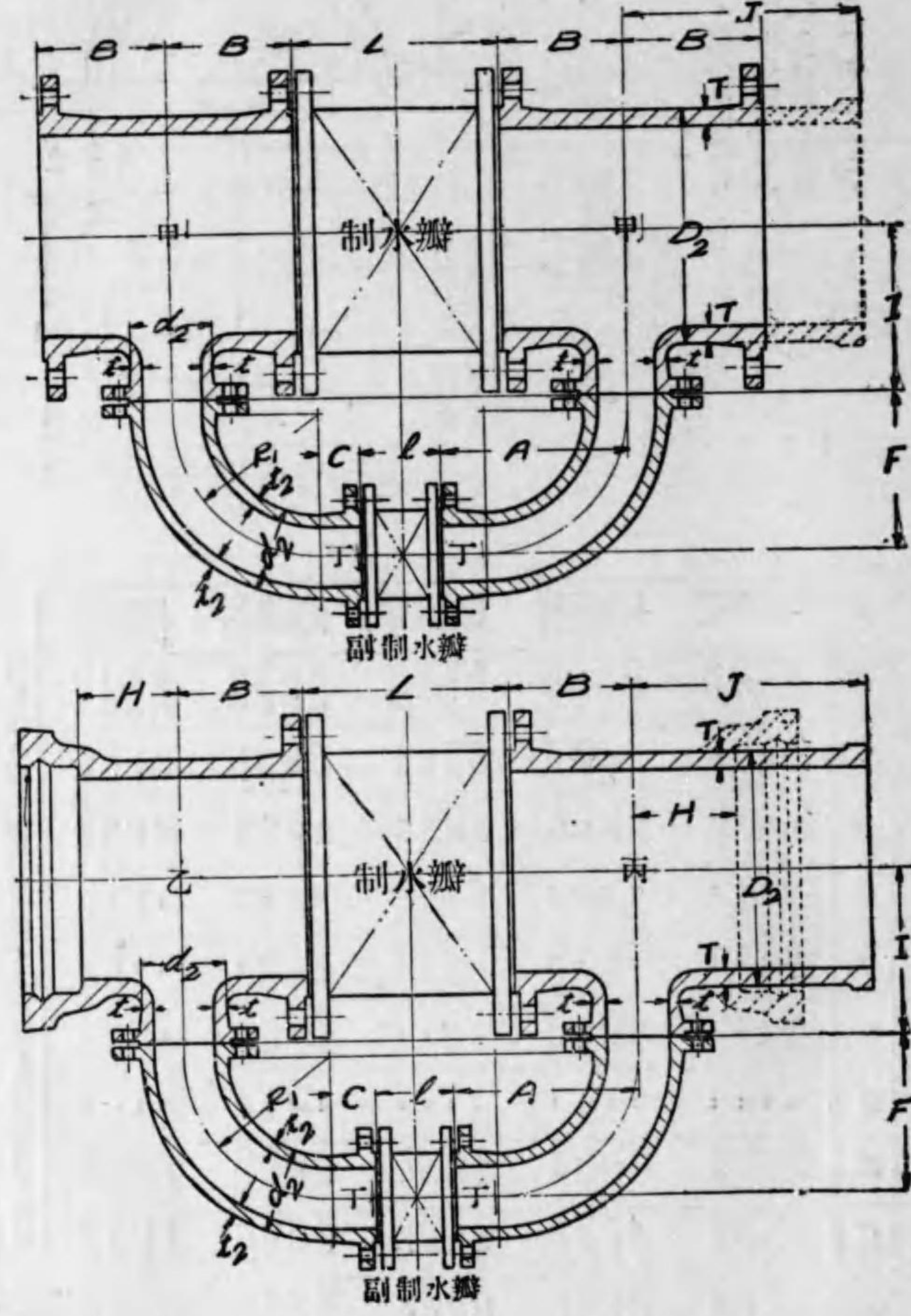
※ 制水瓣ノ重量ハ標準重量ニ非ス單ニ本表使用者ノ便ヲ圖リ參
考トシテ附ス



「ボルト」孔ノ配置ハ制
水瓣ヲ使用ノ位置ニ置
キタル場合ニ共ノ鑄面
ノ垂直中心線ニ對シ振
分トス

第十五號 制水瓣副管

第一表



$$H = F + \frac{D}{10} + R + \frac{d}{2} + 50$$

$$A = R_1 + C$$

$$B = L_2 + M + K + \frac{D}{10} + R_1 + \frac{d}{2}$$

$$C = \left(B + \frac{L}{2} \right) - \left(R_1 + \frac{d}{2} \right)$$

$$F = m + k + R_1$$

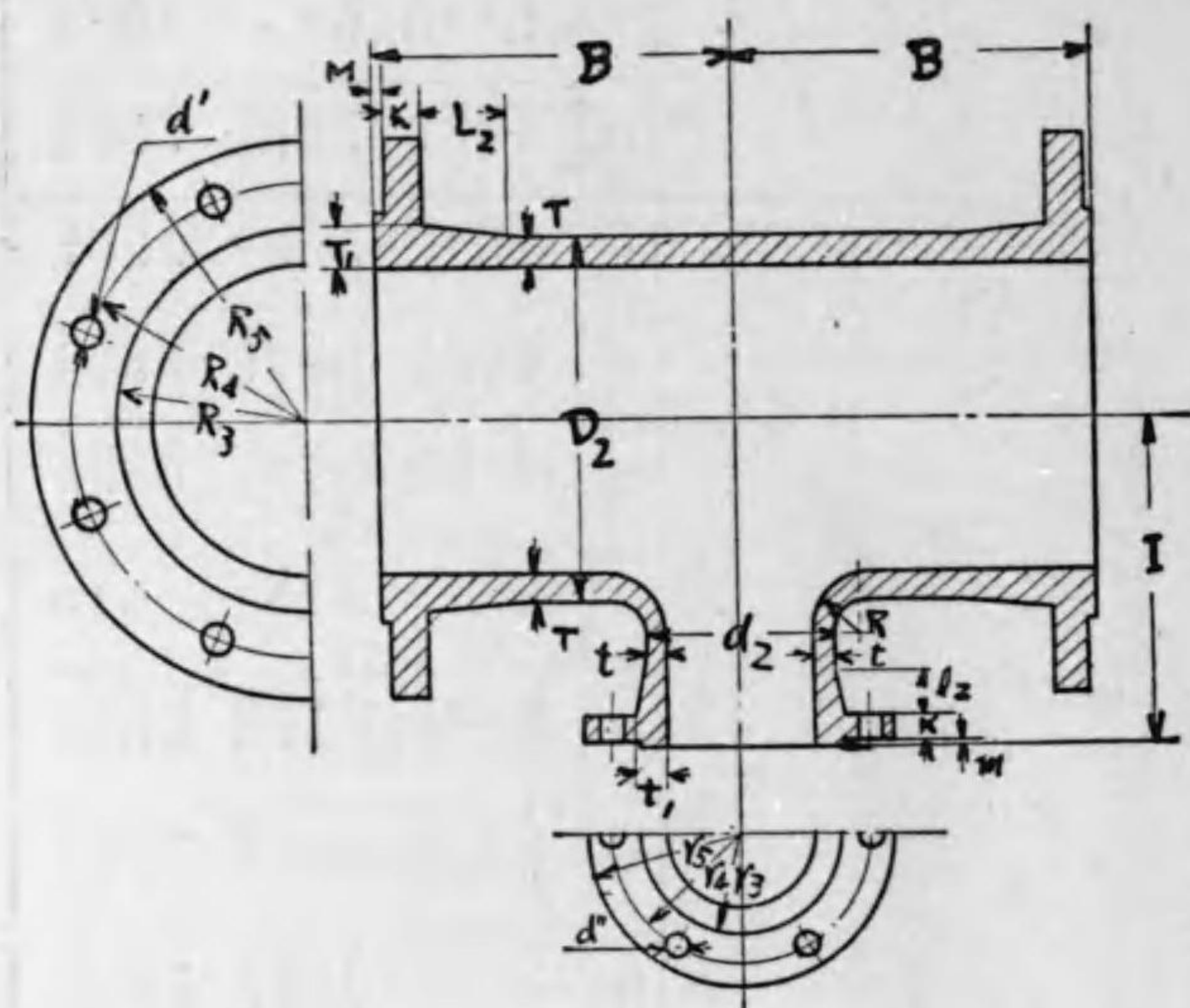
$$I = l_2 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$J = P + \frac{d}{2} + 100$$

制水瓣副管

公稱內徑 D	管 厚										實 外 徑										各 部 寸 法												
	d	T	t	t ₂	D ₂	d ₂	A	B	C	F	H	I	J	L	l	R ₁	d	T	t	t ₂	D ₂	d ₂	A	B	C	F	H	I	J	L	l	R ₁	
400	100	19.0	16.0	11.8	434.6	121.4	445	335	45	425	270	395	700	470	250	400	100	19.0	16.0	11.8	434.6	121.4	445	335	45	425	270	395	700	470	250	400	
450	"	20.2	"	"	456.8	"	465	340	65	"	"	420	770	500	"	"	100	20.2	"	"	456.8	"	465	340	65	"	"	420	770	500	"	"	
500	"	21.5	"	"	539.0	"	485	345	85	"	"	435	840	530	"	"	100	21.5	"	"	539.0	"	485	345	85	"	"	435	840	530	"	"	
600	125	23.9	"	12.4	643.4	147.6	510	360	110	"	"	510	400	560	260	"	100	23.9	"	12.4	643.4	147.6	510	360	110	"	"	435	840	530	"	"	
700	150	26.3	17.0	13.0	747.8	173.6	585	420	185	425	350	571	800	610	280	"	100	26.3	17.0	13.0	747.8	173.6	585	420	185	425	350	571	800	610	280	"	"
800	"	28.7	"	14.2	852.2	"	615	450	215	"	"	621	810	680	"	"	100	28.7	"	14.2	852.2	"	615	450	215	"	"	435	840	530	"	"	
900	200	31.1	18.0	"	956.6	225.8	690	470	290	427	420	637	840	740	300	"	100	31.1	18.0	"	956.6	225.8	690	470	290	427	420	637	840	740	300	"	"
1000	"	33.6	"	"	1061.0	"	715	480	315	"	"	737	840	770	"	"	100	33.6	"	"	1061.0	"	715	480	315	"	"	435	840	530	"	"	
1100	"	36.0	"	"	1165.4	"	755	505	335	"	"	797	845	800	"	"	100	36.0	"	"	1165.4	"	755	505	335	"	"	435	840	530	"	"	
1200	250	38.4	19.0	15.4	1269.8	278.0	760	540	360	429	450	851	875	820	380	"	100	38.4	19.0	15.4	1269.8	278.0	760	540	360	429	450	851	875	820	380	"	"
1350	"	42.0	"	"	1426.4	"	815	580	415	"	"	929	885	850	"	"	100	42.0	"	"	1426.4	"	815	580	415	"	"	431	845	815	850	"	"
1500	300	45.7	20.0	16.6	1583.0	330.2	885	635	485	431	570	1041	915	900	400	"	100	45.7	20.0	16.6	1583.0	330.2	885	635	485	431	570	915	900	400	"	"	

第十五號
第二



制水瓣副管甲

公稱内徑		管厚		實外徑		R	管長				本管			
D	d	T	t	D ₂	d ₂		B	I	L ₂	l ₂	T ₁	K	M	R ₅
400	100	19.0	16.0	434.6	121.4	60	335	395	120	100	25.0	30	4	291
450	"	20.2	"	486.8	"	"	340	420	"	"	26.2	31	"	326
500	"	21.5	"	539.0	"	"	345	445	"	"	27.5	32	"	353
600	125	23.9	"	643.4	147.6	80	360	550	"	"	29.9	35	"	405
700	150	26.3	17.0	747.8	173.6	"	420	571	"	"	32.3	38	"	464
800	"	28.7	"	852.2	"	"	450	621	140	"	35.7	41	5	517
900	200	31.1	18.0	956.6	225.8	90	470	687	"	"	38.1	44	"	578
1000	"	33.6	"	1061.0	"	"	480	737	"	"	40.6	46	"	631
1100	"	36.0	"	1165.4	"	100	505	797	"	"	43.0	49	"	683
1200	250	38.4	19.0	1269.8	278.0	"	540	854	"	"	45.4	52	"	735
1350	"	42.0	"	1426.4	"	"	580	929	160	"	50.0	56	6	821
1500	300	45.7	20.0	1583.0	330.2	110	635	1041	"	120	53.7	60	"	900

制水瓣副管
表 制水瓣副管甲

$$B = L_2 + M + K + \frac{D}{10} + R + \frac{d}{2}$$

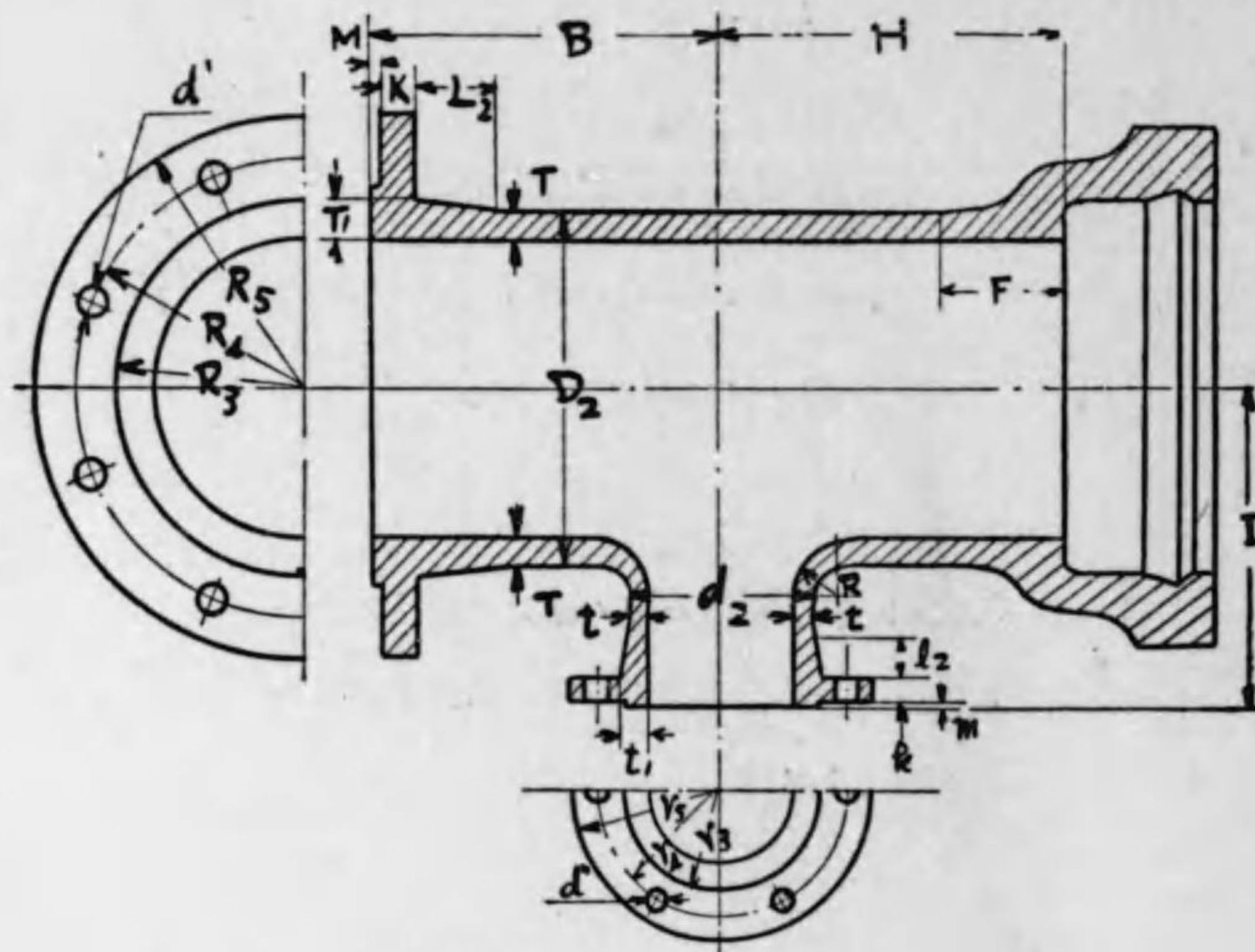
$$I = l_2 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

鑄ノ寸法ハ直管=同シ

「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平
= 爲シタル場合ニ其ノ鑄面ノ垂直中心線ニ
對シ振分トス

