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**Hydraulic fluid power — Dimensions and  
identification code for mounting flanges  
and shaft ends of displacement pumps and  
motors —**

**Part 2:  
Metric series**

*Transmissions hydrauliques — Dimensions et code d'identification des  
flasques de montage et des bouts d'arbres des pompes volumétriques et  
moteurs —*

*Partie 2: Série métrique*



Reference number  
ISO 3019-2:2001(E)

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Printed in Switzerland

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this part of ISO 3019 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 3019-2 was prepared by Technical Committee ISO/TC 131, *Fluid power systems*, Subcommittee SC 2, *Pumps, motors and integral transmissions*.

This third edition cancels and replaces the second edition (ISO 3019-2:1986) and ISO 3019-3:1988, which have been technically revised.

ISO 3019 consists of the following parts, under the general title *Hydraulic fluid power — Dimensions and identification code for mounting flanges and shaft ends of displacement pumps and motors*:

- *Part 1: Inch series shown in metric units*
- *Part 2: Metric series*

Annex A of this part of ISO 3019 is for information only.

## Introduction

In hydraulic fluid power systems, power is transmitted and controlled through a liquid under pressure within an enclosed circuit. Pumps convert mechanical power into hydraulic fluid power, while motors convert hydraulic fluid power into mechanical power.

This part of ISO 3019 provides

- a minimum number of flanges and shaft sizes to cover probable present and future requirements (short and long flange spigot options are included),
- dimensional interchangeability of flange and shaft end mountings,
- flange and spigot dimensions allowing for recommended sealing arrangements when sealing is required between a flange and its mating housing (see annex A), and
- identification codes for flanges and shaft ends that can be used separately or in combination.



# Hydraulic fluid power — Dimensions and identification code for mounting flanges and shaft ends of displacement pumps and motors —

## Part 2: Metric series

### 1 Scope

This part of ISO 3019 establishes a metric series of mounting flanges and shaft ends for positive-displacement, rotary hydraulic fluid power pumps and motors. It specifies sizes and dimensions and establishes an identification code for two- and four-bolt, and polygonal (including circular), mounting flanges, as well as for cylindrical keyed shaft ends, conical keyed shaft ends with an external thread and metric involute spline shaft ends.

NOTE Involute spline is in accordance with DIN 5480 [1]...[8].

## 2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 3019. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 3019 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 261:1998, *ISO general-purpose metric screw threads — General plan*.

ISO 286-2:1988, *ISO system of limits and fits — Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts*.

ISO 1101:—<sup>1)</sup>, *Geometrical Product Specifications (GPS) — Geometrical tolerancing — Tolerances of form, orientation, location and run-out*.

ISO 3912:1977, *Woodruff keys and keyways*.

ISO 5598, *Fluid power systems and components — Vocabulary*.

## 3 Terms and definitions

For the purposes of this part of ISO 3019, the terms and definitions given in ISO 5598 apply.

## 4 Dimensions

### 4.1 Tolerances

Dimensions shown without tolerances are nominal.

Tolerances of form and position are shown in accordance with ISO 1101.

### 4.2 Selection of mounting flanges and shaft ends

#### 4.2.1 General

Selection of mounting flange (4.2.2) and shaft end (4.2.3) dimensions for pumps and motors manufactured in accordance with this part of ISO 3019 shall be according to Tables 1 to 6 and Figures 1 to 6.

For the dimensions of cylindrical keyed shaft ends without internal thread, conical shaft ends with external thread and metric involute spline shaft ends, see Figures 4, 5 and 6, and Tables 7, 8 and 9, respectively.

#### 4.2.2 Mounting flanges

Select mounting flanges according to the following.

- For two-bolt mounting flanges, choose from Table 4, see Figure 1.
- For four-bolt mounting flanges, choose from Table 5, see Figure 2.
- For polygonal (including circular) mounting flanges, choose from Table 6, see Figure 3.
- Avoid, whenever possible, the non-preferred series of two- and four-bolt mounting flanges identified in Tables 1, 4 and 5.

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1) To be published. (Revision of ISO 1101:1983)



### 4.2.3 Shaft ends

4.2.3.1 Nominal shaft end diameter,  $D$  (see Figure 4 and Figure 5), in relation to flange spigot diameter,  $A$ , shall be selected from Table 1 or 2, depending on the type of mounting flange.

**Table 1 — Series of shaft ends for two- and four-bolt mounting flanges**

Dimensions in millimetres

Flange spigot $A$	Shaft end $D$		
	1st choice	2nd choice	Non-preferred
32	10	—	—
40	12	—	—
50	12	16	10
63	16	20	12
80	20	25	16
100	25	32	20
125	32	40	25
140 <sup>a</sup>	32	40	25
160	40	50	32
180 <sup>a</sup>	40	50	32
200	50	63/60 <sup>b</sup>	40
224 <sup>a</sup>	50	63/60 <sup>b</sup>	40
250	63/60 <sup>b</sup>	80	50

For applications such as those involving high torque or heavy side loads, other shaft dimensions may be selected.

