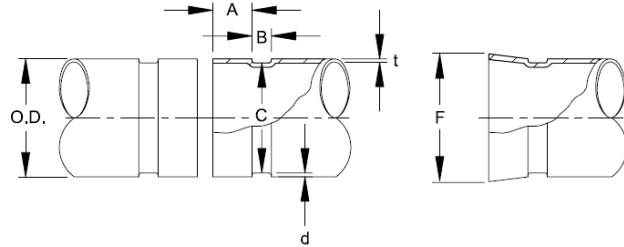


## Roll Grooving Dimensions for ANSI B36.10, BS 1387 (M) & AS 1074 (M) Pipe

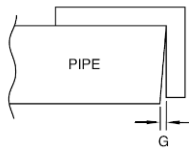
Basic roll groove dimensions conform to ANSI/AWWA C606-06 Table 5 with slightly adjusted tolerances to incorporate international standards including CSA B242, ISO/FDIS 6182-12, Vds 2100-6en and JPF MP-006.



Nominal Size	Pipe O.D.				A ±0.030 ±0.76	B ±0.030 ±0.76	C +0.000 +0.00	t Min. Wall	d Groove Depth (ref.)	F Max. Allowed Flare Dia.
	Basic		Tolerance							
	in	mm	in	mm						
¾	1.050	+0.010	-0.010	0.625	0.281	0.938-0.015	0.065	0.056	1.15	
20	26.7	+0.25	-0.25	15.88	7.14	23.83-0.38	1.65	1.42	29.21	
1	1.315	+0.013	-0.013	0.625	0.281	1.190-0.015	0.065	0.063	1.43	
25	33.4	+0.33	-0.33	15.88	7.14	30.23-0.38	1.65	1.60	36.30	
1¼	1.660	+0.016	-0.016	0.625	0.281	1.535-0.015	0.065	0.063	1.77	
32	42.2	+0.41	-0.41	15.88	7.14	38.99-0.38	1.65	1.60	44.96	
1½	1.900	+0.019	-0.019	0.625	0.281	1.775-0.015	0.065	0.063	2.01	
40	48.3	+0.48	-0.48	15.88	7.14	45.09-0.38	1.65	1.60	51.05	
2	2.375	+0.024	-0.024	0.625	0.344	2.250-0.015	0.065	0.063	2.48	
50	60.3	+0.61	-0.61	15.88	8.74	57.15-0.38	1.65	1.60	62.99	
2½	2.875	+0.029	-0.029	0.625	0.344	2.720-0.018	0.083	0.078	2.98	
65	73.0	+0.74	-0.74	15.88	8.74	69.09-0.46	2.11	1.98	75.69	
76	3.000	+0.030	-0.030	0.625	0.344	2.844-0.018	0.090	0.075	3.10	
	76.1	+0.76	-0.76	15.88	8.74	72.24-0.46	2.30	1.93	78.74	
3	3.500	+0.035	-0.031	0.625	0.344	3.344-0.018	0.083	0.078	3.60	
80	88.9	+0.89	-0.79	15.88	8.74	84.94-0.46	2.11	1.98	91.44	
101.6mm	4.000	+0.040	-0.031	0.625	0.344	3.834-0.020	0.083	0.083	4.10	
	101.6	+1.02	-0.79	15.88	8.74	97.38-0.51	2.11	2.11	104.10	
108.0mm	4.250	+0.042	-0.031	0.625	0.344	4.084-0.020	0.083	0.083	4.35	
	108.0	+1.07	-0.79	15.88	8.74	103.73-0.51	2.11	2.11	110.49	
4	4.500	+0.040	-0.031	0.625	0.344	4.334-0.020	0.083	0.083	4.60	
100	114.3	+1.02	-0.79	15.88	8.74	110.08-0.51	2.11	2.11	116.84	
133.0mm	5.250	+0.051	-0.031	0.625	0.344	5.084-0.020	0.109	0.083	5.35	
	133.0	+1.32	-0.79	15.88	8.74	129.13-0.51	2.77	2.11	135.89	
139.7mm	5.500	+0.050	-0.031	0.625	0.344	5.333-0.020	0.109	0.083	5.60	
	139.7	+1.40	-0.79	15.88	8.74	135.46-0.51	2.77	2.11	142.24	
5	5.563	+0.056	-0.031	0.625	0.344	5.395-0.022	0.109	0.083	5.66	
125	141.3	+1.42	-0.79	15.88	8.74	137.03-0.56	2.77	2.11	143.76	
159.0mm	6.250	+0.063	-0.031	0.625	0.344	6.084-0.030	0.109	0.083	6.35	
	159.0	+1.60	-0.79	15.88	8.74	154.53-0.76	2.77	2.11	161.29	
165.1mm	6.500	+0.063	-0.031	0.625	0.344	6.334-0.022	0.109	0.085	6.60	
	165.1	+1.60	-0.79	15.88	8.74	160.88-0.56	2.77	2.16	167.64	
6	6.625	+0.063	-0.031	0.625	0.344	6.455-0.022	0.109	0.085	6.73	
150	168.3	+1.60	-0.79	15.88	8.74	163.96-0.56	2.77	2.16	170.94	
216.3mm	8.516	+0.063	-0.031	0.750	0.469	8.331-0.025	0.109	0.092	8.69	
	216.3	+1.60	-0.79	19.05	11.91	211.61-0.64	2.77	2.34	220.73	
8	8.625	+0.063	-0.031	0.750	0.469	8.441-0.025	0.109	0.092	8.80	
200	219.1	+1.60	-0.79	19.05	11.91	214.40-0.64	2.77	2.34	223.52	
10	10.750	+0.063	-0.031	0.750	0.469	10.562-0.027	0.134	0.094	10.92	
250	273.0	+1.60	-0.79	19.05	11.91	268.27-0.69	3.40	2.39	277.37	
12	12.750	+0.063	-0.031	0.750	0.469	12.531-0.030	0.156	0.109	12.92	
300	323.9	+1.60	-0.79	19.05	11.91	318.29-0.76	3.96	2.77	328.17	
14	14.000	+0.063	-0.031	0.938	0.469	13.781-0.030	0.156	0.109	14.10	
350	355.6	+1.60	-0.79	23.83	11.91	350.04-0.76	3.96	2.77	358.14	
16	16.000	+0.063	-0.031	0.938	0.469	15.781-0.030	0.165	0.109	16.10	
400	406.4	+1.60	-0.79	23.83	11.91	400.84-0.76	4.19	2.77	408.94	
18	18.000	+0.063	-0.031	1.000	0.469	17.781-0.030	0.165	0.109	18.16	
450	457.2	+1.60	-0.79	25.40	11.91	451.64-0.76	4.19	2.77	461.26	
20	20.000	+0.063	-0.031	1.000	0.469	19.781-0.030	0.188	0.109	20.16	
500	508.0	+1.60	-0.79	25.40	11.91	502.44-0.76	4.78	2.77	512.06	