鑄		枝				管				鑄		重量	公稱内徑	
R ₄	R ₅	ボルト孔 d' 數		t ₁	k	m	r ₅	r ₄	r ₃	ボルト孔 d' 數			D	d
262.0	233	24	12	21.0	22	3	119.0	97.5	76.0	18	4	189	400	100
292.5	259	27	"	"	"	"	"	"	"	"	"	230	450	"
319.5	286	"	"	"	"	"	"	"	"	"	"	269	500	"
371.5	338	"	16	"	"	"	131.5	110.0	88.5	"	6	360	600	125
427.0	390	30	"	22.0	23	"	145.0	123.5	102.0	"	"	516	700	150
480.0	443	"	20	"	"	"	"	"	"	"	"	680	800	"
536.5	495	35	"	23.0	24	"	171.0	149.5	128.0	"	8	859	900	200
589.5	548	"	24	"	"	"	"	"	"	"	"	1030	1000	"
641.5	600	"	"	"	"	"	"	"	"	"	"	1250	1100	"
693.5	652	"	28	25.0	26	"	205.0	180.0	154.0	21	"	1520	1200	250
776.0	731	38	"	"	"	"	"	"	"	"	"	2010	1350	"
855.0	810	"	32	26.0	27	4	233.0	207.0	181.0	"	10	2570	1500	300

第十五號
第三



制水瓣副管 乙

公稱内徑 D	管厚 d	實外徑 T	管厚 t	實外徑 D ₂	實外徑 d ₂	R	管 長					本			
							B	I	H	L ₁	L ₂	T ₁	K	M	R ₅
400	100	19.0	16.0	436.6	121.4	60	335	395	270	120	100	25.0	30	4	291.0
450	"	20.2	"	486.8	"	"	340	420	"	"	"	26.2	31	"	326.0
500	"	21.5	"	539.0	"	"	345	445	230	"	"	27.5	32	"	353.0
600	125	23.9	"	643.4	147.6	"	360	550	"	"	"	29.9	35	"	405.0
700	150	26.3	17.0	747.8	173.6	80	420	571	350	"	"	32.3	38	"	464.0
800	"	28.7	"	852.2	"	"	450	621	370	140	"	35.7	41	5	517.0
900	200	31.1	18.0	956.6	225.8	90	470	687	420	"	"	38.1	44	"	578.0
1000	"	33.6	"	1061.0	"	"	480	737	435	"	"	40.6	46	"	631.0
1100	"	36.0	"	1165.4	"	100	505	797	450	"	"	43.0	49	"	683.0
1200	250	38.4	19.0	1269.8	278.0	"	540	854	495	"	"	45.4	52	"	735.0
1350	"	42.0	"	1426.4	"	"	580	929	515	160	"	50.0	56	6	821.0
1500	300	45.7	20.0	1583.0	330.2	110	635	1041	570	"	120	53.7	60	"	900.0

制水瓣副管
表 制水瓣副管 乙

$$B = L_2 + M + K + \frac{D}{10} + R + \frac{d}{2}$$

$$I = l_2 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

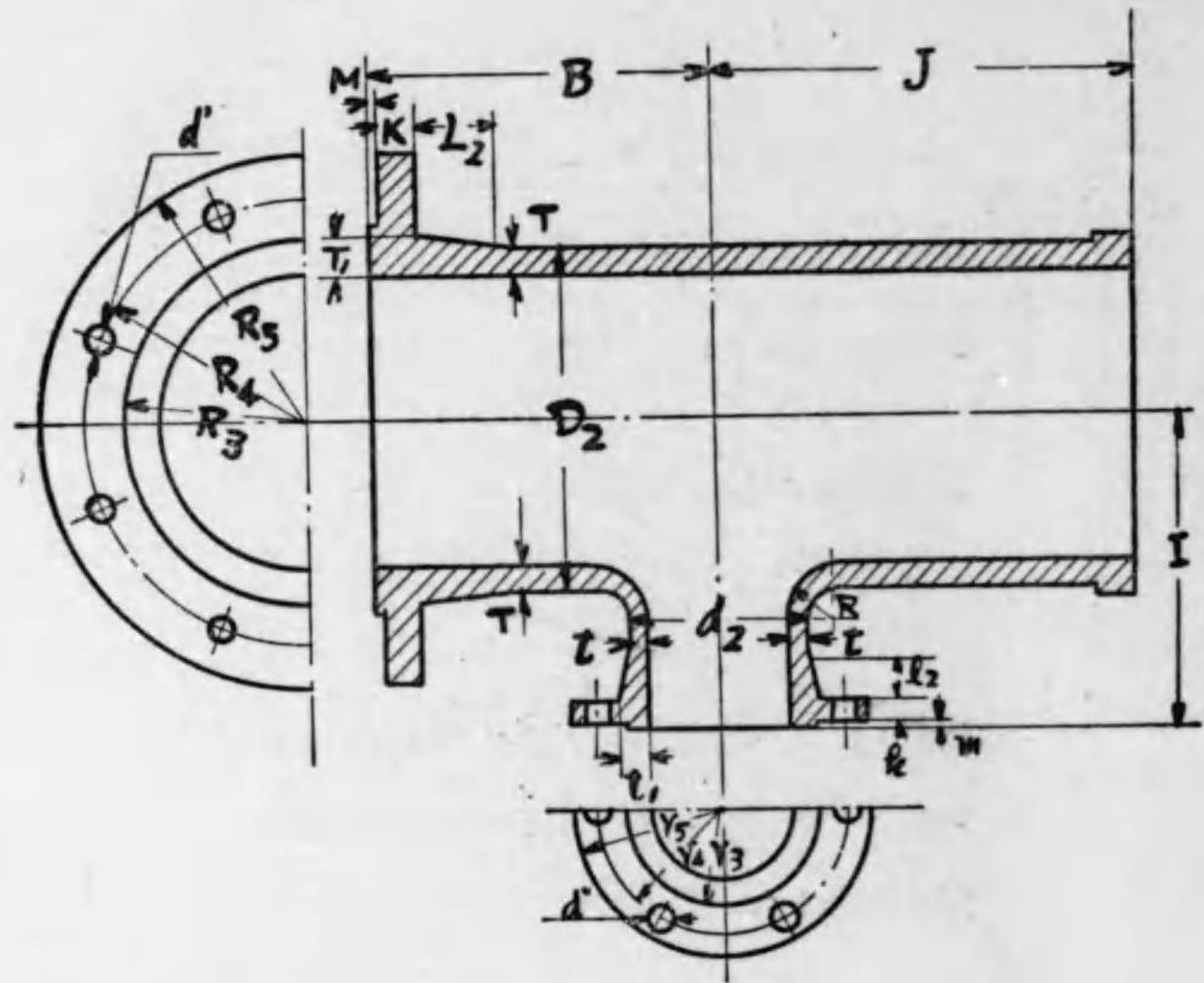
$$H = F + \frac{D}{10} + R + \frac{d}{2} + 30$$

銑及承口ノ寸法ハ直管ニ同シ

「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平
ニ爲シタル場合ニ其ノ銑面ノ垂直中心線ニ
對シ振分トス

管 銑		枝 管 銑							重量		公稱内徑	
R ₄	R ₅	ボルト孔 d' 數	t ₁	k	m	r ₅	r ₄	r ₃	ボルト孔 d' 數	D	d	
262.0	233.0	24 12	21.0	22	3	119.0	97.5	76.0	18 4	201	400	100
292.5	259.0	27 "	"	"	"	"	"	"	" "	242	450	"
319.5	286.0	" "	"	"	"	"	"	"	" "	283	500	"
371.5	333.0	" 16	"	"	"	131.5	110.0	88.5	" 6	378	600	125
427.0	390.0	30 "	22.0	23	"	145.0	123.5	102.0	" "	542	700	150
480.0	443.0	" 20	"	"	"	"	"	"	" "	706	800	"
536.5	495.0	35 "	23.0	24	"	171.0	149.5	128.0	" 8	915	900	200
589.5	548.0	" 24	"	"	"	"	"	"	" "	1110	1000	"
641.5	600.0	" "	"	"	"	"	"	"	" "	1340	1100	"
693.5	652.0	" 28	24.0	26	"	205.0	180.0	154.0	21 "	1660	1200	250
776.0	731.0	38 "	"	"	"	"	"	"	" "	2120	1350	"
855.0	810.0	" 32	26.0	27	4	232.0	207.0	181.0	" 10	2740	1500	300

第十五號 制
第四表 制 水



制水瓣副管 丙

公稱内徑 D	管厚 d	管厚 T	實外徑 t	D ₂	d ₂	R	管 長					本			
							B	I	J	L ₂	I ₂	T ₁	K	M	R ₅
400	100	19.0	16.0	434.6	121.4	60	335	395	760	120	100	25.0	30	4	291.0
450	"	20.2	"	486.8	"	"	340	420	770	"	"	26.2	31	"	326.0
500	"	21.5	"	539.0	"	"	345	445	"	"	"	27.5	32	"	353.0
600	125	23.9	"	643.4	147.6	"	360	550	785	"	"	29.9	35	"	405.0
700	150	26.3	17.0	747.8	173.6	80	420	571	800	"	"	32.3	38	"	464.0
800	"	28.7	"	852.2	"	"	450	621	810	140	"	35.7	41	5	517.0
900	200	31.1	18.0	956.6	225.8	90	470	687	840	"	"	38.1	44	"	578.0
1000	"	33.6	"	1061.0	"	"	480	737	"	"	"	40.6	46	"	631.0
1100	"	36.0	"	1165.4	"	100	505	797	845	"	"	43.0	49	"	683.0
1200	250	38.4	19.0	1269.8	278.0	"	540	854	875	"	"	45.4	52	"	735.0
1350	"	42.0	"	1426.4	"	"	580	929	885	160	"	50.0	56	6	821.0
1500	300	45.7	20.0	1583.0	330.2	110	635	1041	915	"	120	53.7	60	"	900.0

水 瓣 副 管
瓣 副 管 丙

$$B = L_2 + M + K + \frac{D}{10} + R + \frac{d}{2}$$

$$I = l_2 + m + k + \frac{d}{10} + R + \frac{D}{2}$$

$$J = P + \frac{d}{2} + 600$$

鑄及挿口ノ寸法ハ直管=同シ

「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平
=爲シタル場合=其ノ鑄面ノ垂直中心線=
對シ振分トス

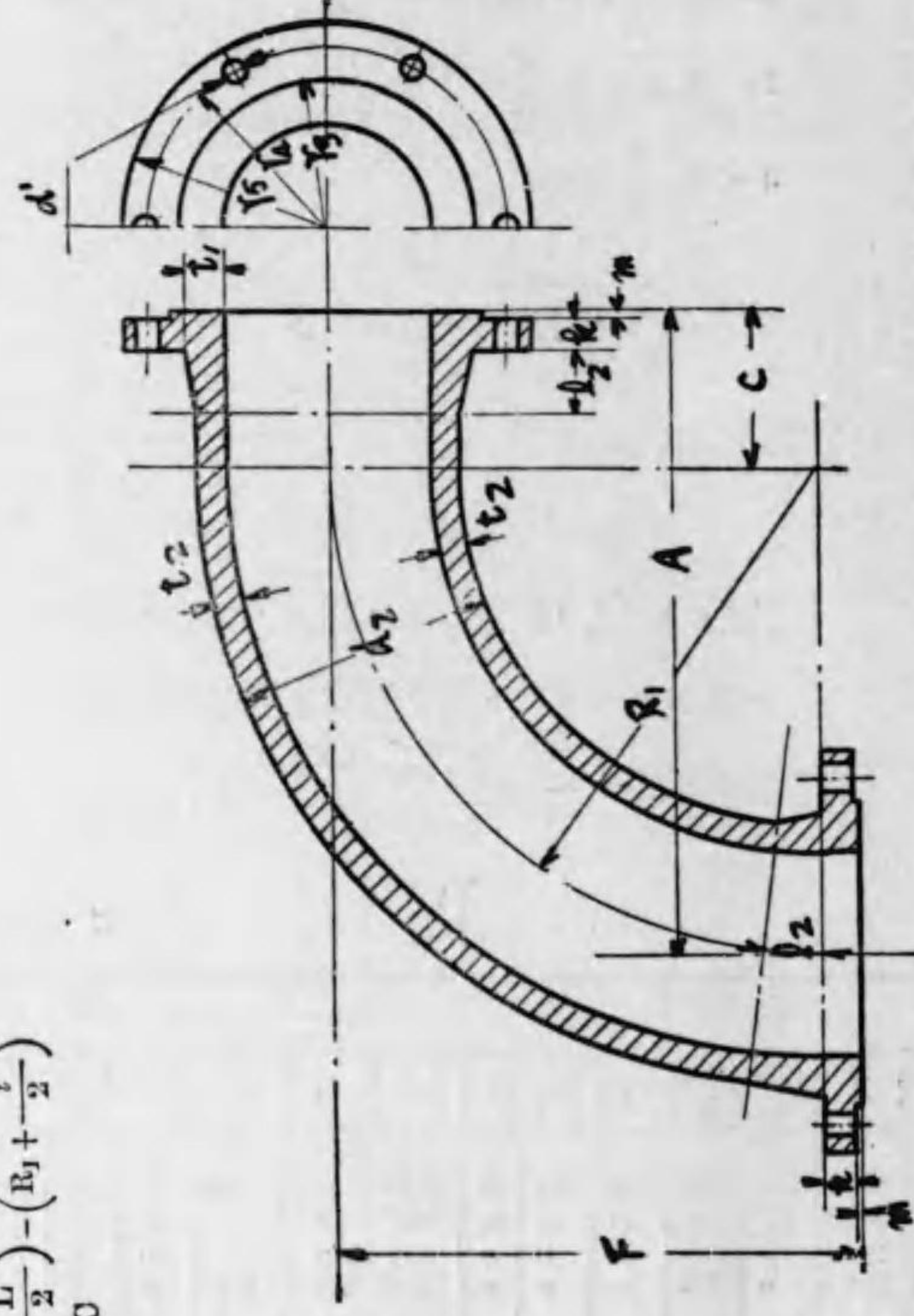
管 鑄		枝 管					管 鑄		重量	公稱内徑					
R ₄	R ₅	ボルト孔 d' 數	t ₁	k	m	r ₅	r ₄	r ₃		D	d				
262.0	233.0	24	12	21.0	22	3	119.0	97.5	76.0	18	4	237	400	100	
292.5	259.0	27	"	"	"	"	"	"	"	"	"	"	286	450	"
319.5	286.0	"	"	"	"	"	"	"	"	"	"	"	336	500	"
371.5	338.0	"	16	"	"	"	131.5	110.0	88.5	"	6	450	600	125	
427.0	390.0	30	"	22.0	23	"	145.0	123.5	102.0	"	"	618	700	150	
480.0	443.0	"	20	"	"	"	"	"	"	"	"	"	784	800	"
536.5	495.0	35	"	23.0	24	"	171.0	149.5	128.0	"	8	990	900	200	
589.5	548.0	"	24	"	"	"	"	"	"	"	"	1180	1000	"	
641.5	600.0	"	"	"	"	"	"	"	"	"	"	1420	1100	"	
693.5	652.0	"	28	24.0	26	"	205.0	180.0	154.0	21	"	1720	1200	250	
776.0	731.0	38	"	"	"	"	"	"	"	"	"	2190	1350	"	
855.0	810.0	"	32	26.0	27	4	232.0	207.0	181.0	"	10	2740	1500	300	