<sup>a</sup> Non-preferred flange spigot dimensions.  
<sup>b</sup> Reference diameter for spline shaft.

Table 2 — Series of shaft ends for polygonal mounting flanges

Dimensions in millimetres

Flange spigot <i>A</i>	Shaft end <i>D</i>		
	1st choice	2nd choice	Non-preferred
80	20	25	16
100	25	32	20
125	32	40	25
160	40	50	32
180	40	50	32
200	50	63	40
224	50	63	40
250	63	70	50
280	63	80	—
315	70	80	—
355	70	80	—
400	80	90	—
450	90	110	—
500	90	110	—
560	110	125/120 <sup>a</sup>	—
630	125/120 <sup>a</sup>	140	—
710	140	160	—
800	160	180	—
900	160	180	—
1 000	180	200	—

For applications such as those involving high torque or heavy side loads, other shaft dimensions may be selected.

<sup>a</sup> Reference diameter for spline shaft.

4.2.3.2 The shaft end shape shall be of one of the following types:

- a) cylindrical keyed shaft end (see Figure 4),
- b) conical keyed shaft end with external thread (see Figure 5), or
- c) metric involute spline shaft end (see Figure 6).

For the nominal shaft end diameter, *D*, select the module of involute spline shaft end and the corresponding number of teeth with respect to the reference diameter from Table 3.

Shaft ends a) and c) may be provided with a tapped hole.

4.2.3.3 Only parallel or Woodruff keys in accordance with ISO 3912 shall be used.

4.2.3.4 For the first and second choices, select shaft end lengths *L<sub>L</sub>*, *L<sub>S</sub>* and *L<sub>ST</sub>* from the short series, except for conical shaft ends of nominal diameters 10 and 12, for which the long series only is available.

For the non-preferred series, select the shaft end lengths *L<sub>L</sub>*, *L<sub>S</sub>* and *L<sub>ST</sub>* from the long series.

On conical shaft ends, the length of the conical surface may exceed *L<sub>ST</sub>* towards the mounting flange, provided *D* is located at *L<sub>ST</sub>*.

Table 3 — Compatible metric involute spline shaft ends

Shaft end reference diameter $d_B$ mm	Module					Number of teeth		Min. shaft diameter <sup>a</sup> $U_{min}$ mm	
	0,8	1,25	2	3	5	●	○	●	○
10	●					11	—	7,6	—
12	●					13	—	9,6	—
16		●				11	—	12,4	—
20		●				14	—	16,4	—
25		●				18	—	21,4	—
32			●			14	—	26,4	—
40			●	○		18	12	34,4	31,8
50			●	○		24	15	44,4	41,8
60			●	○		28	18	54,4	51,7
70				●		22	—	61,7	—
80				●		25	—	71,7	—
90				●	○	28	16	81,7	76,4
110				●	○	35	20	101,7	96,4
120				●	○	38	22	111,7	106,4
140				●	○	45	26	131,7	126,4
160					●	30	—	146,4	—
180					●	34	—	166,4	—
200					●	38	—	186,4	—

● Preferred module/series.  
○ Non-preferred module/series.

<sup>a</sup> See Figure 6.

### 4.3 Mating components

The dimensions and related tolerances of the mating components shall be compatible with the dimensions and tolerances specified in this part of ISO 3019, thus avoiding undue body strain as well as transverse loads on shafts in excess of those permitted by the pump or motor manufacturer.

## 5 Identification code

### 5.1 Mounting flanges

When identifying mounting flanges in accordance with this part of ISO 3019, the following code shall be used.

- Use the term "Flange".
- Refer to this part of ISO 3019: ISO 3019-2.
- Indicate the size reference of the flange by stating the spigot diameter,  $A$ , in millimetres.
- Indicate the flange shape:

— two-bolt mounting flange:  $A$ ;

## ISO 3019-2:2001(E)

- four-bolt mounting flange: B;
  - polygonal mounting flange (including circular flange): D.
- e) Indicate the number of fixing holes: 2 to 14.
- f) Indicate the kinds of holes or slots:
- clearance holes (preferred): H;
  - tapped holes (non-preferred): T;
  - slots: S.
- g) Indicate the spigot version:
- short spigot: W;
  - long spigot: L.

When both a flange and shaft are coded jointly, this indication should be omitted from the code.

See 5.3 for designation examples.

### 5.2 Shaft ends

When identifying shaft ends in accordance with this part of ISO 3019, the following code shall be used.

