

**HTX**  
**PRODUCTS**

# HAMMER UNIONS












































































































## HTX PRODUCTS LLC

offers a comprehensive range of standard and sour gas Hammer Unions. Each union is thoroughly inspected to ensure long, dependable service in the most extreme conditions.

- Three lug nuts and self-locking ACME threads provide quick make-up and break-out.
- Color coded for quick identification.
- Unique identification for sour gas unions.
- Meet or exceed National Association of Corrosion Engineers standard NACE MR-01-75.
- Manufactured from quality steel meeting ASTM and/or AISI standards.
- All unions provide pressure-tight & positive sealing for low-pressure services (500 to 2,000 PSI).
- The spherical surface male sub and angular surface female sub form a metal-to-metal seal, the ball and tangent provides a perfect seal.
- Range from 1/2" to 12" with cold working pressures from 500 to 20,000 PSI.
- Fully interchangeable with most major brands of Hammer Unions.
- HTX Products are ISO 9001 certified.



# SPECIFICATIONS FOR THREADED AND BUTT WELD HAMMER UNIONS

Fig. No.	Assembly color code for standard service	Pressure Rating (PSI)				Nominal Pipe Sizes															
		Standard Service		Sour Gas Service		(in.)	1/2	1	1-1/4	1-1/2	2	2-1/2	3	4	5	6	8	10	12		
		Cold Working	Test	Cold Working	Test	(mm.)	13	25	32	38	50	65	80	100	125	150	200	250	300		
50		500	750	N/A	N/A																
100		1,000	1,500	N/A	N/A																
101		1,000	1,500	N/A	N/A																
200		2,000	3,000	2,000	3,000																
201		2,000	3,000	2,000	3,000																
206		2,000	3,000	2,000	3,000																
207		2,000	3,000	2,000	3,000																
211		2,000	3,000	N/A	N/A																
300		2,000	3,000	N/A	N/A																
400		4,000	6,000	4,000	6,000																
602		6,000	9,000	6,000	9,000																
1002		10,000	15,000	7,500	11,250																
1003		10,000	15,000	7,500	11,250																
1004		10,000	15,000	7,500	11,250																
1502		15,000	22,500	10,000	15,000																
2002		20,000	30,000	N/A	N/A																
2202		N/A	N/A	15,000	22,500																
6666		6,000	9,000	N/A	N/A																

\*Indicates different Cold Working Pressure due to other design factor - difference as shown below:

- 5", 6", 12" : Figure 400, Cold Working Pressure 2,500 PSI & Test Pressure 4,000 PSI
- 5", 6" : Figure 1002 Butt Weld, Cold Working Pressure 7,500 PSI & Test Pressure 11,250 PSI Std. Service
- 4", 5" : Figure 1003 Butt Weld, Cold Working Pressure 7,500 PSI & Test Pressure 11,250 PSI Std. Service
- 5", 6" : Figure 1002 Butt Weld, Cold Working Pressure 5,000 PSI & Test Pressure 7,500 PSI Sour Service
- 4", 5" : Figure 1003 Butt Weld, Cold Working Pressure 5,000 PSI & Test Pressure 7,500 PSI Sour Service
- 1/2" : Figure 300, Cold Working Pressure 15,000 PSI & Test Pressure 20,000 PSI, Zinc Plated





**FIG 50 UNION**  
Red Nut, Red Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
4	5.13	6.20	500	750	N/A	N/A	27.00
5	5.22	5.60	500	750	N/A	N/A	22.40

- These Hammer Unions are recommended for suction and low pressure lines
- Available in threaded and socket weld ends.



**FIG 100 UNION**  
Black Nut, Yellow Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
2	2.90	3.23	1,000	1,500	N/A	N/A	5.63
2-1/2	3.60	4.25	1,000	1,500	N/A	N/A	11.47
3	4.00	4.59	1,000	1,500	N/A	N/A	13.80
4	4.70	4.94	1,000	1,500	N/A	N/A	19.42
5	5.80	6.00	1,000	1,500	N/A	N/A	32.50
6	6.50	6.84	1,000	1,500	N/A	N/A	46.21
8	7.87	7.31	1,000	1,500	N/A	N/A	69.88

- These Hammer Unions are used in low pressure manifold lines and air, water, oil or gas applications.
- Available in both threaded and butt weld ends.
- Metal to metal sealing surface.