第十五號 制水瓣副管
第五表 制水瓣副管丁

$$F = R_1 + k + m$$

$$C = \left(B + \frac{L}{2} \right) - \left(R_1 + \frac{l}{2} \right)$$

$$A = R_1 + C$$



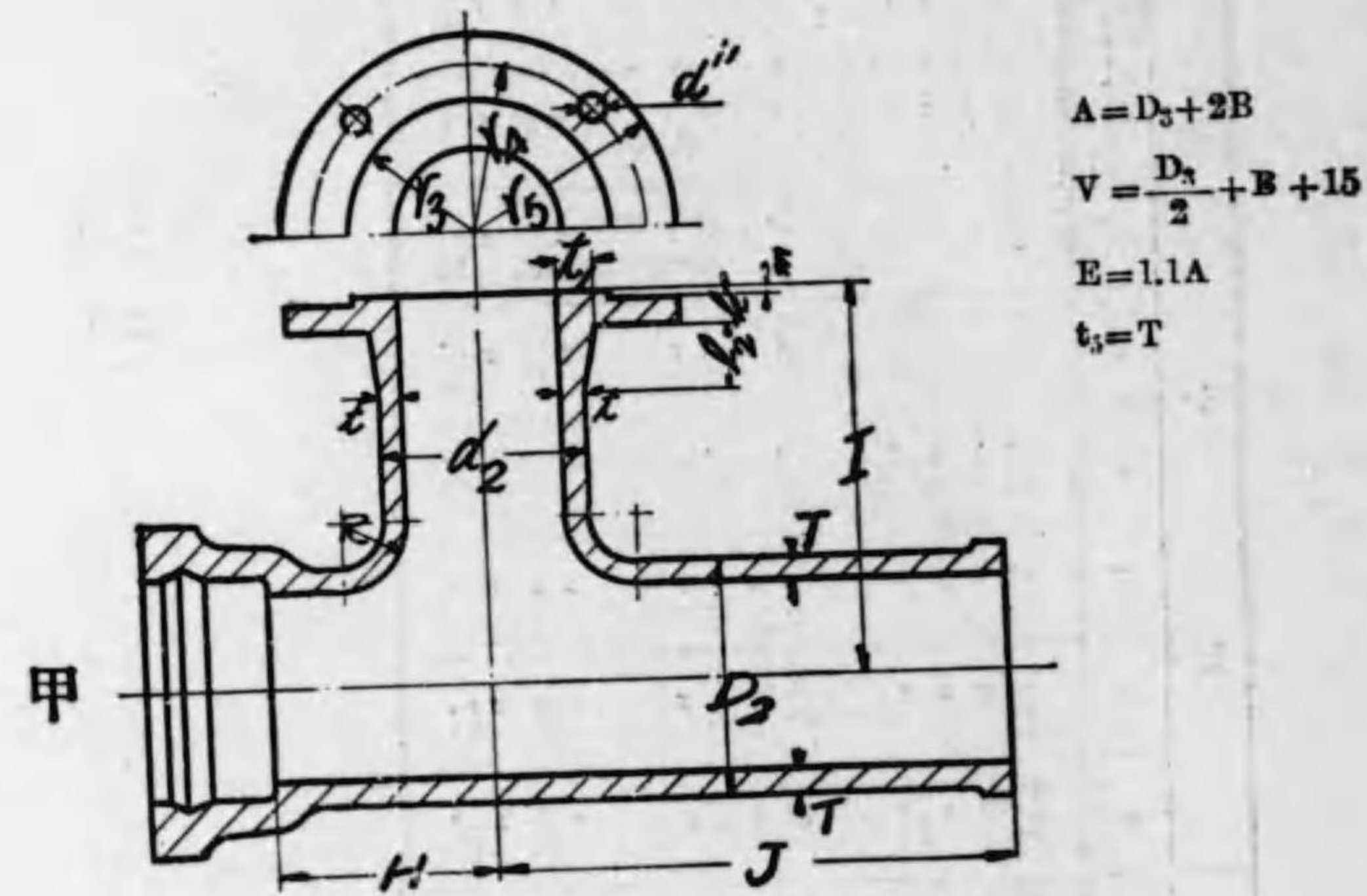
「ボルト」孔ノ配置ハ管ノ總テノ軸
線ヲ水平ニ爲シタル場合ニ共ノ鏝
面ノ垂直中心線ニ對シ振分トス

鏝ノ寸法ハ直管ニ同シ

制水瓣副管丁

公称内径 D	管厚 t _s	實外徑		R ₁	管			長				鈔				法		重量
		D ₂	D ₃		F	O	A	l ₄	b ₁	k	m	r ₃	r ₄	r ₃	r ₄	ボルト孔 d'	數	
400	11.8	434.6	121.4	400	425	45	445	100	16.8	22	3	119.0	97.5	76.0	18	4	32.5	
450	"	486.8	"	"	"	65	465	"	"	"	"	"	"	"	"	"	33.1	
500	"	539.0	"	"	"	85	485	"	"	"	"	"	"	"	"	"	33.7	
600	12.4	643.4	147.6	"	"	110	510	"	17.4	"	"	131.5	110.0	88.5	"	6	42.6	
700	13.0	747.8	173.6	"	426	185	535	"	18.0	23	"	145.0	123.5	102.0	"	"	55.9	
800	"	852.2	"	"	"	215	615	"	"	"	"	"	"	"	"	"	57.3	
900	14.2	956.6	225.8	"	427	290	690	"	19.2	24	"	171.0	149.5	128.0	"	8	85.1	
1000	"	1061.0	"	"	"	315	715	"	"	"	"	"	"	"	"	"	86.8	
1100	"	1165.4	"	"	"	355	755	"	"	"	"	"	"	"	"	"	88.5	
1200	15.4	1269.8	278.0	"	429	360	760	"	20.4	26	"	205.0	180.0	154.0	21	"	123	
1350	"	1423.4	"	"	"	415	815	"	"	"	"	232.0	207.0	181.0	"	"	128	
1500	16.6	1533.0	330.2	"	431	485	855	120	22.6	27	4	232.0	207.0	181.0	"	10	173	

第十六號 消火栓管
第一表 消火栓用管甲及乙



$$A = D_2 + 2B$$

$$V = \frac{D_2}{2} + B + 15$$

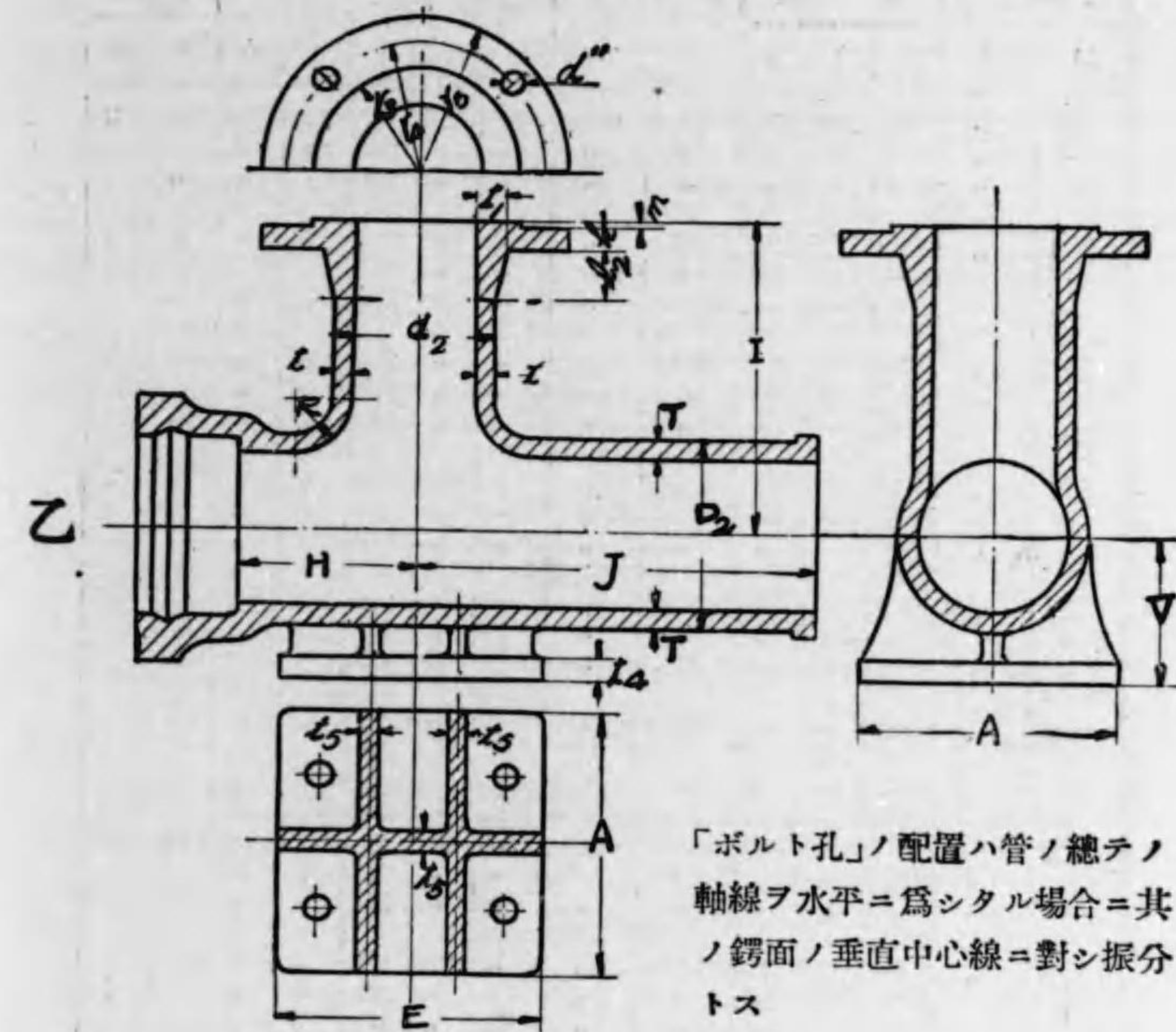
$$E = 1.1A$$

$$t_3 = T$$

承口、挿口、銑寸法ハ直管ニ同シ

消火栓用管甲及乙

公稱内徑 D	管厚 a	管厚			實外徑		R	管長					枝	
		T	t	t ₁	D ₂	d ₂		H	I	J	L ₂	k	m	
75	75	11.2	11.2	16.2	95.4	95.4	50	200	250	730	100	21	3	
"	"	"	"	"	"	"	"	"	300	"	"	"	"	
"	"	"	"	"	"	"	"	"	500	"	"	"	"	
100	"	11.8	11.8	16.8	121.4	"	"	"	250	"	"	"	"	
"	"	"	"	"	"	"	"	"	300	"	"	"	"	
"	"	"	"	"	"	"	"	"	500	"	"	"	"	
125	"	12.4	12.4	17.4	147.6	"	"	210	280	"	"	"	"	
"	"	"	"	"	"	"	"	"	330	"	"	"	"	
"	"	"	"	"	"	"	"	"	530	"	"	"	"	



「ボルト孔」ノ配置ハ管ノ總テノ軸線ヲ水平ニ爲シタル場合ニ其ノ銑面ノ垂直中心線ニ對シ振分トス

管					重量	臺寸法					台重量
r ₅	r ₄	r ₃	ボルト孔 d" 數			t ₄	t ₅	A	E	V	
105.5	84.0	62.5	18	4	36.5	16.0	11.2	176	195	105	5.35
"	"	"	"	"	37.6	"	"	"	"	"	"
"	"	"	"	"	39.8	"	"	"	"	"	"
"	"	"	"	"	46.2	"	11.8	200	220	115	6.68
"	"	"	"	"	47.3	"	"	"	"	"	"
"	"	"	"	"	51.8	"	"	"	"	"	"
"	"	"	"	"	56.4	18.0	12.4	230	255	130	9.94
"	"	"	"	"	57.2	"	"	"	"	"	"
"	"	"	"	"	62.3	"	"	"	"	"	"

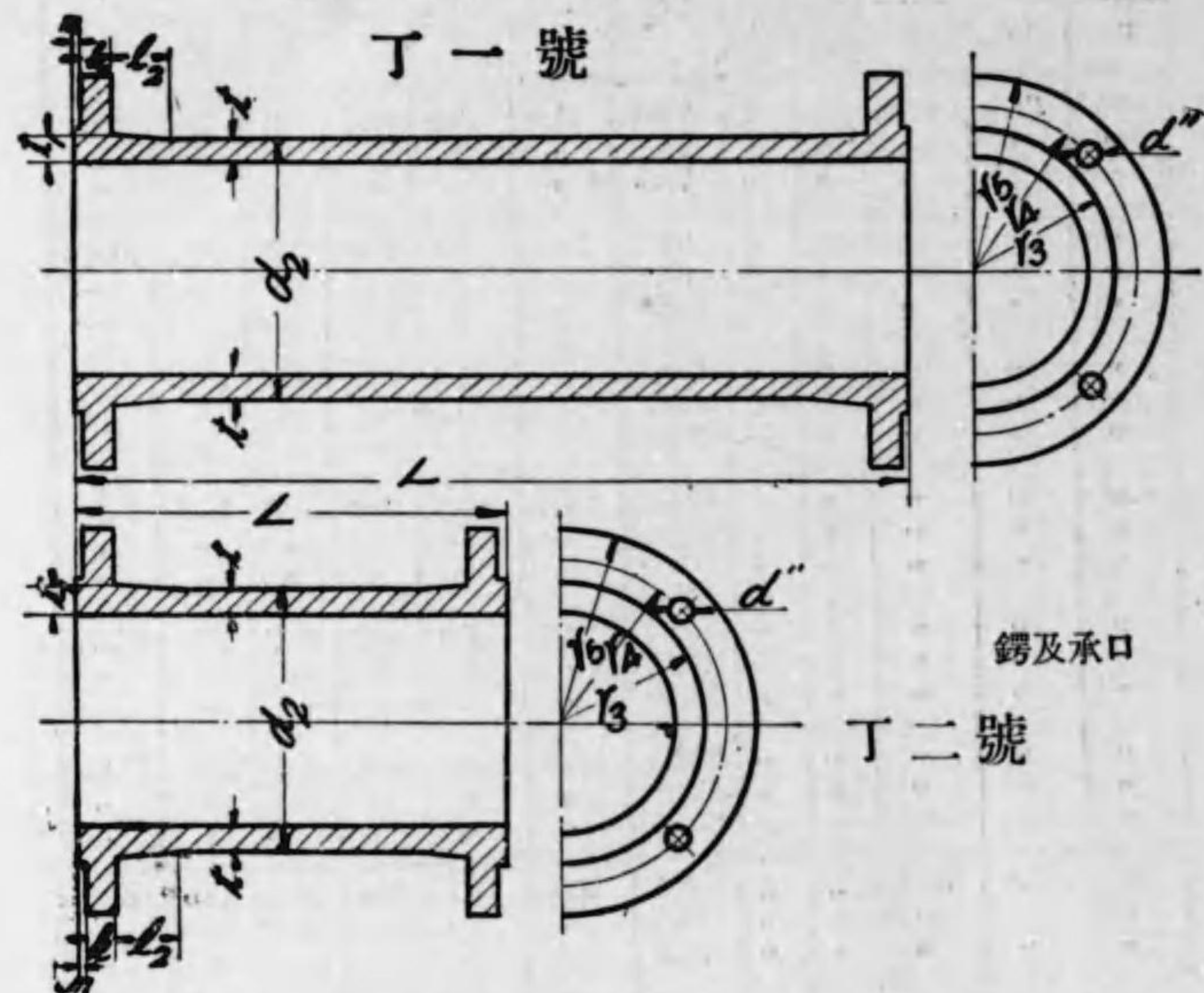
消火栓用管甲及乙

公稱內徑 D	管厚			實外徑		R	管長				枝		
	d	T	t	t ₁	D ₂		d ₂	H	I	J	L ₂	k	m
150	75	13.0	13.0	18.0	173.6	95.4	50	210	280	740	100	21	3
"	"	"	"	"	"	"	"	"	330	"	"	"	"
"	"	"	"	"	"	"	"	"	530	"	"	"	"
200	"	14.2	14.2	19.2	225.8	"	"	220	300	750	"	"	"
"	"	"	"	"	"	"	"	"	350	"	"	"	"
"	"	"	"	"	"	"	"	"	550	"	"	"	"
250	"	15.4	15.0	20.0	278.0	"	"	"	330	"	"	"	"
"	"	"	"	"	"	"	"	"	380	"	"	"	"
"	"	"	"	"	"	"	"	"	580	"	"	"	"
300	"	16.6	"	21.0	330.2	"	"	240	350	"	"	"	"
"	"	"	"	"	"	"	"	"	400	"	"	"	"
"	"	"	"	"	"	"	"	"	600	"	"	"	"
350	"	17.8	"	"	382.4	"	60	"	380	"	"	"	"
"	"	"	"	"	"	"	"	"	430	"	"	"	"
"	"	"	"	"	"	"	"	"	630	"	"	"	"
400	"	19.0	"	"	434.6	"	"	250	400	"	"	"	"
"	"	"	"	"	"	"	"	"	450	"	"	"	"
"	"	"	"	"	"	"	"	"	650	"	"	"	"
100	100	11.8	11.8	16.8	121.4	121.4	50	210	250	"	"	22	"
"	"	"	"	"	"	"	"	"	300	"	"	"	"
"	"	"	"	"	"	"	"	"	500	"	"	"	"
125	"	12.4	12.4	17.4	147.6	"	"	220	250	"	"	"	"
"	"	"	"	"	"	"	"	"	300	"	"	"	"
"	"	"	"	"	"	"	"	"	500	"	"	"	"
150	"	13.0	13.0	18.0	173.6	"	"	"	280	"	"	"	"
"	"	"	"	"	"	"	"	"	330	"	"	"	"
"	"	"	"	"	"	"	"	"	530	"	"	"	"
200	"	14.2	14.2	19.2	225.8	"	"	230	300	"	"	"	"
"	"	"	"	"	"	"	"	"	350	"	"	"	"
"	"	"	"	"	"	"	"	"	550	"	"	"	"
250	"	15.4	15.4	20.4	278.0	"	"	240	330	70	"	"	"
"	"	"	"	"	"	"	"	"	380	"	"	"	"
"	"	"	"	"	"	"	"	"	580	"	"	"	"
300	"	16.6	16.0	22.0	330.2	"	"	"	350	"	"	"	"
"	"	"	"	"	"	"	"	"	400	"	"	"	"
"	"	"	"	"	"	"	"	"	600	"	"	"	"
350	"	17.8	"	"	382.4	"	60	260	380	"	"	"	"
"	"	"	"	"	"	"	"	"	430	"	"	"	"
"	"	"	"	"	"	"	"	"	630	"	"	"	"
400	"	19.0	"	"	434.6	"	"	270	400	"	"	"	"
"	"	"	"	"	"	"	"	"	450	"	"	"	"
"	"	"	"	"	"	"	"	"	650	"	"	"	"