- a) Use the term "Shaft ends".
- b) Refer to this part of ISO 3019: ISO 3019-2.
- c) Indicate the shape of the shaft end:
- cylindrical keyed shaft end, but without internal thread: E;
  - conical keyed shaft end with external thread: F;
  - cylindrical keyed shaft end with internal thread (non-preferred): G;
  - metric involute spline shaft end according to Table 3: P.
- d) Indicate the size reference of the shaft by using the nominal diameter,  $D$ , in millimetres.
- e) Indicate the shaft end length:
- short shaft end: N;
  - long shaft end: M.

See 5.3 for designation examples.

### 5.3 Designation examples

EXAMPLE 1 A four-bolt mounting flange of spigot diameter 100 mm, having a short spigot with clearance holes:

**Flange ISO 3019-2 - 100B4HW**

EXAMPLE 2 A conical shaft end, with external thread, of nominal diameter ( $D$ ) 32 mm, short series:

**Shaft end ISO 3019-2 - F32N**

EXAMPLE 3 The combination of both elements designated in the above examples:

**Flange and shaft end ISO 3019-2 - 100B4HW - F32N**

## 6 Flange/shaft end concentricity and perpendicularity

Maintain flange or shaft end concentricity and perpendicularity within the limits shown in Figures 1 to 3 and given in Tables 4 to 6.

NOTE Rigid couplings may require closer tolerances.

## 7 Identification statement (Reference to this part of ISO 3019)

It is strongly recommended that manufacturers use the following statement in test reports, catalogues and sales literature when electing to comply with this part of ISO 3019:

*“Dimensions and identification code for mounting flanges and shaft ends in accordance with ISO 3019-2:2001, Hydraulic fluid power — Dimensions and identification code for mounting flanges and shaft ends of displacement pumps and motors — Part 2: Metric series.”*