**FIG 101 UNION**  
Beige Nut, Yellow Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
5	5.52	8.05	1,000	1,500	N/A	N/A	33.00

- These Hammer Unions are used in low pressure manifold lines and air, water, oil or gas applications.
- Available in threaded ends.
- Subs with flat face.
- O-ring recommended for line connections where straight breakout of short pipe segment is required.



**FIG 200 UNION**  
Blue Nut, Grey Subs

## SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1	1.96	2.65	2,000	3,000	2,000	3,000	1.75
1-1/4	2.17	2.78	2,000	3,000	2,000	3,000	2.37
1-1/2	2.41	2.98	2,000	3,000	2,000	3,000	3.29
2	2.90	3.17	2,000	3,000	2,000	3,000	5.47
2-1/2	3.63	4.13	2,000	3,000	2,000	3,000	10.00
3	4.26	4.58	2,000	3,000	2,000	3,000	15.03
4	5.00	4.94	2,000	3,000	2,000	3,000	20.95
5	5.50	6.55	2,000	3,000	2,000	3,000	33.26
6	6.43	6.66	2,000	3,000	2,000	3,000	42.50
8	7.43	7.19	2,000	3,000	2,000	3,000	64.00
10	9.00	9.13	2,000	3,000	2,000	3,000	91.00

- These Hammer Unions are used in general service manifold lines and air, water, oil or gas applications.
- Available in both threaded and butt weld ends.
- Metal to metal sealing surface.

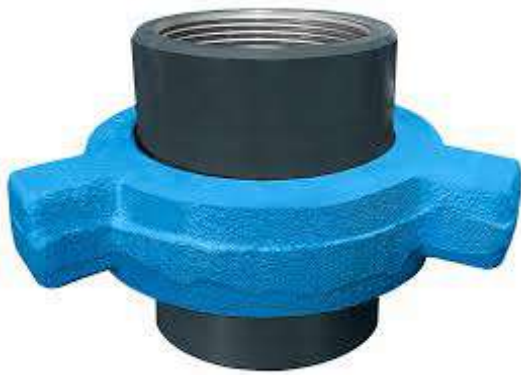


**FIG 201 UNION**  
Gold Nut, Grey Subs

## SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
2-1/2	4.69	6.06	2,000	3,000	2,000	3,000	19.45

- These Hammer Unions are used in air, water, oil or gas applications.
- Available in threaded ends.
- Subs with flat face.
- O-ring recommended for line connections where straight breakout of short pipe segments is required.



**FIG 206 UNION**  
Blue Nut, Grey Subs

## SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1	1.96	2.65	2,000	3,000	2,000	3,000	1.75
1-1/4	2.17	2.78	2,000	3,000	2,000	3,000	2.37
1-1/2	2.41	2.98	2,000	3,000	2,000	3,000	3.29
2	2.90	3.17	2,000	3,000	2,000	3,000	5.47
2-1/2	3.63	4.13	2,000	3,000	2,000	3,000	10.00
3	4.26	4.58	2,000	3,000	2,000	3,000	15.03
4	5.00	4.94	2,000	3,000	2,000	3,000	20.95
5	5.50	6.55	2,000	3,000	2,000	3,000	33.26
6	6.43	6.66	2,000	3,000	2,000	3,000	42.50
8	7.43	7.19	2,000	3,000	2,000	3,000	64.00
10	9.00	9.13	2,000	3,000	2,000	3,000	91.00

- These Hammer Unions are similar to Fig 200 with a secondary seal to supplement the metal to metal design.
- Recommended for use in corrosive environments.
- Available in both threaded and butt weld ends.