管		鑄		重量	臺 寸 法					台
r ₃	r ₄	r ₅	ボルト孔 d# 數		t ₄	t ₅	A	E	V	重量
105.5	84.0	62.5	18 4	70.3	18.0	13.0	262	288	146	13.30
"	"	"	"	71.7	"	"	"	"	"	"
"	"	"	"	77.3	"	"	"	"	"	"
"	"	"	"	96.2	20.0	14.2	318	350	174	21.90
"	"	"	"	97.7	"	"	"	"	"	"
"	"	"	"	104.0	"	"	"	"	"	"
"	"	"	"	128.0	"	15.4	376	414	205	32.90
"	"	"	"	129.0	"	"	"	"	"	"
"	"	"	"	136.0	"	"	"	"	"	"
"	"	"	"	161.0	22.0	16.6	432	475	230	41.90
"	"	"	"	163.0	"	"	"	"	"	"
"	"	"	"	169.0	"	"	"	"	"	"
"	"	"	"	198.0	24.0	17.8	488	537	260	67.90
"	"	"	"	199.0	"	"	"	"	"	"
"	"	"	"	206.0	"	"	"	"	"	"
"	"	"	"	242.0	26.0	19.0	547	610	290	82.70
"	"	"	"	244.0	"	"	"	"	"	"
"	"	"	"	251.0	"	"	"	"	"	"
119.0	97.5	76.0	"	49.5	16.0	11.8	200	220	115	6.68
"	"	"	"	51.0	"	"	"	"	"	"
"	"	"	"	56.9	"	"	"	"	"	"
"	"	"	"	59.9	18.0	12.4	230	255	130	9.94
"	"	"	"	61.4	"	"	"	"	"	"
"	"	"	"	67.6	"	"	"	"	"	"
"	"	"	"	72.9	"	13.0	262	288	146	13.30
"	"	"	"	74.5	"	"	"	"	"	"
"	"	"	"	80.9	"	"	"	"	"	"
"	"	"	"	99.3	20.0	14.2	318	350	174	21.80
"	"	"	"	101.0	"	"	"	"	"	"
"	"	"	"	108.0	"	"	"	"	"	"
"	"	"	"	132.0	"	15.4	376	414	205	32.90
"	"	"	"	134.0	"	"	"	"	"	"
"	"	"	"	141.0	"	"	"	"	"	"
"	"	"	"	164.0	22.0	16.6	432	475	230	41.90
"	"	"	"	166.0	"	"	"	"	"	"
"	"	"	"	174.0	"	"	"	"	"	"
"	"	"	"	204.0	24.0	17.8	488	537	260	67.90
"	"	"	"	206.0	"	"	"	"	"	"
"	"	"	"	214.0	"	"	"	"	"	"
"	"	"	"	250.0	26.0	19.0	547	610	290	82.70
"	"	"	"	252.0	"	"	"	"	"	"
"	"	"	"	259.0	"	"	"	"	"	"

第十六號

第三表 消火栓用丁管



消火栓用丁管

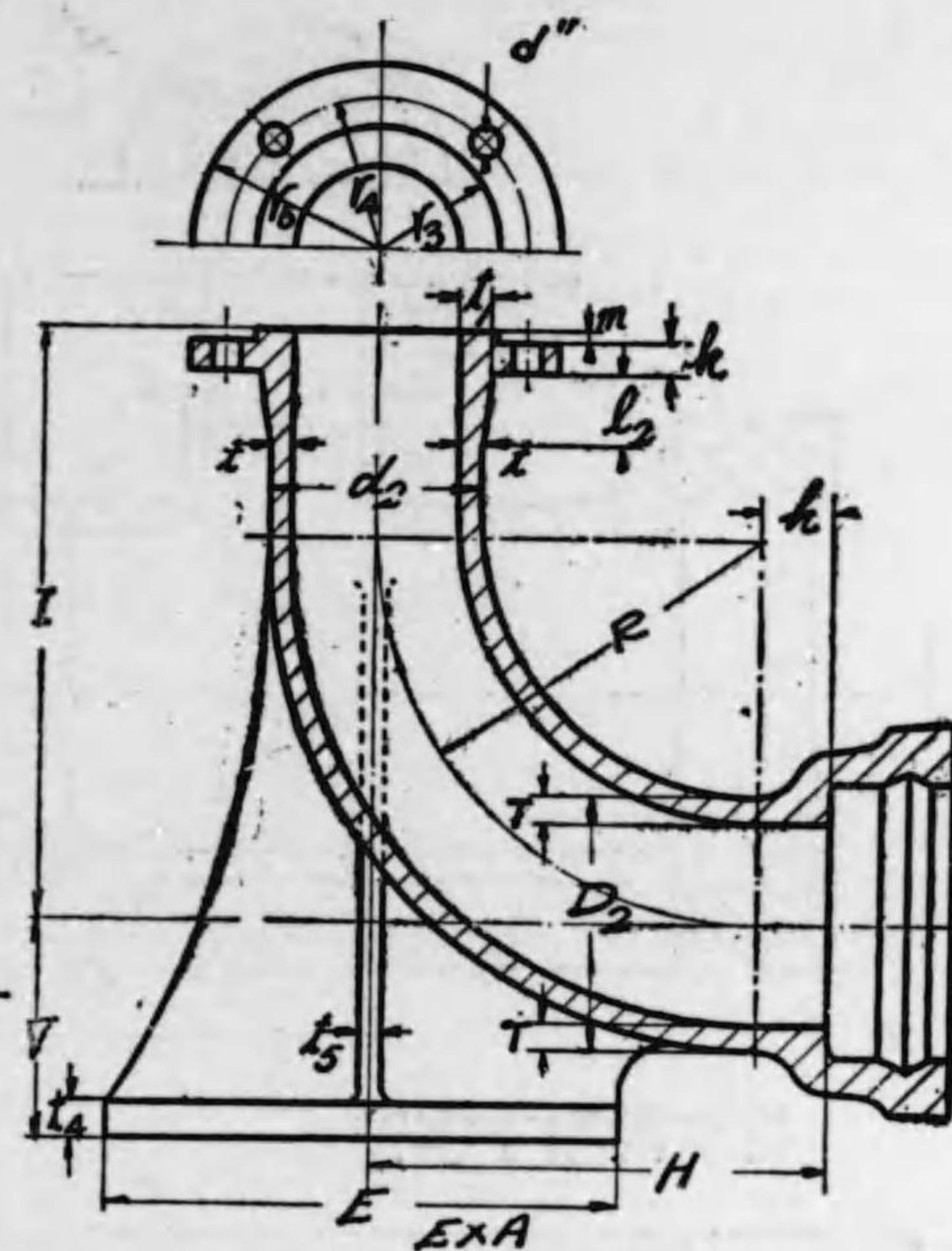
公稱 內徑	管 厚	實外徑	管長	鑄 寸 法															
				r_5	r_4	r_3	d_2	L	l_2	k	m	r_5	r_4	r_3	ボルト孔 d' 數				
75	11.2	16.2	95.4	150	100	21	3	105.5	84.0	62.5	19	4							
"	"	"	"	300	"	"	"	"	"	"	"	"							
100	11.8	16.8	121.4	150	"	22	"	119.0	97.5	76.0	"	"							
"	"	"	"	300	"	"	"	"	"	"	"	"							

消火栓用丙管

公稱 內徑	管 厚	實外徑	鑄 寸 法																
			r_5	r_4	r_3	d_2	D_2	d_2	k	m	r_5	r_4	r_3	ボルト孔 d' 數					
75	11.2	16.2	95.4	95.4	21	3	105.5	84.0	62.5	18	4								
100	11.8	16.8	121.4	"	"	"	"	"	"	"	"								
"	100	11.8	16.8	"	121.4	22	"	119.0	97.5	76.0	"	"							

消火栓用管

第二表 消火栓用丙管



寸法ハ直管=同シ

$$h = \frac{D}{10} + F$$

$$I = l_2 + m + k + R + \frac{d}{10}$$

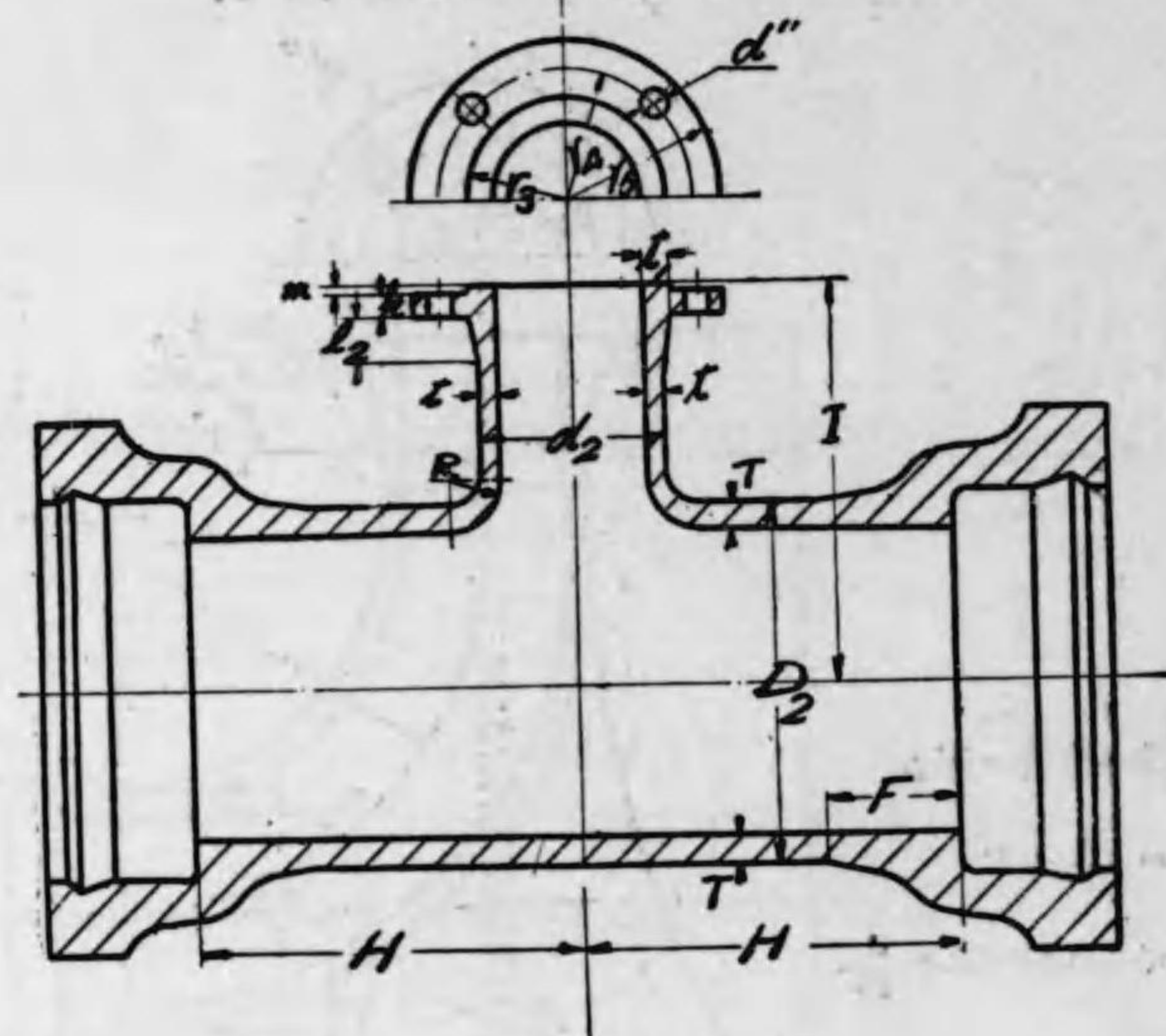
$$t_5 = T$$

重量	號別
12.8	二號
16.0	一號
16.4	二號
20.8	一號

「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平ニ爲シタル場合ニ其ノ鑄面ノ垂直中心線ニ對シ振分トス

各 部 寸 法						重量	臺 寸 法			臺重量
R	l_2	H	I	V	h		t_4	E	A	
150	100	260	300	110	110	23.1	20	240	300	15.4
200	"	310	350	"	"	26.2	"	"	"	16.4
"	"	"	"	"	"	32.9	"	"	"	16.3

第十七號 排氣瓣用丁字管



排氣瓣用丁字管

公稱内徑 D	管 d	管 厚			實 外 徑		R	管	
		T	t	t ₁	D ₂	d ₂		H	I
400	75	19.0	15.0	20.0	434.6	95.4	60	255	392
450	"	20.2	"	"	486.3	"	"	260	417
500	"	21.5	"	"	539.0	"	"	270	442
600	"	23.9	"	"	645.4	"	"	285	492
700	"	26.3	"	"	747.8	"	70	305	552
800	"	28.7	"	"	852.2	"	"	320	602
900	100	31.1	16.0	21.0	956.6	121.4	80	360	665
1000	"	33.6	"	"	1061.0	"	"	375	715
1100	"	36.0	"	"	1165.4	"	90	395	775
1200	"	38.4	"	"	1269.8	"	"	410	825
1350	"	42.0	"	"	1426.4	"	100	440	860
1500	150	45.7	17.0	22.0	1583.0	173.6	"	490	990

$$H = F + \frac{D}{10} + R + \frac{d}{2} + 30$$

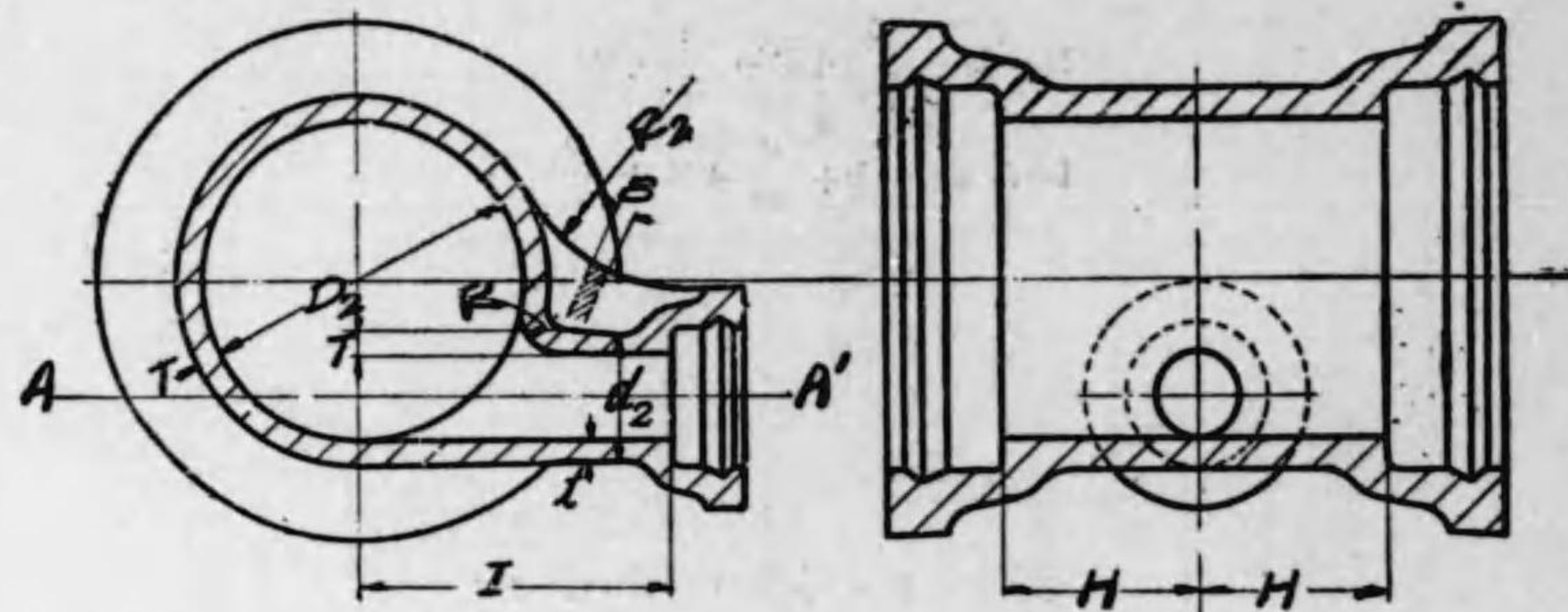
$$I = l_2 + m + k + \frac{d}{10} + R + \frac{d}{2}$$