Dimensions in millimetres,  
surface roughness values in micrometres

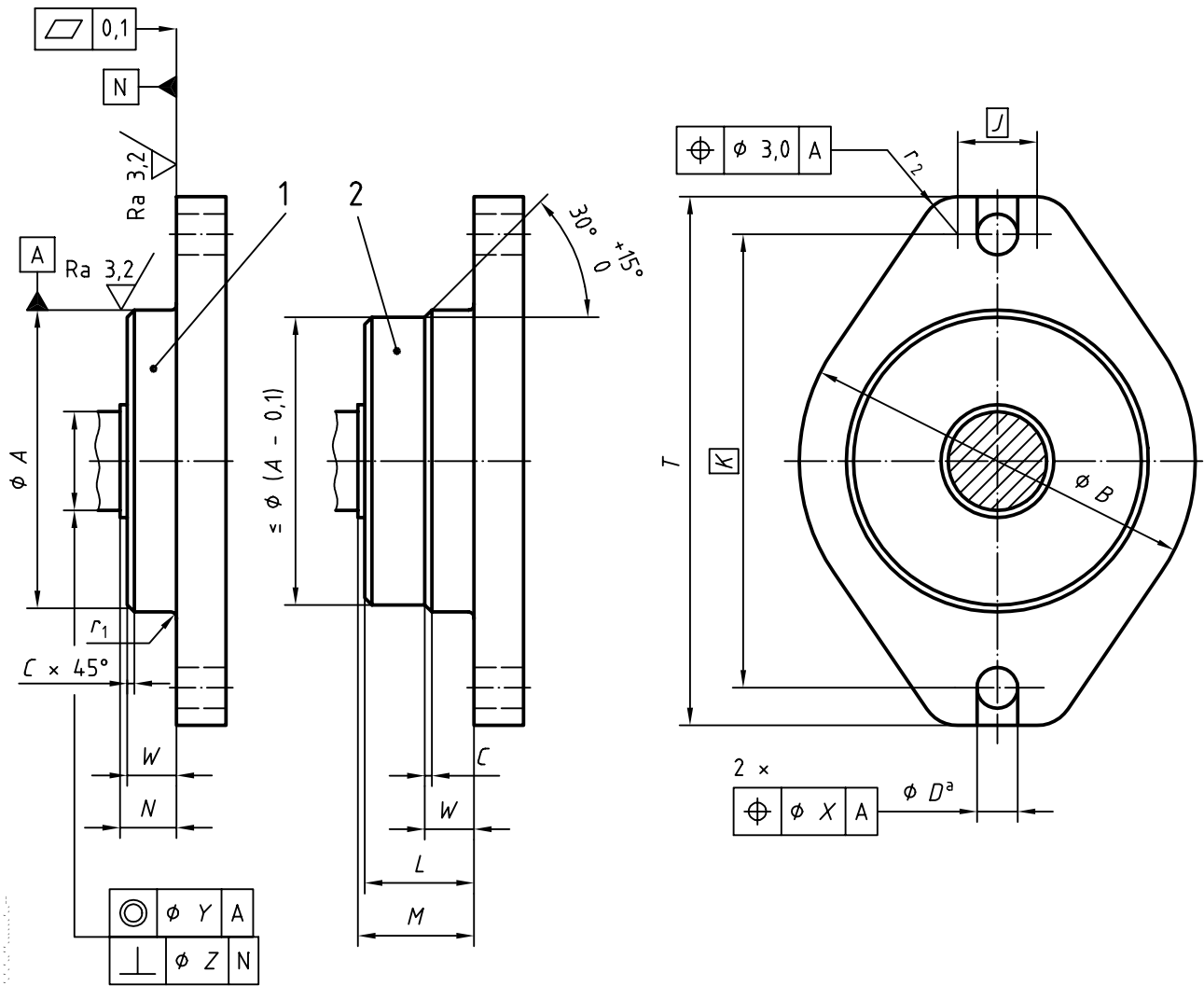


Figure 1 — Basic layout of two-bolt mounting flanges

Key

- 1 Short spigot version
- 2 Long spigot version
- a Slots or threaded holes may be used instead of holes.

