HAMMER UNION FIG 1502 NPT

Three Lug Hammer Union · Forged Steel · NPT Threaded Ends · 15,000 psi CWP

BRAND: SARA SAE | SKU: SW-0049 | SIZE 1" TO 4" | 15,000 PSI CWP



FIG. 1 | HAMMER UNION FIG 1502, NPT THREADED ENDS

PRODUCT OVERVIEW

The Sara Sae Fig 1502 hammer union is a quick make-up pipe connection for air, water, oil, gas and mud service on manifolds, truck mounted units and other high pressure installations. A three lug wing nut draws the male and female subs together and is tightened or released with a hammer, so lines can be assembled and broken out quickly without special tools.

A replaceable lip type seal ring in Buna-N gives the pressure seal, protects the metal to metal seating face and keeps turbulence in the flow path low. Both subs have female NPT (line pipe) threads for direct make-up on threaded pipe. The union is rated to 15,000 psi cold working pressure and is colour coded for identification: blue nut, red subs.

Product type	**Hammer union, three lug**
Figure	**Fig 1502**
Material	**Forged steel**
End connection	**Female NPT threaded**
Pressure rating	**15,000 psi CWP**
Size range	**1" to 4"**

TECHNICAL SPECIFICATION

Figure	**Fig 1502**	Nut	**Three lug wing nut, forged steel**
Cold working pressure	**15,000 psi**	Subs	**Forged steel, male and female**
Test pressure	**On request**	Colour code	**Blue nut, red subs**
End connection	**Female NPT, ASME B1.20.1**	Sour service	**10,000 psi working**
Sealing	**Buna-N lip seal ring**	Pipe schedule	**Not applicable**
Nut thread	**ACME**	Make-up	**Hammer, no special tools**

BILL OF MATERIALS

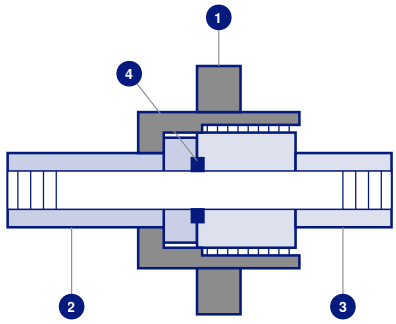

FIG. 2 | SECTIONAL ARRANGEMENT

#	COMPONENT	MATERIAL
1	Wing nut, three lug	Forged steel
2	Male sub	Forged steel
3	Female sub, ACME thread	Forged steel
4	Lip seal ring	Buna-N (nitrile)

Steel grade and heat treatment are as per the manufacturer certificate for the supplied batch. Seal rings are replaceable and are available as spares.

DIMENSIONS AND WEIGHTS

SIZE	NUT RADIUS (IN)	NUT RADIUS (MM)	TOTAL LENGTH (IN)	TOTAL LENGTH (MM)	WEIGHT (KG)
1"	2-3/4"	70	4-3/8"	111	3.82
2"	4"	102	7"	178	9.54
3"	4-13/16"	122	7-5/8"	194	14.10
4"	6-1/16"	154	8-1/2"	216	34.00

Nut radius = pipe centreline to the tip of the lug. Total length = overall length of the made-up union. Figures are converted from the manufacturer catalogue, are nominal and are given for guidance only. Derates to 10,000 psi working pressure for sour service.

ORDERING INFORMATION

FIELD	OPTIONS
Product code	SW-0049
Figure	Fig 1502, 15,000 psi CWP
Size	1", 2", 3", 4"
End connection	Female NPT
Service	Standard or sour gas
Order example	**SW-0049 / FIG 1502 / 2" / NPT**

Stock held in Dubai for fast despatch across the UAE and GCC. Contact our sales desk for pricing, availability, project quantities and certification requirements.

PRESSURE AND TEMPERATURE

Cold working pressure	**15,000 psi**
Test pressure	**On request**
Sour service, working	**10,000 psi**
Service	**Non-shock, cold working**

CWP = cold working pressure, non-shock. On threaded unions the usable pressure of the joint is also limited by the pipe and the thread connection. Seal material sets the temperature limit where a seal is fitted. Confirm the duty with SWBM before ordering.

TYPICAL APPLICATIONS

- Oilfield service and well site flow lines
- Cementing, fracturing and mud pump lines
- Choke and kill, standpipe and manifold connections
- Truck mounted and skid mounted pumping units
- Temporary pipework and hose connections
- Marine and industrial fluid transfer

COMPLIANCE AND QUALITY

- Figure 1502 pattern, colour coded: blue nut, red subs
- Forged steel wing nut and subs
- Three lug nut for fast make-up and break-out with a hammer
- NPT threads to ASME B1.20.1
- Sour gas service versions rated as shown, to NACE MR0175 / ISO 15156
- Figure number, size and pressure rating marked on the nut
- Material and test certificates on request

INSTALLATION AND OPERATION

- Check that the figure number, size and pressure rating on both halves match before make-up
- Never join halves of different figure numbers or pressure ratings, even where the threads appear to engage
- Apply thread sealant to the male pipe thread only
- Clean and inspect the ACME threads and sealing faces. Replace any damaged seal ring
- Run the nut up by hand, then tighten by striking the lugs squarely with a hammer
- Never tighten, loosen or strike a union while the line is under pressure
- Wear eye protection. Dress or replace nuts with mushroomed or cracked lugs

COMPANY

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