鑄及承口ノ寸法ハ直管ニ同シ

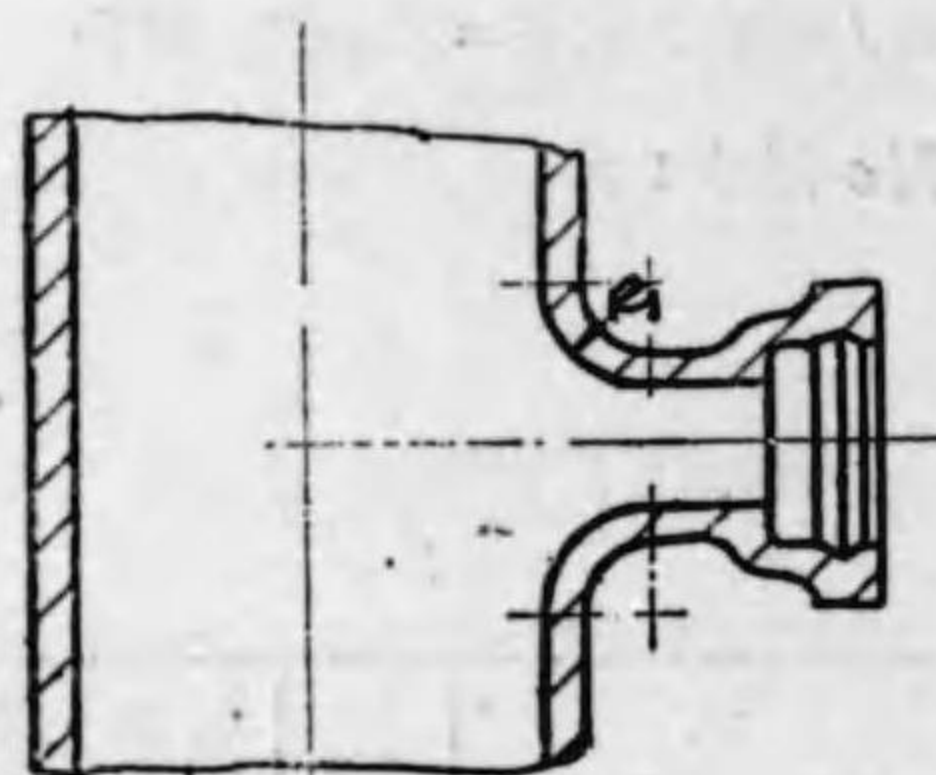
「ボルト」孔ノ配置ハ管ノ總テノ軸線ヲ水平ニ爲シタル場合
ニ其ノ鑄面ノ垂直中心線ニ對シ振分トス

長 l ₂	鑄 寸 法						重量	公稱内徑		
	k	m	r ₅	r ₄	r ₃	ボルト孔 數		D	d	
100	21	∵	105.5	84.0	62.5	18	4	205	400	75
"	"	"	"	"	"	"	"	246	450	"
"	"	"	"	"	"	"	"	290	500	"
"	"	"	"	"	"	"	"	391	600	"
"	"	"	"	"	"	"	"	521	700	"
"	"	"	"	"	"	"	"	670	800	"
"	22	"	119.0	97.5	76.0	"	"	902	900	100
"	"	"	"	"	"	"	"	1090	1000	"
"	"	"	"	"	"	"	"	1320	1100	"
"	"	"	"	"	"	"	"	1580	1200	"
"	"	"	"	"	"	"	"	2030	1350	"
"	23	"	145.0	123.5	102.0	"	6	2630	1500	150

第十八號 泥 吐 管



断面 A-A'



$$H = F + \frac{D}{10} + R + \frac{d}{2} + 30$$

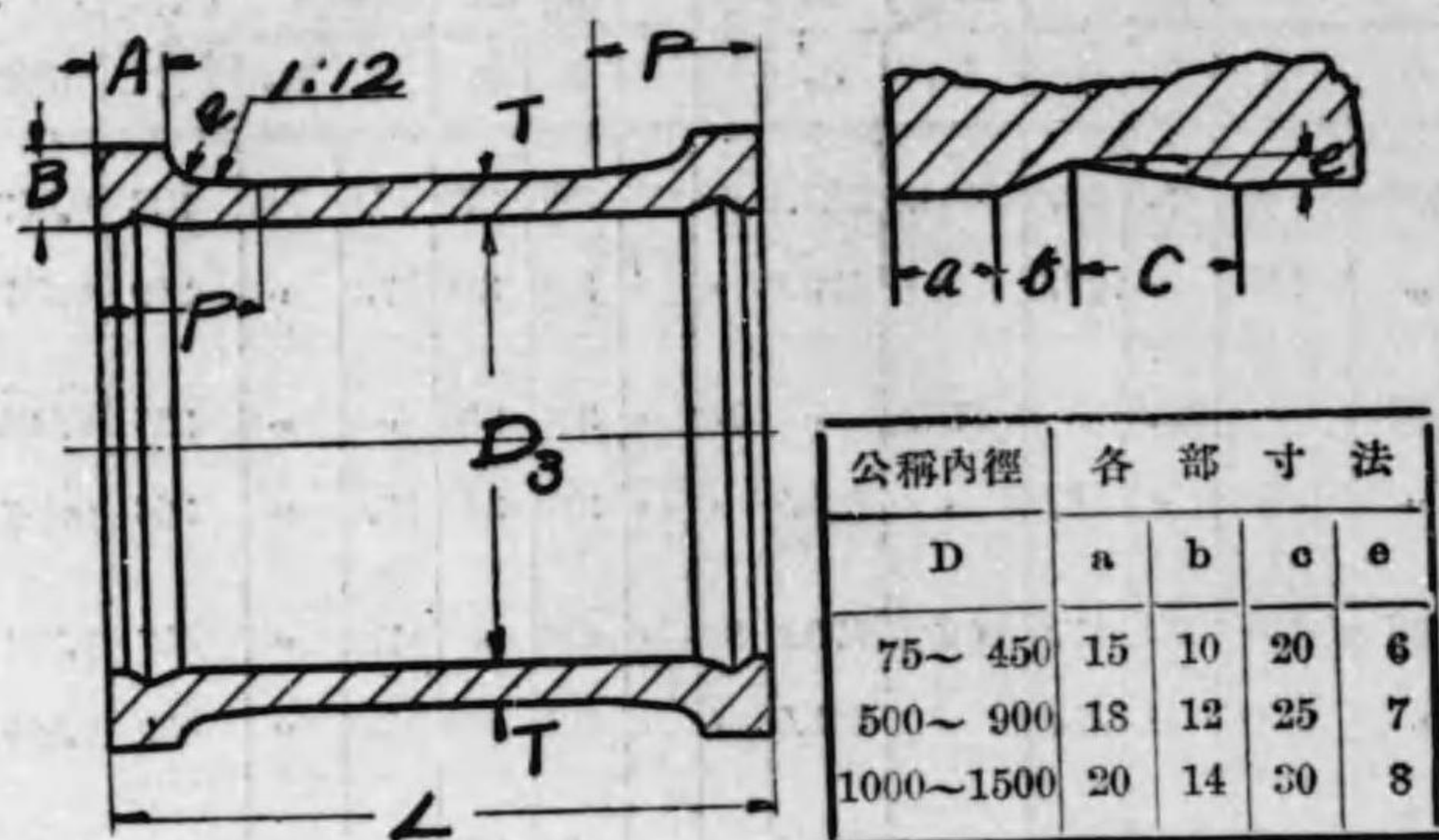
$$I = \frac{D}{2} + T + f + \frac{d}{10}$$

承口ノ寸法ハ直管ニ同シ

泥 吐 管

公称内径 D	管厚 d	管厚		實外徑		R ₁	R	管長		リップ		重量 リップ 重量ヲ 含マス	リップ 重量
		T	t	D ₂	d ₂			I	H	B	R ₂		
400	100	19.0	16.0	434.6	121.4	60	10	300	270	16.0	100	226	0.507
"	150	"	17.0	"	173.6	"	"	310	300	17.0	"	249	0.457
500	"	21.5	"	539.0	"	70	"	365	280	"	"	325	0.536
"	200	"	18.0	"	225.8	"	"	370	340	18.0	"	366	0.447
600	150	23.9	17.0	643.4	173.6	80	"	415	"	17.0	"	457	0.721
"	200	"	18.0	"	225.8	"	"	425	370	18.0	"	489	0.505
700	"	26.3	"	747.8	"	"	"	475	380	"	106	579	0.682
"	250	"	19.0	"	278.0	90	"	485	410	19.0	"	670	0.571
800	200	28.7	17.0	852.2	225.8	80	15	525	390	18.0	150	789	1.48
"	250	"	19.0	"	278.0	90	"	535	430	19.0	"	828	1.36
900	"	31.1	"	956.6	"	"	"	590	440	"	"	1050	1.62
"	300	"	20.0	"	330.2	"	"	595	470	20.0	"	1100	1.39
1000	"	33.6	"	1061.0	"	100	"	645	500	"	"	1350	1.49
"	400	"	23.0	"	434.6	110	"	660	520	23.0	"	1420	1.30
1100	300	36.0	20.0	1165.4	330.2	100	20	700	506	20.0	200	1580	2.32
"	400	"	23.0	"	434.6	110	"	715	570	23.0	"	1750	2.42
1200	300	38.4	20.0	1269.8	330.2	100	"	750	520	20.0	"	1890	2.76
"	400	"	23.0	"	434.6	110	"	765	580	23.0	"	2050	"
1350	300	42.0	20.0	1426.4	330.2	100	"	830	540	20.0	"	2370	3.63
"	400	"	23.0	"	434.6	110	"	845	590	23.0	"	2550	3.25
1500	300	45.7	20.0	1583.0	330.2	100	"	910	560	20.0	"	2930	4.38
"	400	"	23.0	"	434.6	110	"	925	610	23.0	"	3130	4.23

第十九號 接 ぎ 輪

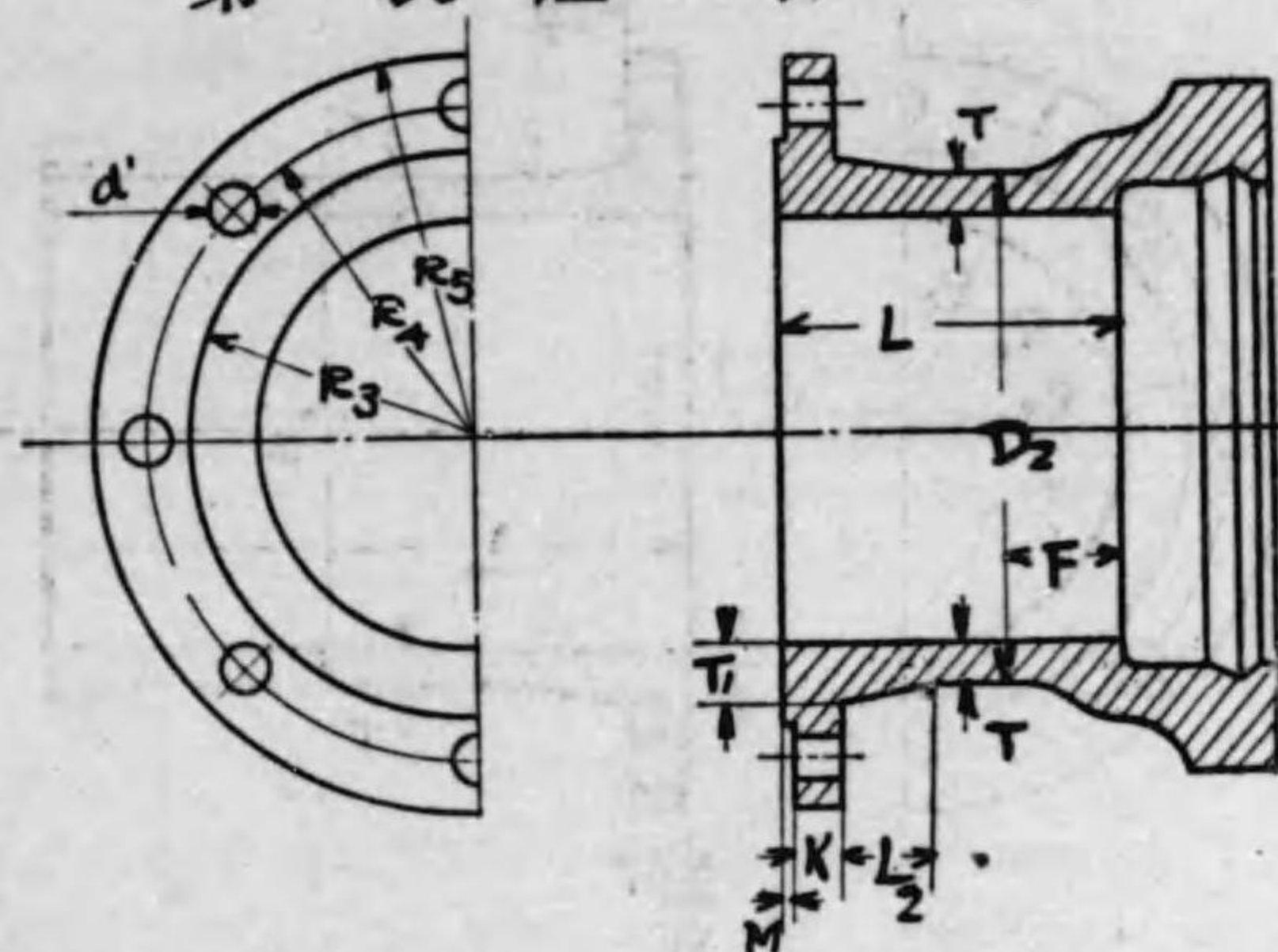


公称内径	各 部 寸 法			
D	a	b	c	e
75~450	15	10	20	6
500~900	18	12	25	7
1000~1500	20	14	30	8

接 ぎ 輪

管ノ公称内径 D	接ぎ輪内径 D ₃	管 厚 T	各 部 寸 法					重 量
			A	B	R	P	L	
75	115.4	15.0	35	30	15	90	300	17.5
100	141.4	16.0	"	31	16	95	"	22.3
125	167.6	"	"	32	"	"	"	26.3
150	193.6	17.0	"	34	17	100	"	33.7
200	245.8	18.0	40	36	18	"	"	43.2
250	299.0	19.0	"	38	19	105	"	55.2
300	352.2	20.0	"	40	20	"	350	76.0
350	404.4	21.0	"	42	21	110	"	91.7
400	456.6	23.0	45	45	23	"	"	114
450	508.8	24.0	"	47	24	115	"	133
500	563.0	25.0	"	49	25	"	"	152
600	667.0	27.0	50	53	27	120	400	218
700	771.8	29.0	"	58	29	125	"	273
800	876.2	31.0	55	62	31	130	"	339
900	980.6	34.0	"	67	34	135	"	415
1000	1087.0	36.0	60	71	36	140	450	538
1100	1191.4	38.0	"	74	38	145	"	620
1200	1295.8	40.0	65	77	40	150	"	717
1350	1452.4	43.0	70	80	43	160	500	938
1500	1609.0	47.0	75	83	47	165	"	1120