Table 4 — Dimensions of two-bolt mounting flanges

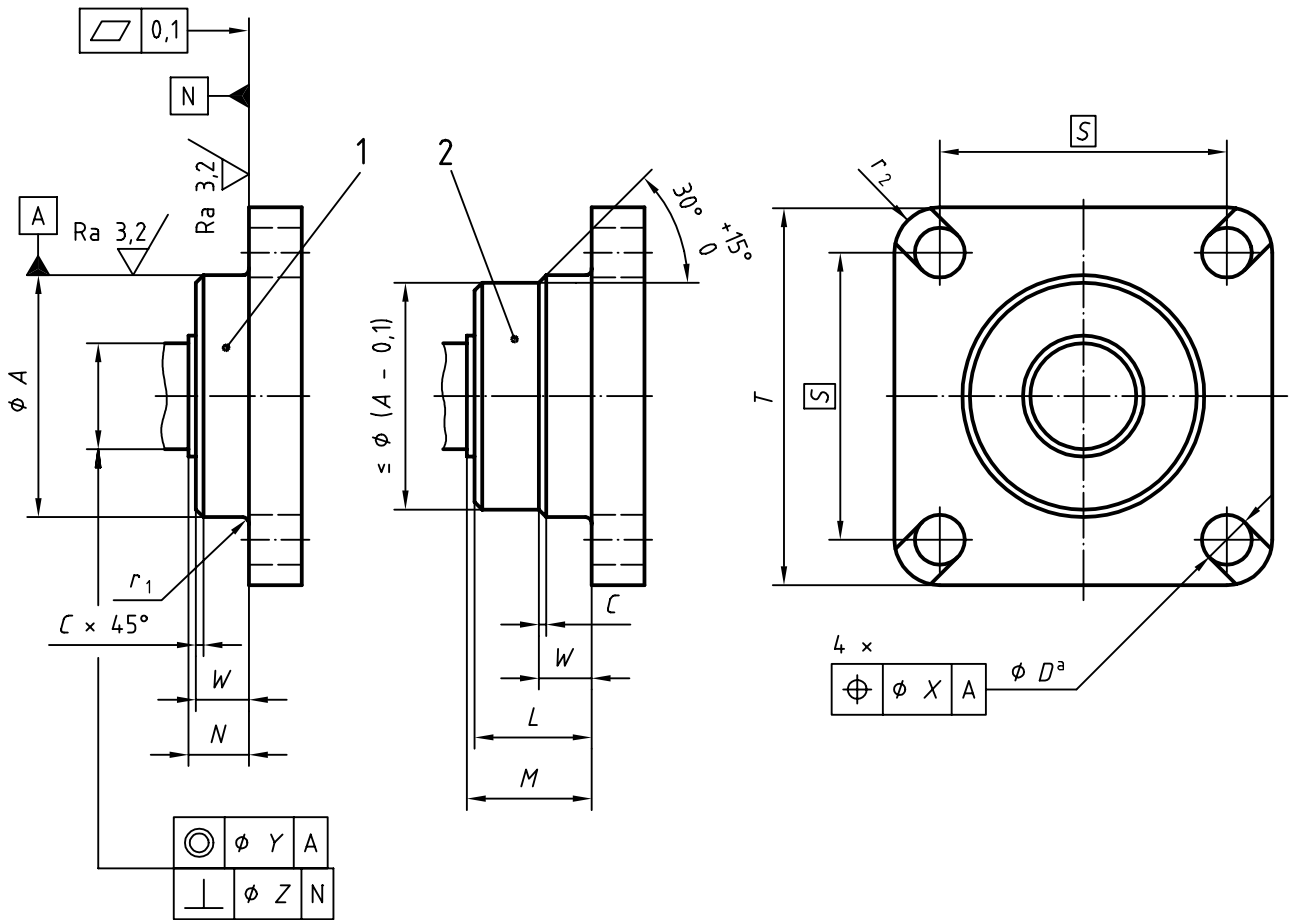
Dimensions in millimetres

Pilot dimensions									Flange dimensions										
A	W	N	L	M	C	r <sub>1</sub>	γ <sup>b</sup>	Z <sup>b</sup>	B	J	K	D		X	T	r <sub>2</sub>			
h8	+0,5 0	+0,1 0	max.	Flange spigot (long)	max.	max.		mm/mm				2 bolts	Clear holes						
									tol.			Thread	H13		tol.	max.			
32	7	8	15,5	16 <sup>+1</sup> <sub>0</sub>	1,5	0,5	0,2	0,001 5	50	± 0,5	8	56	M6	6,6	0,3	72	± 0,5	8	
40				56					10		63	79							
50			19,5	20 <sup>+1</sup> <sub>0</sub>					0,25		65	12	80	M8	9	0,5			100
63											80	14	100						120
80											100	18	109						M10
100	9	10	24,5	25 <sup>+1</sup> <sub>0</sub>	2	1,6	0,35	0,002	125	± 1,5	20	140	M12	13,5	0,75	168	± 1,5	14	
125				31,5					32 <sup>+1</sup> <sub>0</sub>		150	24	180	M16		17,5			216
140 <sup>a</sup>			39,5								40 <sup>+1</sup> <sub>0</sub>	170	34		200				M20
160												200	42	224	268				
180 <sup>a</sup>			212								52	250	294						
200			236	56					280		M24	26	332	26					

NOTE For tolerance values, see ISO 286-2.

<sup>a</sup> Non-preferred size.  
<sup>b</sup> Tolerances stated are for the unloaded condition. (Rigid couplings may require tighter tolerances.)

Dimensions in millimetres,  
surface roughness values in micrometres



**Key**

- 1 Short spigot version
- 2 Long spigot version
- a Slots or threaded holes may be used instead of holes.

**Figure 2 — Basic layout of four-bolt mounting flanges**



Table 5 — Dimensions of four-bolt mounting flanges

Dimensions in millimetres

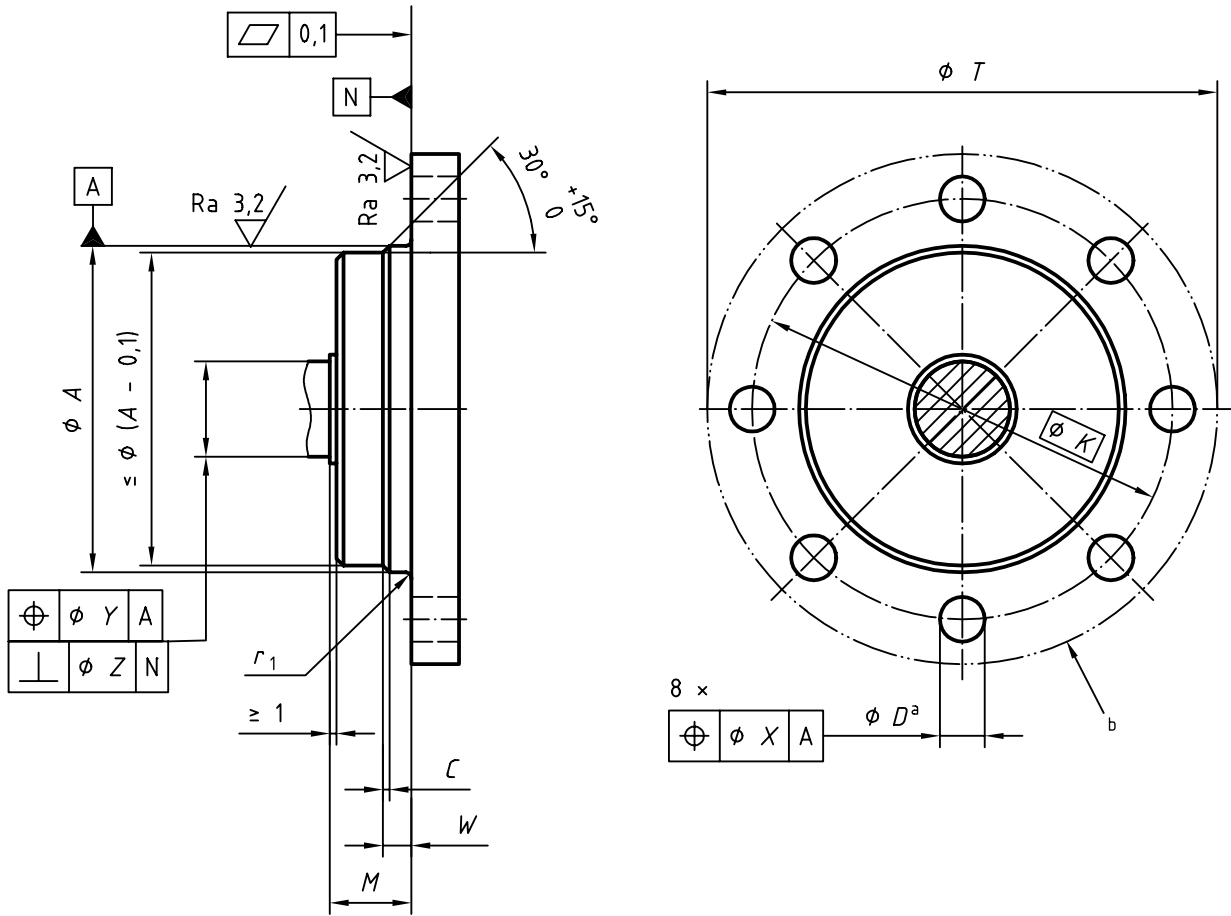
A	W	N Flange spigot (short)	Pilot dimensions						Flange dimensions					
			L	M Flange spigot (long)	C	r <sub>1</sub>	γ <sup>b</sup>	z <sup>b</sup> mm/mm	S	D 4 bolts Clear holes	X	T	r <sub>2</sub>	
h8	+0,5 0	+0,1 0	max.		max.	max.				Thread	H13		max.	
63	7	8	19,5	20 <sup>+1</sup> <sub>0</sub>	1,5	0,5	0,2	0,001 5	60,1	M8	9	0,5	80	10
80							0,25		72,8				100	
100	9	10	24,5	25 <sup>+1</sup> <sub>0</sub>	2	1,6	0,3		0,002	88,4	M10		11	0,75
125			31,5	32 <sup>+1</sup> <sub>0</sub>			113,2	M12		13,5	150	18		
140 <sup>a</sup>			39,5	40 <sup>+1</sup> <sub>0</sub>			127,3				170			
160			49,5	50 <sup>+1,2</sup> <sub>0</sub>			141,4	M16		17,5	190	22		
180 <sup>a</sup>			0,35	158,4			212							
200			0,4	176,8			M20	22		1	236	24		
224 <sup>a</sup>			198	266										
250			222,8	M24			26	301			2			