**FIG 207 UNION**  
Blue Nut, Gray Subs

## SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
3	2.75	3.87	2,000	3,000	2,000	3,000	9.80
4	3.59	4.38	2,000	3,000	2,000	3,000	16.25
6	4.92	5.60	2,000	3,000	2,000	3,000	45.88

- Fig. 207 Hammer Unions are fully interchangeable with figure 200 and 206 unions.
- Used to blank off the end of a line.
- O-ring is provided in blanking cap to ensure leak proof seal.
- Available in both threaded and butt weld ends.



**FIG 211 UNION**  
Gray Nut, Blue Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
2	3.03	3.45	2,000	3,000	N/A	N/A	6.60
3	4.27	4.55	2,000	3,000	N/A	N/A	14.08

- These Hammer Unions are used in production systems with electrolytic corrosive environments.
- No metal to metal contact between the subs.
- Laminated insulating rings provide 35 million Ohms resistance across the union. O-ring in male sub provides a positive primary seal.
- Resilient seal ring in female sub provides secondary protection from corrosion.
- Available in threaded ends.



**FIG 300 UNION**  
Gray Nut, Yellow Subs\*

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1/2	1.80	3.00	15,000	20,000	N/A	N/A	1.80
1	2.13	2.63	2,000	3,000	N/A	N/A	2.00
2	2.88	3.75	2,000	3,000	N/A	N/A	2.50

- These Hammer Unions have a flat face design which permits straight breakout for lateral removal of valves and other fittings for inspection or replacement.
- Available in threaded ends.
- \* 1/2" Fig 300 Hammer Unions are zinc plated and gray in color.



**FIG 400 UNION**  
Black Nut, Red Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
2	3.54	5.13	4,000	6,000	4,000	6,000	12.48
3	4.17	6.14	4,000	6,000	4,000	6,000	20.13
4	5.04	8.18	4,000	6,000	4,000	6,000	31.24
5	6.70	11.10	2,500	4,000	2,500	4,000	49.60
6	7.70	11.40	2,500	4,000	2,500	4,000	63.47
12	10.26	10.90	2,500	4,000	2,500	4,000	164.90

- These Hammer Unions are used in manifold & lines connections, pump suction and mud services.
- Available in both threaded and butt weld ends.
- 3" through 12" sizes have o-ring for primary seal.



**FIG 602 UNION**  
Black Nut, Orange Subs

## SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1	2.19	3.53	6,000	9,000	6,000	9,000	3.50
1-1/4	3.08	4.80	6,000	9,000	6,000	9,000	9.01
1-1/2	3.10	4.90	6,000	9,000	6,000	9,000	9.17
2	3.70	5.30	6,000	9,000	6,000	9,000	13.78
3	4.50	6.20	6,000	9,000	6,000	9,000	22.76
4	5.19	8.18	6,000	9,000	6,000	9,000	34.96

- These Hammer Unions are used in water, oil, gas and mud service.
- Replaceable, lip type rubber seal provides primary sealing.
- Available in both threaded and butt weld ends.



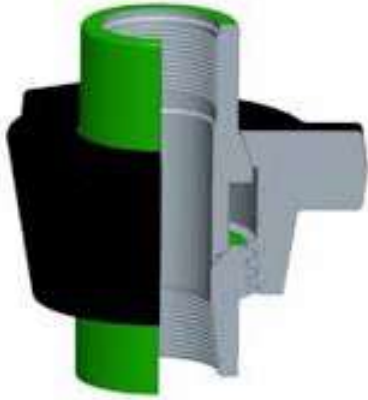
**FIG 1002 UNION**  
Red Nut, Blue Subs

## SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1	2.19	3.55	10,000	15,000	7,500	11,250	3.50
1-1/4	3.08	4.88	10,000	15,000	7,500	11,250	9.01
1-1/2	3.10	4.90	10,000	15,000	7,500	11,250	9.17
2	3.70	5.30	10,000	15,000	7,500	11,250	13.78
3	4.50	6.20	10,000	15,000	7,500	11,250	22.53
4	5.20	8.20	10,000	15,000	7,500	11,250	34.91
5	6.26	9.13	7,500	11,250	5,000	7,500	66.57
6	7.00	7.60	7,500	11,250	5,000	7,500	92.15

- These Hammer Unions are used in high pressure applications for choke and kill lines, cementing and acidizing. Replaceable, lip type rubber seal provides primary sealing up to 4".
- 5" and 6" sizes have o-ring for primary sealing.
- Available in both threaded and butt weld ends.
- 6" unions are only available in butt weld for sour service.