第二十號 短 管
第一表 短 管 甲

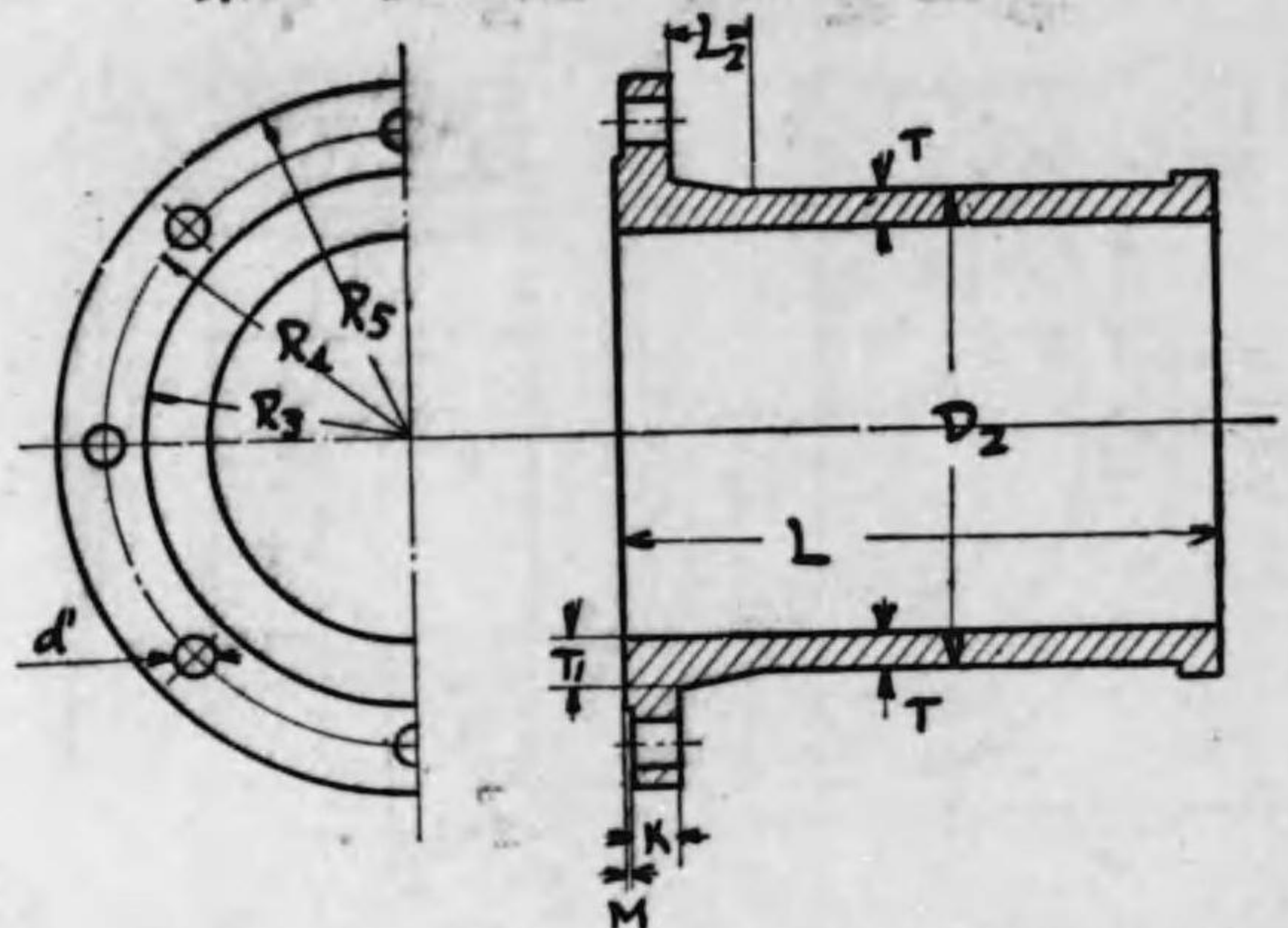


鋳及承口ノ寸法ハ直管ニ同シ

短 管 甲

公称内径 D	管 厚		管 長	鋳 寸 法						重量				
	T	T ₁		D ₂	L	L ₂	F	K	M		R ₃	R ₄	R ₅	ボルト孔数 d'
75	10.2	15.2	95.4	280	100	71.4	21	3	105.5	84.0	62.5	18	4	18.0
100	10.7	15.7	121.4	"	"	73.1	22	"	119.0	97.5	76.0	"	"	23.7
125	11.3	16.3	147.6	"	"	"	"	"	131.5	110.0	88.5	"	6	28.6
150	11.8	16.8	173.6	"	"	74.9	23	"	145.0	123.5	102.0	"	"	35.6
200	12.9	17.9	225.8	"	"	76.7	24	"	171.0	149.5	128.0	"	8	48.4
250	14.0	19.0	278.0	"	"	80.1	26	"	205.0	180.0	154.0	21	"	66.4
300	15.1	21.1	330.2	"	120	81.8	27	4	232.0	207.0	181.0	"	10	82.9
350	16.2	22.2	382.4	"	"	83.6	28	"	265.0	236.0	207.0	24	"	104
400	17.3	23.3	434.6	370	"	87.0	30	"	291.0	262.0	233.0	"	12	142
450	18.4	24.4	486.8	"	"	88.8	31	"	326.0	292.5	259.0	27	"	172
500	19.5	25.5	539.0	"	"	92.2	32	"	353.0	319.5	286.0	"	"	199
600	21.7	27.7	643.4	"	"	95.7	35	"	405.0	371.5	338.0	"	16	263
700	23.9	29.9	747.8	"	"	99.2	38	"	464.0	427.0	390.0	30	"	340
800	26.1	33.1	852.2	"	140	102.6	41	5	517.0	480.0	443.0	"	20	427
900	28.3	35.3	956.6	510	"	107.8	44	"	578.0	536.5	495.0	35	"	621
1000	30.5	37.5	1061.0	"	"	113.0	46	"	631.0	589.5	548.0	"	24	741
1100	32.7	39.7	1165.4	"	"	116.6	49	"	683.0	641.5	600.0	"	"	871
1200	34.9	41.9	1269.8	"	"	120.0	52	"	735.0	693.5	652.0	"	28	1020
1350	38.2	46.2	1426.4	"	160	125.2	56	6	821.0	776.0	731.0	38	"	1280
1500	41.5	49.5	1583.0	"	"	132.0	60	"	900.0	855.0	810.0	"	32	1540

第二十號 短管
第二表 短管 乙

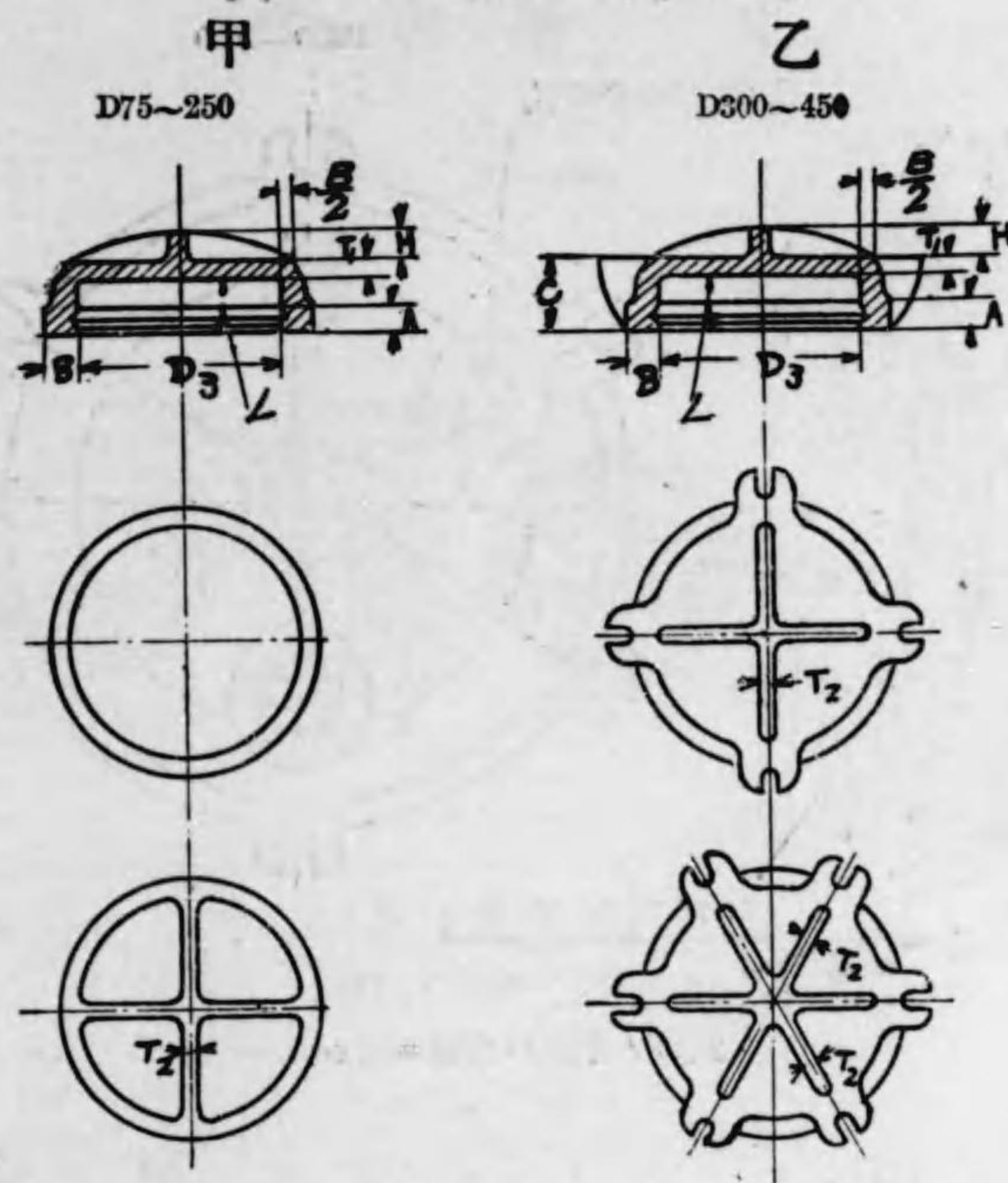


鋳及挿口ノ寸法ハ直管ニ同シ

短管 乙

公稱 内徑	管厚		實外徑	管長		鋳寸法										重量
	D	T		T ₁	D ₂	L	L ₂	K	M	R ₃	R ₄	R ₅	ボルト孔 d' 數			
75	10.2	15.2	95.4	800	100	21	3	105.5	84.0	62.5	18	4	20.7			
100	10.7	15.7	121.4	"	"	22	"	119.0	97.5	76.0	"	"	27.7			
125	11.3	16.3	147.6	"	"	"	"	131.5	110.0	88.5	"	6	35.0			
150	11.8	16.8	173.6	"	"	23	"	145.0	123.5	102.0	"	"	43.0			
200	12.9	17.9	225.8	"	"	24	"	171.0	149.5	128.0	"	8	60.5			
250	14.0	19.0	278.0	"	"	26	"	205.0	180.0	154.0	21	"	82.5			
300	15.1	21.1	330.2	"	120	27	4	232.0	207.0	181.0	"	10	106			
350	16.2	22.2	382.4	"	"	28	"	265.0	236.0	207.0	24	"	133			
400	17.3	23.3	434.6	900	"	30	"	291.0	262.0	233.0	"	12	177			
450	18.4	24.4	486.8	"	"	31	"	326.0	292.5	259.0	27	"	214			
500	19.5	25.5	539.0	"	"	32	"	353.0	319.5	286.0	"	"	250			
600	21.7	27.7	643.4	"	"	35	"	405.0	371.5	338.0	"	16	329			
700	23.9	29.9	747.8	"	"	38	"	464.0	427.0	390.0	30	"	424			
800	26.1	33.1	852.2	"	140	41	5	517.0	480.0	443.0	"	20	529			
900	28.3	35.3	956.6	1000	"	44	"	578.0	536.5	495.0	35	"	710			
1000	30.5	37.5	1061.0	"	"	46	"	631.0	589.5	548.0	"	24	844			
1100	32.7	39.7	1165.4	"	"	49	"	683.0	641.5	600.0	"	"	991			
1200	34.9	41.9	1269.8	"	"	52	"	735.0	693.5	652.0	"	28	1150			
1350	38.2	46.2	1426.4	"	160	56	6	821.0	776.0	731.0	38	"	1430			
1500	41.5	49.5	1583.0	"	"	60	"	900.0	855.0	810.0	"	32	1720			

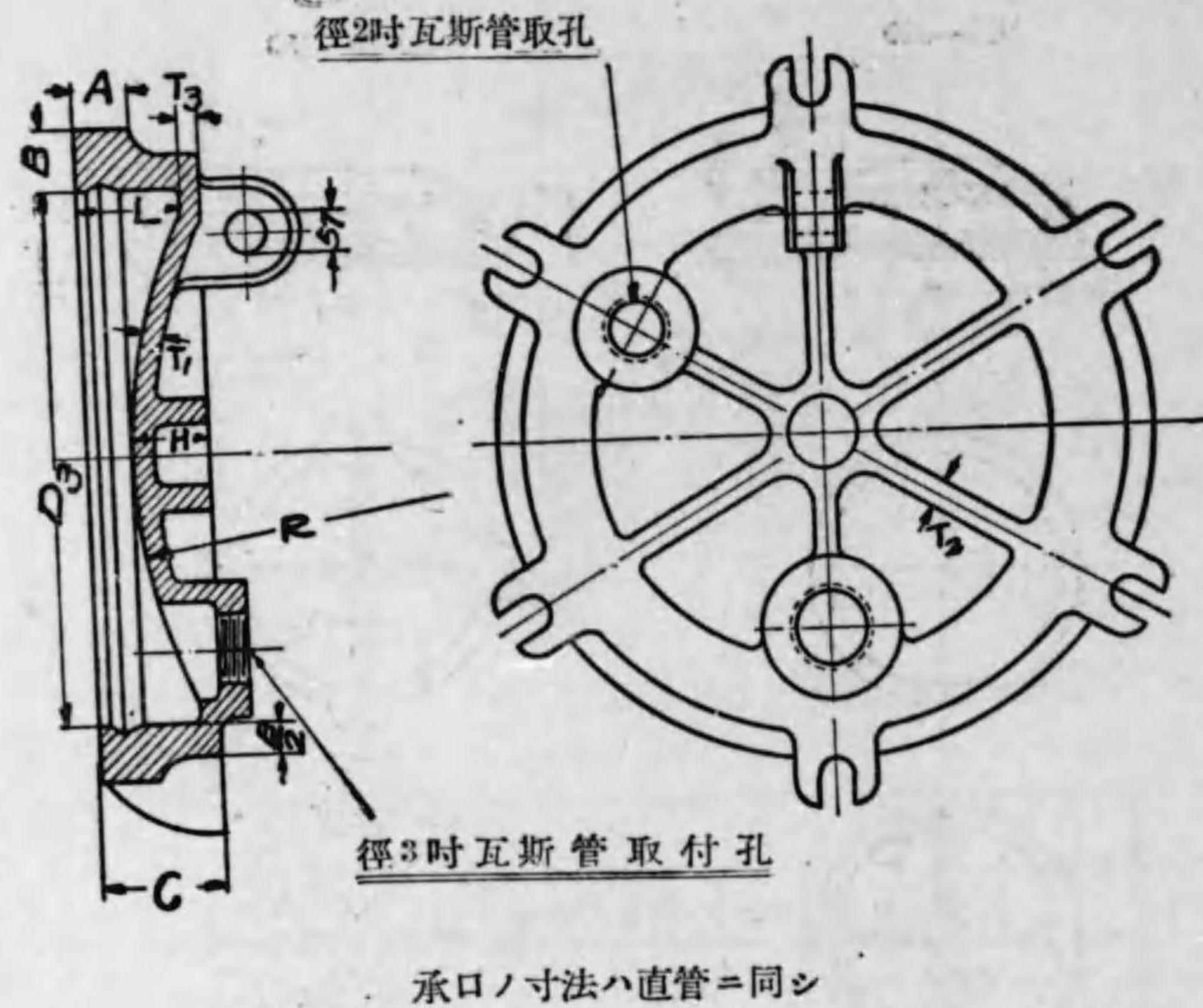
第二十一號 帽
第一表 帽甲及乙



帽甲及乙

管ノ公 稱内徑	各部寸法								リッ ブ數	重量
	D	D ₃	A	B	L	H	T ₁	T ₂		
75	115.4	35	30	90	15	8.47
100	141.4	"	31	95	"	11.4
125	167.6	"	32	"	17	14.0
150	193.6	"	34	100	"	18.1
200	245.8	40	36	"	20	26.1
250	300.0	"	38	105	38.1	"	19	4	38.6
300	352.2	"	42	"	39.4	22	"	127	4	50.2
350	404.4	"	45	110	48.3	"	"	136	"	69.8
400	456.6	45	47	"	50.8	25	"	139	6	94
450	508.8	"	49	115	"	"	25	144	"	118