NOTE For tolerance values, see ISO 286-2.

<sup>a</sup> Non-preferred size.

<sup>b</sup> Tolerances stated are for the unloaded condition. (Rigid couplings may require tighter tolerances.)

Dimensions in millimetres,  
surface roughness values in micrometres



- a Slots or threaded holes may be used instead of holes.
- b Circular envelope.

Figure 3 — Basic layout of polygonal mounting flanges

Table 6 — Dimensions of polygonal mounting flanges

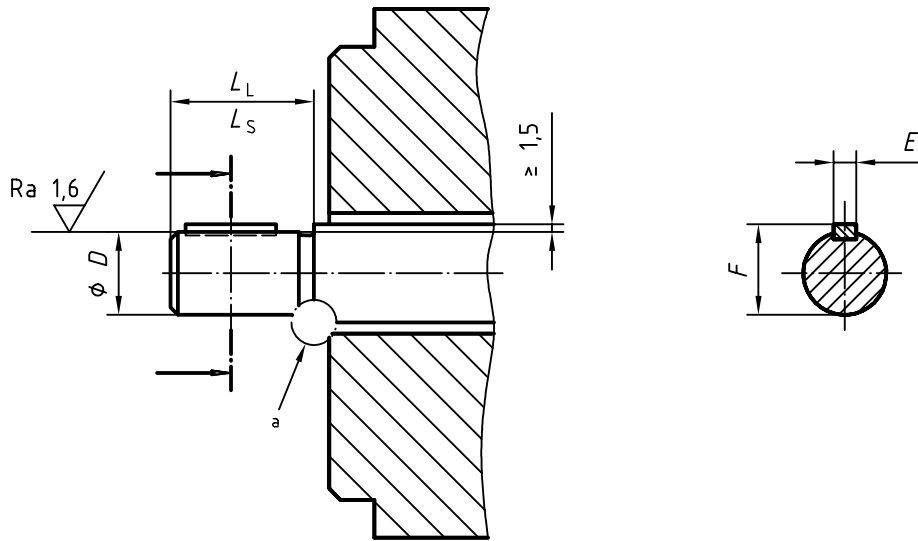
Dimensions in millimetres

A	Pilot dimensions						Flange dimensions										
	W	M	C	r <sub>1</sub>	y <sup>a</sup>	z <sup>a</sup>	K	D		X	T						
	h8		max.			mm/mm		Quantity	Thread			Clear holes					
80	7 <sup>+0,5</sup> <sub>0</sub>	20 ± 0,8	2	0,5	0,25	0,001 5	103	M8	9	0,5	125						
100							125				M10	11	160				
125							160				M12	13,5	200				
160	9 <sup>+0,5</sup> <sub>0</sub>	25 ± 0,8					1,6	0,35	0,002		200	M16	17,5	1	250		
180											224				5, 6 7 or 8	280	280
200											250					300	
224	280	335															
250	16 <sup>+1</sup> <sub>0</sub>	40 ± 0,8	3	1,6	0,35	0,002	300	M20	22	355							
280							320			375							
315							360			425							
355			400				465										
400			450				515										
450			510				585										
500	20 <sup>+1</sup> <sub>0</sub>	50 ± 1	5	1,6	0,35	0,002	560	M24	26	1,5	635						
560							630				5, 7 8, 10 12 or 14	710	710				
630							710					800					
710							800	900									
800							60 ± 1,5	5	5		1,6	0,35	0,002	900	M30	33	1 000
900														1 000			1 100
1 000	1 100	1 200															
1 000	1 100	1 200															

NOTE For tolerance values, see ISO 286-2.