**FIG 1003 UNION**  
Black Nut, Green Subs

**SPECIFICATIONS**

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
3	4.80	8.87	10,000	15,000	7,500	11,250	47.50
4	6.00	10.90	7,500	11,250	5,000	7,500	78.15
5	6.00	10.90	7,500	11,250	5,000	7,500	79.62

- These Hammer Unions are used in air, water, oil, mud, gas service, high pressure manifold, drilling rig where alignment of piping components is a problem.
- Replaceable o-ring on male sub provides primary sealing.
- Available in threaded and butt weld ends.
- 5"unions are available in butt weld ends only.



**FIG 1004 UNION**  
Red Nut, Gray Subs

**SPECIFICATIONS**

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
5	6.00	8.25	10,000	15,000	7,500	11,250	85.00
6	7.25	9.38	10,000	15,000	7,500	11,250	140.00

- Available in threaded and butt weld ends.
- Face of male and female subs is perfectly square.
- Provided with lip type seal ring.



**FIG 1502 UNION**  
Blue Nut, Red Subs

**SPECIFICATIONS**

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1	2.19	4.38	15,000	22,500	10,000	15,000	9.12
1-1/2	3.50	4.50	15,000	22,500	10,000	15,000	16.30
2	4.00	7.00	15,000	22,500	10,000	15,000	20.11
3	4.88	7.64	15,000	22,500	10,000	15,000	34.10
4	6.02	8.57	15,000	22,500	10,000	15,000	72.68
5	6.53	9.00	15,000	22,500	10,000	15,000	95.00
6	7.20	9.75	15,000	22,500	10,000	15,000	145.00

- These Hammer Unions are use in cementing, acidizing, choke and kill lines.
- Replaceable lip type rubber seal.
- Available in both threaded and butt weld ends.



**FIG 2002 UNION**  
Green Nut, Gray Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
2	2.75	4.67	20,000	30,000	N/A	N/A	8.20
3	3.50	4.50	20,000	30,000	N/A	N/A	16.30

- Replaceable lip type rubber seal.
- Available in butt weld ends only.



**FIG 2202 UNION**  
Green Nut, Green Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
2	2.75	4.69	N/A	N/A	15,000	22,500	8.20
3	3.50	4.50	N/A	N/A	15,000	22,500	16.40
4	4.00	7.00	N/A	N/A	15,000	22,500	21.50

- These Hammer Unions are specially designed for sour gas service.
- Replaceable lip type rubber seal with stainless steel anti extrusion ring.
- Conform to NACE standard MR-01-75 and API-14E.
- Available in butt weld ends only.



**FIG 6666 UNION**  
Brown Nut, Silver Subs

### SPECIFICATIONS

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1-1/2	2.83	4.19	6,000	9,000	N/A	N/A	6.60
2	3.46	5.85	6,000	9,000	N/A	N/A	12.58

- Available in threaded ends only.



## **G-TYPE 10,000 PSI UNION**

**Green Nut, Silver Subs**

### **SPECIFICATIONS**

Size	Nut Radius	Lenght Total	Pressure Rating (PSI)				Weight (LBS)
			Standard Service		Sour Gas Service		
Inches	Inches	Inches	Cold Working	Test	Cold Working	Test	(Approx)
1-1/2	3	4.14	10,000	15,000	N/A	N/A	8.25

• Available in threaded ends only.

## **CONTACT US:**

333-A Northpark Central Drive  
Houston, TX 77073, USA  
(281) 571-7005  
sales@htxproducts.com

**HTXPRODUCTS.COM**

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