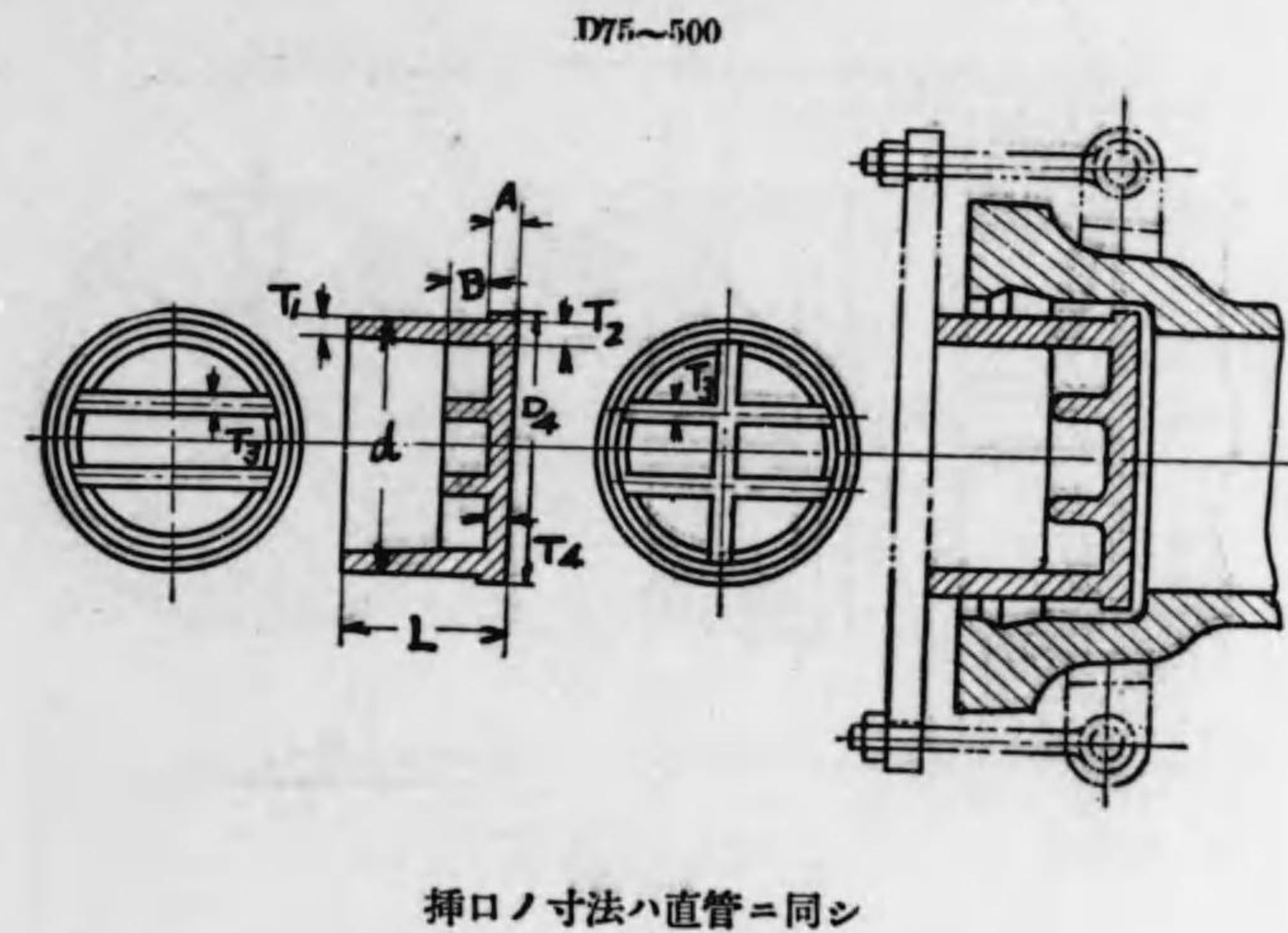
第二十一號 帽
第二表 帽 丙
D500~1500



帽 丙

管ノ公稱内徑 D	各 部 寸 法										リッ ブ 数	重 量
	D ₃	A	B	L	H	T ₁	T ₂	T ₃	C	R		
500	563.0	45	49	115	65	25	25	25	144	457	6	133
600	667.4	50	53	120	"	27	"	27	150	657	"	192
700	771.8	"	58	125	75	29	29	29	153	785	"	241
800	876.2	55	62	130	"	31	"	31	164	1025	"	311
900	980.6	"	67	135	85	33	32	33	171	1155	"	422
1000	1087.0	60	71	140	"	38	36	38	181	1352	8	524
1100	1191.4	"	74	145	95	43	"	43	191	1553	"	608
1200	1295.8	65	77	150	"	48	38	48	201	1856	"	787
1350	1452.4	70	80	160	105	51	"	51	214	2126	"	994
1500	1609.0	75	83	165	"	53	"	53	222	2339	"	1260

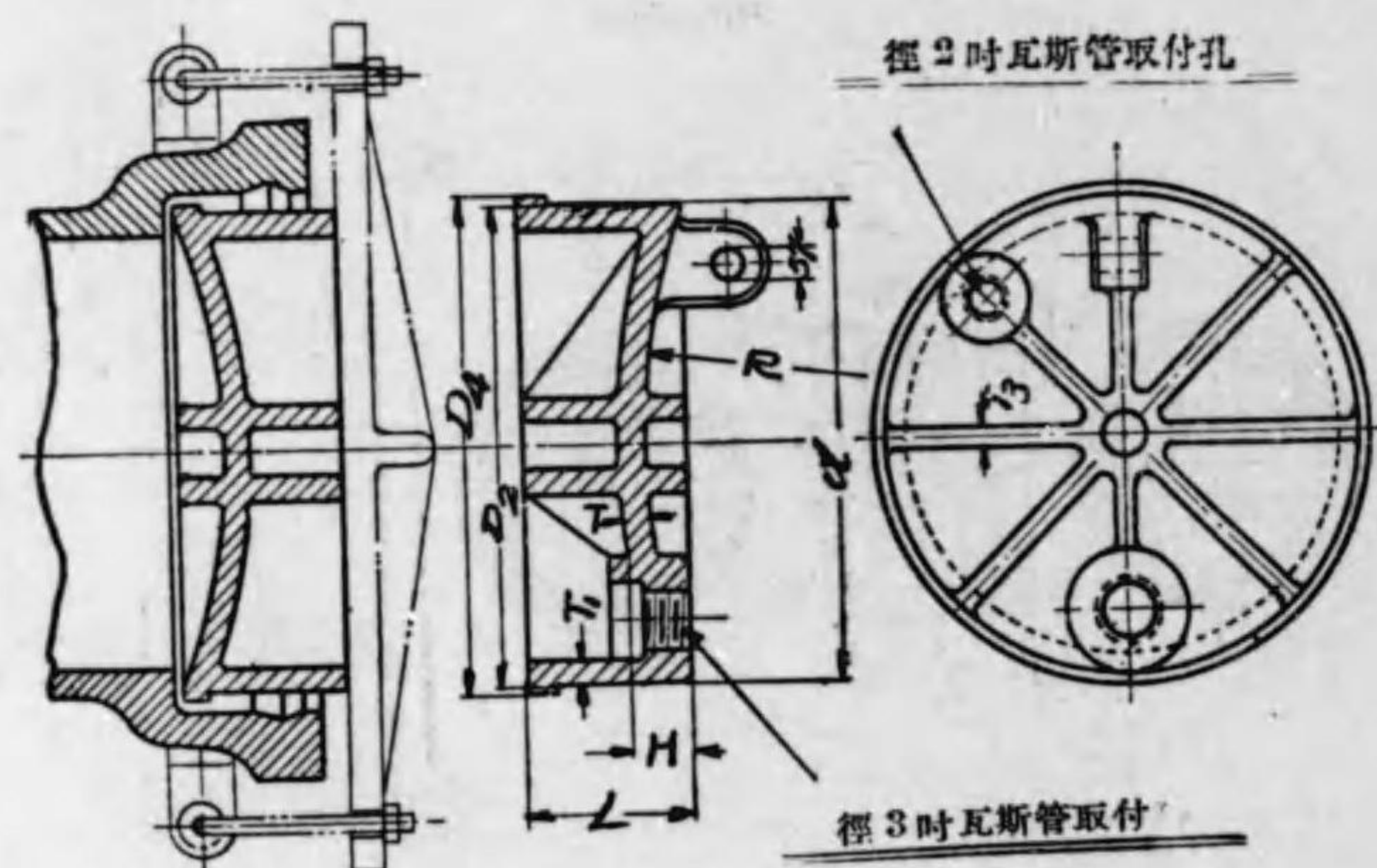
第二十二號 栓
第一表 栓 甲
D75~500



栓 甲

管ノ公稱内徑 D	各 部 寸 法									リッ ブ 数	重 量
	d	D ₄	A	L	T ₁	T ₂	T ₃	T ₄	B		
75	95.4	105.4	15	140	6	9	9	12	50	1	2.86
100	121.4	131.4	"	"	"	10	10	13	"	"	4.52
125	147.6	157.6	"	"	"	"	"	"	"	"	6.11
150	173.6	183.6	"	"	"	"	"	14	"	"	7.75
200	225.8	235.8	"	"	"	"	"	"	"	2	10.6
250	278.0	288.0	20	152	"	13	13	17	55	"	19.3
300	330.2	340.2	"	"	"	"	"	19	"	"	27.7
350	382.4	392.4	"	"	8	"	"	"	"	3	34.3
400	434.6	446.6	25	165	"	"	"	22	60	"	45.7
450	486.8	498.8	"	"	"	16	16	24	"	"	61.0
500	539.0	551.0	"	"	"	"	"	25	"	"	75.2

第二十二號 栓
第二表 栓 乙



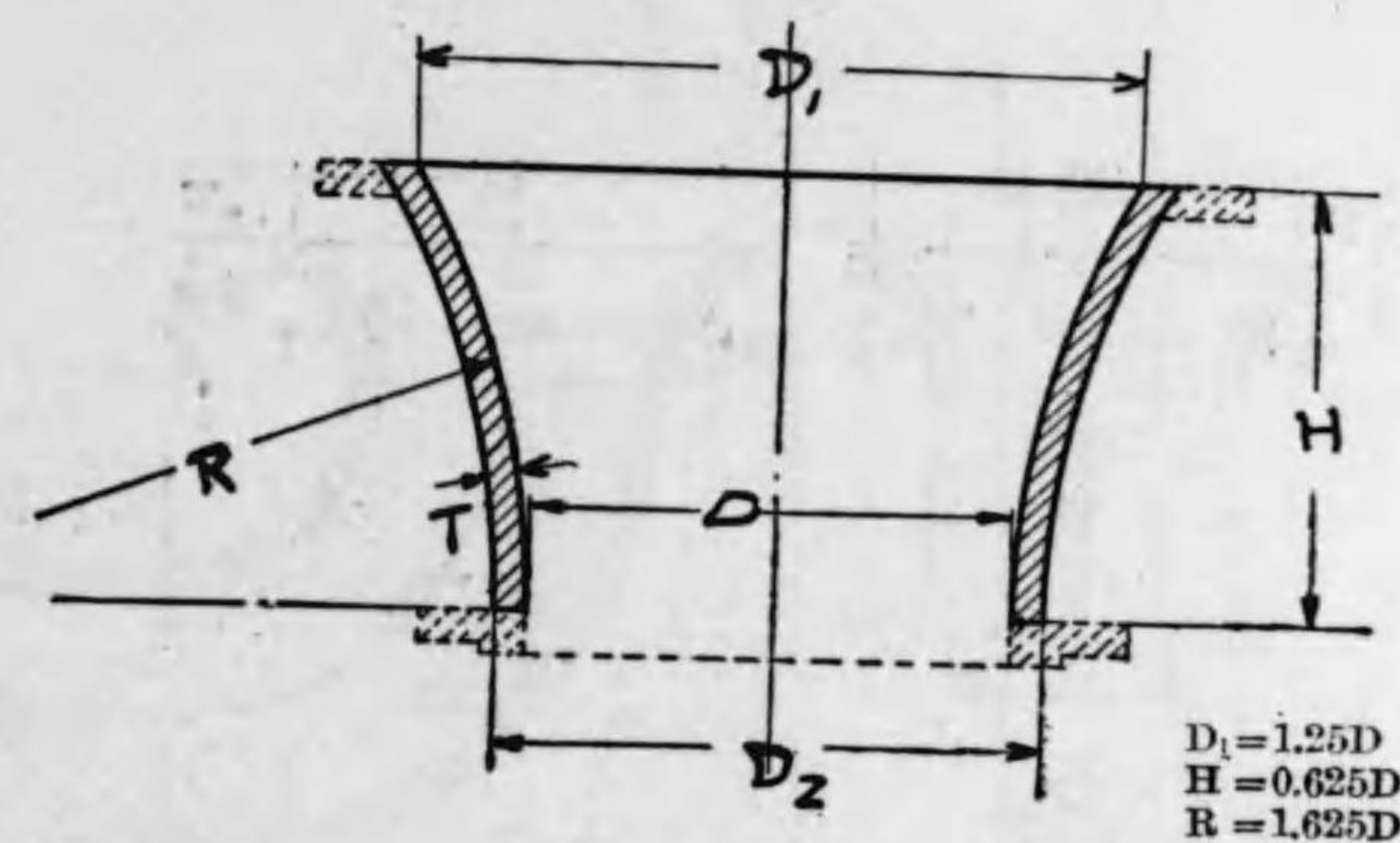
$T_3 = 0.9T$

挿口ノ寸法ハ直管=同シ

栓 乙

管ノ公稱内徑 D	各部寸法								リップ 数	重量
	D ₂	d	D ₄	L	T=T ₁	T ₃	H	R		
600	643.4	637.3	655.4	200	23	21	80	584	6	107
700	747.8	741.7	759.8	"	26	23	"	785	"	166
800	852.2	846.1	864.2	"	28	25	"	1015	"	205
900	956.6	950.5	968.6	"	29	26	"	1277	"	253
1000	1061.0	1051.9	1073.0	230	31	28	"	1571	8	326
1100	1165.4	1159.3	1177.4	"	33	30	"	1896	"	381
1200	1269.8	1263.7	1281.8	"	36	32	"	2252	"	481
1350	1426.4	1420.3	1438.4	"	39	35	"	2845	"	581
1500	1583.0	1576.9	1595.0	"	42	38	"	3551	"	819