<sup>a</sup> Tolerances stated are for the unloaded condition. (Rigid couplings may require tighter tolerances.)

Dimensions in millimetres,  
surface roughness values in micrometres



a At the option of the manufacturer.

Figure 4 — Basic layout of cylindrical keyed shaft ends without internal thread

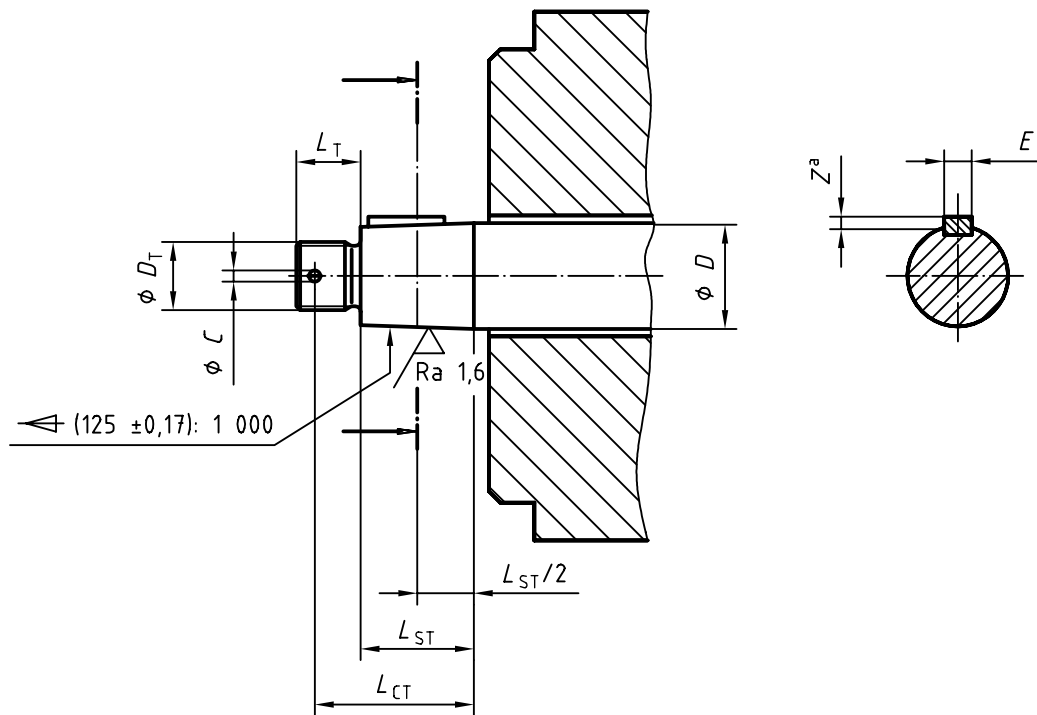
Table 7 — Dimensions of cylindrical keyed shaft ends without internal thread

Dimensions in millimetres

<i>D</i>		<i>E</i> Key width h9	<i>F</i>	<i>L<sub>L</sub></i> Long	<i>L<sub>S</sub></i> Short
nom.	tol.				
10	j7	3	11,2	23	20
12		4	13,5	30	25
16		5	18	40	28
20		6	22,5	50	36
25		8	28	60	42
32	k7	10	35	80	58
40		12	43	110	82
50		14	53,5	110	82
63	m7	18	67	140	105
70		20	74,5	140	105
80		22	85	170	130
90		25	95	170	130
110		28	116	210	165
125		32	132	210	165
140		36	148	250	200
160		40	169	300	240
180		45	190	300	240
200	45	210	350	280	

NOTE For tolerance values, see ISO 286-2.

Dimensions in millimetres,  
surface roughness values in micrometres



<sup>a</sup> Dimension  $Z$  is normal to the key and at the large end of the taper.

