

# Technical Information

## Tube and Pipe Qualification

DM 20 Series - NPS Pipe		
Size	Min. Wall	Max. Wall
1/4"	Sch.10	Sch.80
3/8"	Sch.10	Sch.80
1/2"	Sch.10	*Sch.160
3/4"	Sch.10	*Sch.160
1"	Sch.10	*Sch.160
1-1/4"	Sch.10	*Sch.160
1-1/2"	Sch.10	*Sch.160
2"	Sch.10	Sch.160
3"	Sch.80	Sch.160

DM 60 Series - OD Tube		
Size	Min. Wall	Max. Wall
1/4"	0.028"	0.083"
3/8"	0.028"	0.095"
1/2"	0.035"	0.120"
5/8"	0.035"	0.120"
3/4"	0.049"	0.180"
1"	0.049"	0.180"
1-1/4"	0.065"	0.220"
1-1/2"	0.065"	0.220"
2"	0.065"	0.220"

DM 80 Series - Metric Tube		
Size	Min. Wall	Max. Wall
6mm	1mm	2mm
8mm	1mm	2mm
10mm	1mm	3mm
12mm	1mm	3mm
15mm	1mm	3mm
16mm	1mm	3mm
18mm	1mm	3mm
20mm	1mm	4mm
22mm	1mm	4mm
25mm	2mm	4mm
28mm	2mm	4mm
30mm	2mm	*5mm
35mm	2mm	4mm
38mm	3mm	*6mm
42mm	3mm	*6mm
50mm	3mm	*7mm
60mm	3mm	*8mm

DM 80 Series - JIS Metric Tube			
Size	OD	Min. Wall	Max. Wall
06A	10.50mm	1.00mm	3.00mm
08A	13.80mm	1.00mm	3.00mm
10A	17.30mm	1.00mm	3.20mm
15A	21.70mm	1.00mm	4.00mm
20A	27.20mm	2.00mm	4.00mm
25A	34.00mm	2.00mm	6.40mm
32A	42.70mm	3.00mm	6.40mm
40A	48.60mm	3.00mm	7.14mm
50A	60.50mm	3.00mm	8.71mm

DP 40N Series - NPS Low Pressure		
Size	Min. Wall	Max. Wall
2-1/2"	Sch.10	Sch.80
3"	Sch.10	Sch.80
4"	Sch.10	Sch.80

DP 40M Series - Metric Pipe CuNi Tube		
Size	Min. Wall	Max. Wall
44.5mm	1mm	3mm
57mm	1mm	3mm
76mm	1mm	3mm

\*heavy wall thickness may require a larger size Pyplok tool to swage the Pyplok fitting. Please consult the factory.

Allowable Outside Pipe/Tube Diameter Tolerances for PYPLOK®		
NPS Pipe	1/4" to 1-1/2"	+/- 0.015" (0.381mm)
	2" - 4"	+/- 0.030" (0.762mm)
OD Tube	1/4" to 3/8"	+/- 0.005" (0.127mm)
	1/2" to 1-1/2"	+/- 0.010" (0.254mm)
	2"	+/- 0.015" (0.381mm)
Metric Tube	6mm to 38mm	+/- 0.254mm (0.010")
	42mm to 60mm	+/- 0.381mm (0.015")
JIS Metric Tube	06A - 25A	+/- 0.254mm (0.010")
	32A - 50A	+/- 0.381mm (0.015")

*Qualified Pipe/Tube		
Stainless Steel PYPLOK®	Carbon Steel PYPLOK®	Copper Nickel PYPLOK®
ASTM A312/A269 (304/304L/316/316L) EN 10216-5 (304/304L/316/316L) EN10305-4 (E355N/ST52.4)	ASTM A106 Gr. A/B/C A53 ERW Gr. A/B EN10305-4 (E355N/E235N/ST52.4/ST37.4) API 5L Seamless/ERW ASTM A333 Gr.6	MIL-T-16420 (70/30 & 90/10) EEMUA 144 ASTM B466 DIN 1755

\*As there are numerous pipe/tube specs, not every spec has been listed. If you do not see your spec please consult the factory to confirm pipe/tube qualification.

**2" NPS DM 20 Series Carbon Steel PYPLOK® cannot be used on EN 10305-4 (E355N/ST52.4) pipe/tube but as replacement 2" NPS DM 20 Series Stainless Steel PYPLOK® or 60mm DM 80 Series Carbon Steel PYPLOK® can be used.**

# Technical Information

## Tube and Pipe Qualification: CUSTOM Material

DM 20 Series - NPS Pipe		
Size	Min. Wall	Max. Wall
1/4"	Sch.10	Sch.80
3/8"	Sch.10	Sch.80
1/2"	Sch.10	Sch.80
3/4"	Sch.10	Sch.80
1"	Sch.10	Sch.80
1-1/4"	Sch.10	Sch.80
1-1/2"	Sch.10	Sch.80
2"	Sch.10	Sch.80

DM 60 Series - OD Tube		
Size	Min. Wall	Max. Wall
1/4"	0.028"	0.083"
3/8"	0.028"	0.095"
1/2"	0.035"	0.120"
5/8"	0.035"	0.120"
3/4"	0.049"	0.180"
1"	0.049"	0.180"
1-1/4"	0.065"	0.180"
1-1/2"	0.065"	0.180"
2"	0.065"	0.180"

DP 40N Series - NPS Low Pressure		
Size	Min. Wall	Max. Wall
2-1/2"	Sch.10	Sch.40
3"	Sch.10	Sch.40
4"	Sch.10	Sch.40

\*For certain sizes and heavier wall thickness larger tonnage PYPLOK® tooling maybe required. Consult factory for guidance on tool section with custom materials along with PYPLOK® Installation manual for special instructions.

Allowable Outside Pipe/Tube Diameter Tolerances for PYPLOK®		
NPS Pipe	1/4" to 1-1/2"	+/- 0.015" (0.381mm)
	2" - 4"	+/- 0.030" (0.762mm)
OD Tube	1/4" to 3/8"	+/- 0.005" (0.127mm)
	1/2" to 1-1/2"	+/- 0.010" (0.254mm)
	2"	+/- 0.015" (0.381mm)

*Qualified Pipe/Tube		
DUPLEX PYPLOK®	SUPER DUPLEX PYPLOK®	TITANIUM PYPLOK®
ASTM A790 (S31803/2205)	ASTM A790 (S32750/2507)	ASTM B861 Grade 2

\*As there are numerous pipes/tube specs, not every spec has been listed. If you do not see your spec please consult the factory to confirm pipe/tube qualification.