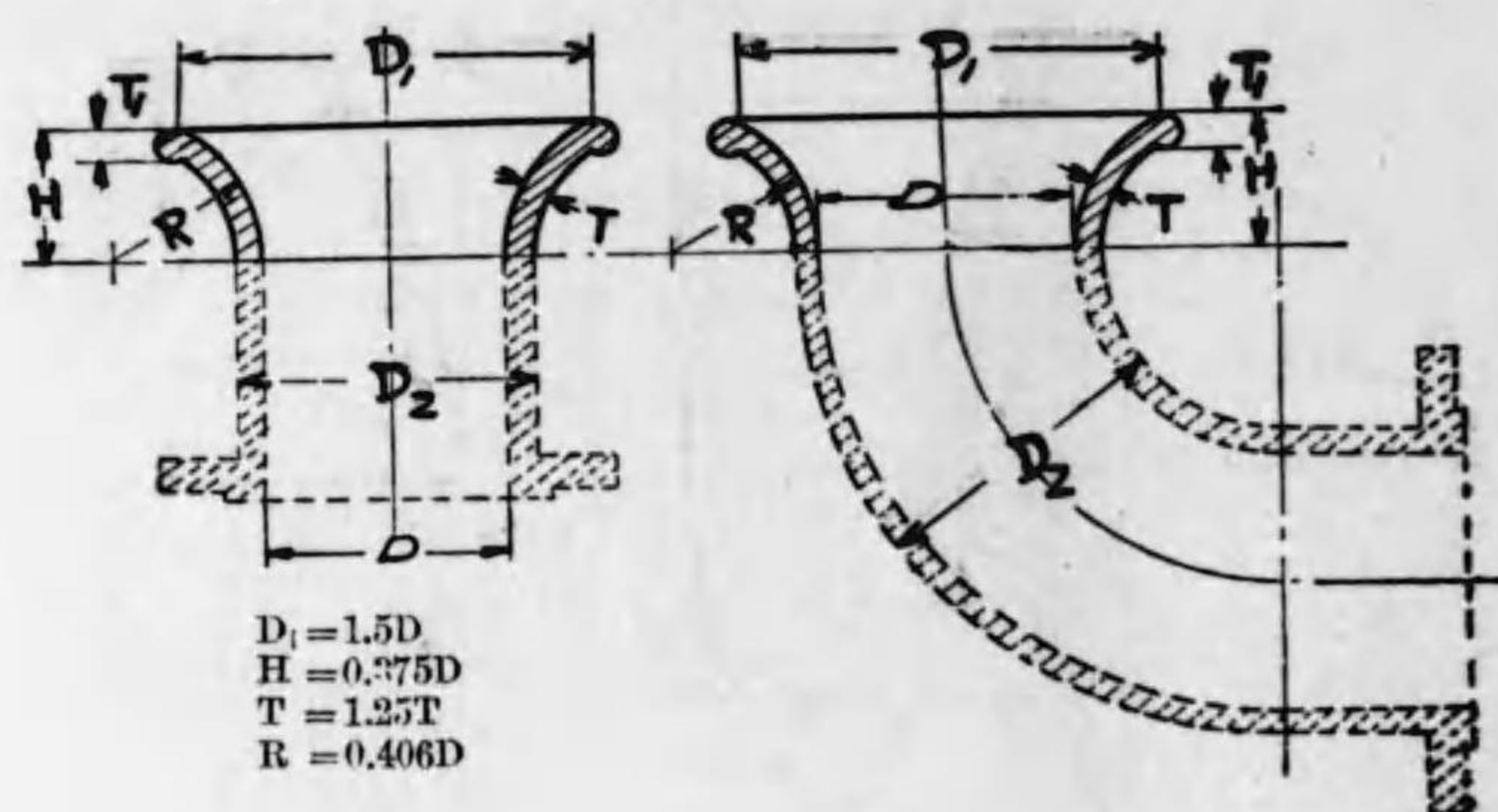
第二十三號 らつば口
第一表 らつば口 甲



らつば口 甲

公稱内徑 D	管厚 T	實外徑 D ₂	各部寸法			重量 點線ノ部分 ハ含マズ
			D ₁	H	R	
75	11.2	97.4	94	47	122	1.11
100	11.8	123.6	125	63	163	2.07
125	12.4	149.8	156	78	203	3.40
150	13.0	176.0	188	94	244	4.86
200	14.2	228.4	250	125	325	9.38
250	15.4	280.8	313	156	406	15.8
300	16.6	333.2	375	188	488	24.6
350	17.8	385.6	438	219	569	35.3
400	19.0	438.0	500	250	650	49.6
450	20.2	490.4	563	281	731	66.8
500	21.5	543.0	625	313	813	87.8
600	23.9	647.8	750	375	975	140
700	26.3	752.6	875	438	1138	223
800	28.7	857.4	1000	500	1300	297
900	31.1	962.2	1125	563	1463	408
1000	33.6	1067.2	1250	625	1625	543
1100	36.0	1172.0	1375	688	1788	640
1200	38.4	1276.8	1500	750	1950	888
1350	42.0	1434.0	1688	844	2194	1240
1500	45.7	1591.4	1875	938	2438	1660

第二十三號 らっぱ口
第二表 らっぱ口乙

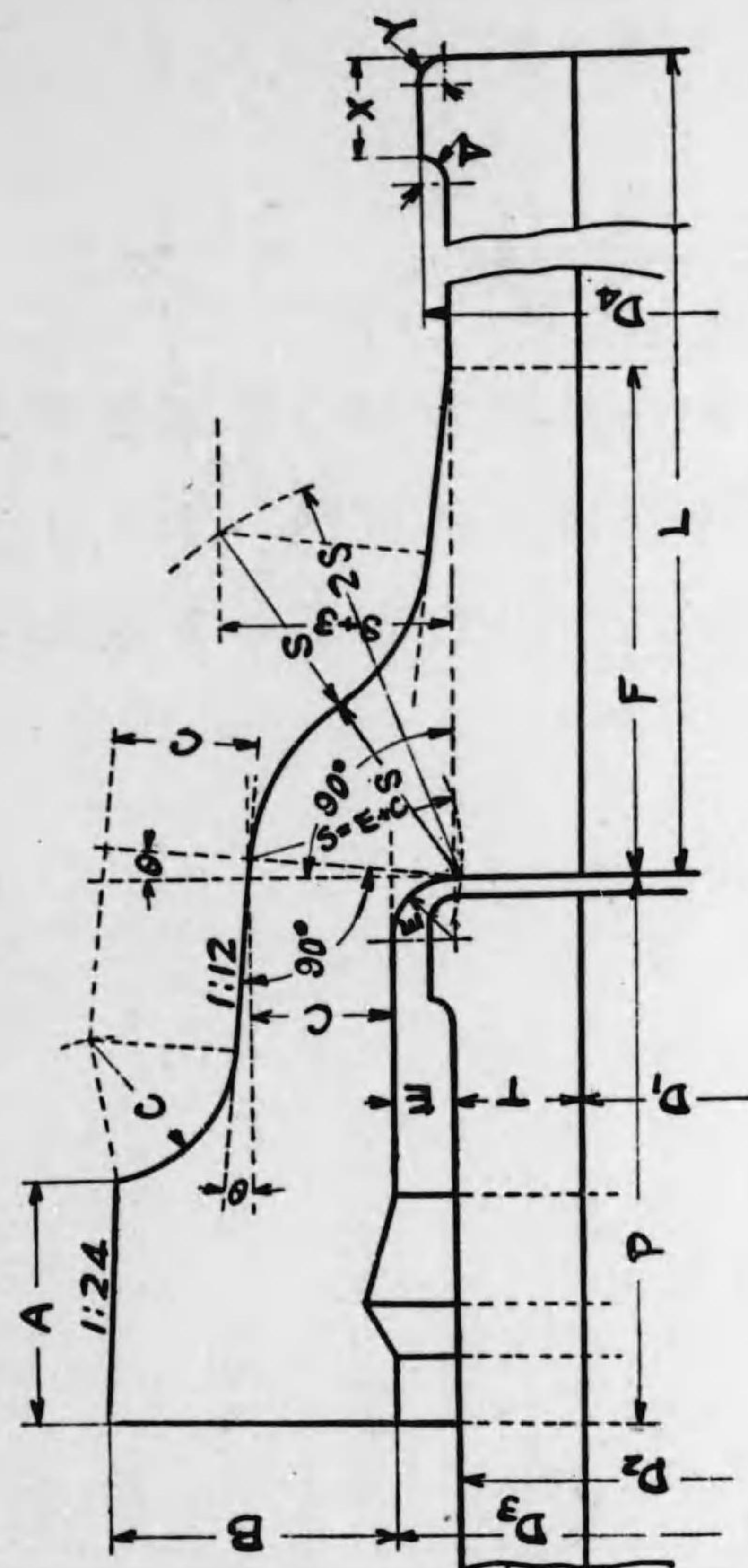


$D_1 = 1.5D$
 $H = 0.375D$
 $T = 1.25T$
 $R = 0.406D$

らっぱ口 乙

公称内径 D	管厚 T	実外径 D ₂	各部寸法				重量 点線ノ部分 分々
			D ₁	T ₁	H	R	
100	11.8	123.6	150	15	33	41	1.76
125	12.4	149.8	188	16	47	51	2.69
150	13.0	176.0	225	17	56	61	4.02
200	14.2	228.4	300	18	75	81	7.61
250	15.4	280.8	375	20	94	102	12.9
300	16.6	333.2	450	21	113	122	19.8
350	17.8	385.6	525	23	131	142	28.9
400	19.0	438.0	600	24	150	162	39.9
450	20.2	490.4	675	25	169	183	53.6
500	21.5	543.0	750	27	188	203	70.3
600	23.9	647.8	900	30	225	244	112
700	26.3	752.6	1050	33	263	284	168
800	28.7	857.4	1200	36	300	325	239
900	31.1	962.2	1350	40	338	365	328

承口断面の書き方



乙 號

水道用鑄鐵管仕様書標準の寸法を
メートル式に変更及異形管の種類
増加に関する調査書

水道用鑄鐵管仕様書標準の 寸法をメートル式に変更及 異形管の種類増加

第一章 總 說

- 1、調査事項大正8年ニ決定セル水道用鑄鐵管仕様書標準ヲ「メートル式」ニ變更スルト共ニ異形管ノ種類ヲ増加セリ
- 2、調査ノ順序 第一ニ「メートル式」ニ依ル直管ノ厚サヲ定ムル公式ヲ定メ承口、挿口等ノ細部ヲ決定シ次ニ在來ノ仕様ニ規定セル曲管、枝管、片落管、接ぎ輪及兩鑄管、片鑄管ノ外今回増加セル異形管ノ種類、形狀、寸法ヲ調査決定セリ
- 3、調査ノ原則 在來ノ直管及異形管ヲ「メートル式」ニ變更セルモ大體其寸法ニ準據シ可成的之レカ變化ヲ來サシメザル範圍内ニ於テ厚サ其他ヲ定ムル公式ヲ選定セリ
- 4、單位 寸法ノ單位ハ耗トシ小數點以下一位ニ止メ以下ヲ四捨五入トセリ、重量ノ單位ハ珎トシ鑄鐵一立方糎ノ重量ヲ7.2瓦トシテ算出セリ、但シ重量表ニハ有效數字三桁ヲ取り以下ヲ四捨五入トス

第二章 直管ノ種類及寸法

- 5、直管ノ長サハ印籠直管 = 在リテハ内徑 150 耗以下ハ 3 米、200 耗以上ハ 4 米トス
兩銑管及片銑管 = 在リテハ内徑 350 耗以下ハ 3 米、400 耗以上ハ 4 米トス
- 6、鐵管ハ 2 種トシ靜水頭 45 米乃至 75 米 = 對スルモノヲ普通壓管ト稱シ靜水頭 45 米未滿 = 對スルモノヲ低壓管ト稱ス
- 7、普通壓管ノ内徑ヲ標準トシ其外徑ヲ定メ低壓管ノ場合 = ハ其外徑ヲ標準トシ其内徑ヲ定ム
- 8、前項ノ内徑ヲ公稱内徑ト稱ヘ左ノ 20 種トス

75 耗	100 耗	125 耗	150 耗	200 耗
250 耗	300 耗	350 耗	400 耗	450 耗
500 耗	600 耗	700 耗	800 耗	900 耗
1,000 耗	1,100 耗	1,200 耗	1,350 耗	1,500 耗

第三章 管ノ厚サノ算定

- 9、鐵管ノ標準壓ハ既 = 前調査委員會 = 於テ各地水道鐵管及諸種ノ既定公式ヲ精細 = 調査ノ上内徑 10 吋以上ノ鐵管ノ厚サハ Fanning 氏ノ公式 = 從ヒ其レ以下ノ鐵管ノ厚サハ同公式ヨリ稍薄キ寸法ヲ得ヘキ公式ヲ作成スルコトトシテ次式ヲ採用セリ

$$T = \frac{(P+P')d}{7,200} + 0.274 + \frac{d^2}{21,000}$$

$$P' = \frac{500}{\sqrt{d+8.8}}$$

式中

T = 管ノ厚サ吋 P = 使用壓力一平方吋 = 於ケル吋

d = 管ノ内徑吋 P' = 水ノ衝擊壓力一平方吋 = 於ケル吋

其後モ土壓及彎曲力率ヲ考慮セル公式ヲ新 = 作成セルモノアルモ遙 = 厚サヲ増シ現狀ト異ナルコト大ナルヲ以テ前回 = 採用セル前記ノ公式ヲ其儘メートル式 = 換算シ其係數ヲ簡約スルコト = 決定シ次ノ 5 式ヲ作成シ之レヲ原式 = 比シ猶從來内徑小ナル管ハ普通敷設延長モ大 = 埋設深モ淺ク且ツ手荒キ取扱ヲ受ケ易キヲ以テ故障比較的多キ事實 = 徵シ審議ノ結果前回委員會 = 於テ 10 吋以下ノ管ノ厚サヲ特 = 稍薄クセント努メタルコトヲ廢シ從來 = 比スレハ幾分小管ノ厚サヲ増スカ如キ直線式ナル第(4)式ヲ採用スルコトトセリ

$$T = \frac{(P+P')d}{506.23} + 6.9596 + \frac{d^2}{533,400} \quad P' = \frac{177.17}{\sqrt{d+223.52}}$$

(原式ヲ其儘メートル式 = 換算セルモノ)

$$T = \frac{(P+P')d}{500} + 7.0 + \frac{d^2}{500,000} \quad P' = \frac{177}{\sqrt{d+224}} \dots\dots(1)$$

$$T = \frac{(P+P')d}{500} + 7.0 + \frac{d^2}{550,000} \quad P' = \frac{175}{\sqrt{d+225}} \dots\dots(2)$$

$$T = \frac{(P+P')d}{500} + 7.0 + \frac{d^2}{500,000} \quad P' = \frac{175}{\sqrt{d+225}} \dots\dots(3)$$

$$T = \frac{(P+P')d}{500} + 8.5 \left(1 - \frac{d}{2,125}\right) \dots\dots(4)$$

$$T = \frac{(P+P')d}{500} + 8.5 \left(1 - \frac{d}{2,360}\right) \dots\dots(5)$$

式中

T = 管ノ厚サ耗

d = 管ノ内徑

P = 靜水壓力每平方糎 = 於ケル恥

P' = 衝擊壓力

第五式ハ Fanning 氏ノ公式ト極メテ能ク一致ス

而シテ前委員會ニ於テハ P ハ使用壓力ナリシモ實際適用上改メテ靜水壓力トスルヲ便ナリト認メ猶東京市水道局ニ於ケル衝擊實驗ノ結果其ノ量ノ普通極メテ小ナルニ鑑ミ之ニ對スル餘裕ヲ水頭ニテ平均 70 米 (7kg/cm^2) ナリシヲ 55 米 (5.5kg/cm^2) ニ減スルコトトセリ、今普通壓管ヲ水頭 75 米ニ對スルモノトシ低壓管ヲ水頭 45 米ニ對スルモノトスレハ管ノ厚サヲ定ムル式ハ第(4)式ニ依リ

普通壓管ノ厚サ $T = 0.022a + 8.5$

低壓管ノ厚サ $T = 0.016a + 8.5$

斯クノ如ク従前ニ比シ衝擊ニ對スル餘裕ヲ約 2 割減セルハ一ツハ實驗ノ結果之レカ安全ヲ信シタルト一ツハ本邦ニ於テ 30[メートル]乃至 45[メートル]ノ水頭ヲ有スル水道比較的多ク之レ等ヲシテ凡テ普通壓管ヲ使用セシムルハ小水道ニ於テハ負擔ヲ重クシ水道ノ普及ヲ阻害スル虞アルトニ因レリ

從テ唧筒ニ直結スル配水管又ハ電力ヲ以テ開閉スル瓣等衝擊作用ノ大ナルカ如キ箇所ニ於テハ空氣室ヲ設クルカ瓣ノ開閉ニ注意ヲ拂フ等特別ノ考慮ヲ要ス

- 10、異形管ノ厚サハ普通壓直管ノ厚サノ 1 割増シヲ通則トス而シテ之レカ増大ハ恒ニ管ノ内方ニ於テシ外徑ハ之レヲ不變ナラシム

第四章 鐵管接手ノ形狀

- 11、管ノ接手ノ形狀ハ主トシテ從來ノ標準ニ準スルモノトシ關東大震災ノ結果ニ鑑ミ多小承口ノ深サヲ増大シ附表第壹號及貳號ノ如ク定メタリ

備考 耐震接手ハ猶慎重ナル研究ヲ要スルヲ以テ別ニ桑港其他ニ於ケル前例ヲ參照シテ實地ニ之レヲ作成シ本委員會第二部ニ於テ更ニ實驗ノ上決定スルモノトス

- 12、突縁ハ從來全ク英國ノ標準ニ據リシモノヲ改メテ汎ク實例ヲ參照シテ附表第壹號及貳號ノ如ク決定セリ

第五章 異管ノ種類及形狀

- 13、異形管ハ十字管、丁字管、片落管、曲管、乙字管、又管、制水瓣附屬用管、消火栓用管、排氣瓣用丁字管、泥吐管、接ぎ輪、短管、帽、栓、らつば口ノ 15 種トス之レニ制水瓣管ニ關係アル寸法ヲ加ヘタリ其形狀ヲ定メンカ爲メニハ前委員會ニ於テ定メタル標準アルモノハ之レニ準シ、今回増加セル新種類ハ各地水道用異形管ノ實例ヲ比較研究シテ細部ヲ附表第壹號乃至第 23 號ノ如ク定メタリ

第六章 抗折試驗片ノ寸法

増減ニ對スル算式

- 14、規格第 8 條抗折試驗片幅及厚サノ増減ノ程度ニ應シ