**Figure 5 — Basic layout of conical keyed shaft ends with external thread**

Table 8 — Dimensions of conical keyed shaft ends with external thread

Dimensions in millimetres

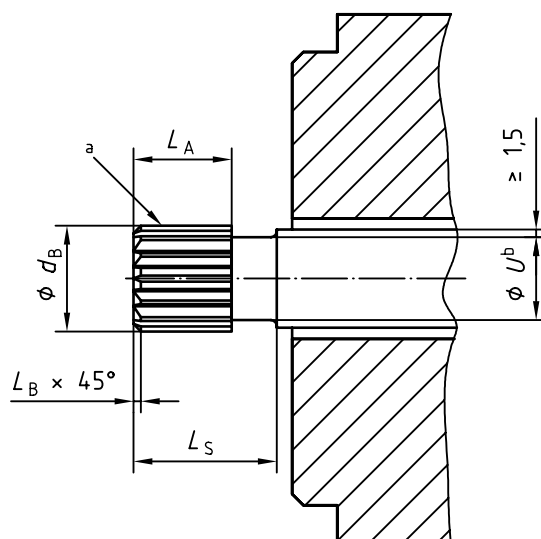
<i>D</i>	<i>L<sub>CT</sub></i>		<i>L<sub>ST</sub></i>		<i>L<sub>T</sub></i>	<i>C</i> + 0,13 - 0,08	<i>D<sub>T</sub><sup>a</sup></i>	<i>E</i> Key width h9	<i>Z</i>
	short	long	short	long					
10	—	20	—	15	8 <sup>b</sup>	1,6	M6 <sup>b</sup>	—	—
12	—	24,5	—	18	12 <sup>b</sup>	2	M8 × 1 <sup>b</sup>	2	0,8 <sup>+1</sup> <sub>0</sub>
16	24	36	16	28	12	2,5	M10 × 1,25	3	1,2 <sup>+1</sup> <sub>0</sub>
20	32	46	22	36	14	3,2	M12 × 1,25	4	1,5 <sup>+1</sup> <sub>0</sub>
25	37	55	24	42	18	4	M16 × 1,5	5	2 <sup>+2</sup> <sub>0</sub>
32	52	74	36	58	22	4	M20 × 1,5	6	2,5 <sup>+2</sup> <sub>0</sub>
40	73	101	54	82	28	5	M24 × 2	10	3 <sup>+2</sup> <sub>0</sub>
50	—	—	54	82	28	—	M36 × 3	12	3 <sup>+2</sup> <sub>0</sub>
63	—	—	70	105	35	—	M42 × 3	16	4 <sup>+2</sup> <sub>0</sub>
70	—	—	70	105	35	—	M48 × 3	18	4 <sup>+2</sup> <sub>0</sub>
80	—	—	90	130	40	—	M56 × 4	20	4,5 <sup>+2</sup> <sub>0</sub>
90	—	—	90	130	40	—	M64 × 4	22	5 <sup>+2</sup> <sub>0</sub>
110	—	—	120	165	45	—	M80 × 4	25	5 <sup>+2</sup> <sub>0</sub>
125	—	—	120	165	45	—	M90 × 4	28	6 <sup>+2</sup> <sub>0</sub>
140	—	—	150	200	50	—	M100 × 4	32	7 <sup>+3</sup> <sub>0</sub>
160	—	—	180	240	60	—	M125 × 4	36	8 <sup>+3</sup> <sub>0</sub>
180	—	—	180	240	60	—	M140 × 6	40	9 <sup>+3</sup> <sub>0</sub>
200	—	—	210	280	70	—	M160 × 6	40	9 <sup>+3</sup> <sub>0</sub>

NOTE For tolerance values, see ISO 286-2.

<sup>a</sup> Threads in accordance with ISO 261.

<sup>b</sup> For long version only.

Dimensions in millimetres



- a Spline.  
b See Table 3.

Figure 6 — Basic layout of metric involute spline shaft end

Table 9 — Dimensions of metric involute spline shaft ends

Dimensions in millimetres

$d_B$	$L_A$ min.	$L_B$	$L_S$
10	5	1	18
12	6		20
16	8	1,5	25
20	10		28
25	12,5		32
32	16	2	36
40	20		45
50	25		55
60	30		70
70	35	3	80
80	40		90
90	45		105
110	55		125
120	60		135
140	70	5	155
160	80		175
180	90		195
200	100		215

## Annex A (informative)

### Examples of methods of sealing between a mounting flange and its housing

In order to achieve a low-pressure, fluid-tight joint between the mounting flange and its housing, one of the following methods can be used.

- a) Introduction of a suitable gasket between the flange and housing.
- b) Introduction of an O-ring into a suitably machined annular recess in the housing. Spigot lengths allow for, at minimum, the following O-ring cross-selection diameters:
  - 2,65 mm for spigot diameters up to and including 100 mm;
  - 3,55 mm for spigot diameters above 100 mm and up to and including 200 mm.

It is envisaged that this form of sealing will not be required where the spigot diameter,  $A$ , exceeds 200 mm.

- c) Introduction of an O-ring in the annular triangular section formed by the flange face, spigot and a suitable chamfer, machined on the corner of the housing mounting face and spigot bore. In this case the O-ring dimensions and other details will be agreed between the supplier and purchaser.



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**ICS 23.100.10**

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