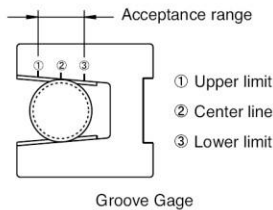
Nominal Size	Pipe O.D.			A	B	C	t	d	F
	Basic	Tolerance		$\pm 0.030$	$\pm 0.030$	$+0.000$	Min. Wall	Groove Depth (ref.)	Max. Allowed Flare Dia.
	in mm	in mm	in mm	$\pm 0.76$ mm	$\pm 0.76$ mm	$+0.00$ mm	in mm	in mm	in mm
22 550	22.000 558.8	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.469 11.91	21.656-0.030 550.06-0.76	0.188 4.78	0.172 4.37	22.20 563.88
24 600	24.000 609.6	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.500 12.70	23.656-0.030 600.86-0.76	0.218 5.54	0.172 4.37	24.20 614.68

- Pipe ends must be square cut. See above table for maximum allowable tolerances from square cut ends



Pipe Size	G (max)
~3 1/2"	0.030" (0.8mm)
4 ~ 6"	0.045" (1.2mm)
8" ~	0.060" (1.6mm)

- The gasket seating surface 'A' shall be free from deep scores, marks, or ridges that would prevent a positive seal.
- The 'C' dimensions are average values. The groove must be of uniform depth around the entire circumference. Use a **Shurjoint** groove gage or rule to check the groove diameter.
- The 't' is the minimum allowable wall thickness that may be roll-grooved.



- The 'd' is for reference use only. The groove depth shall be determined by the groove diameter 'C'.
- Flare Diameter: The pipe end that may flare when the groove is rolled shall be within this limit when measured at the extreme end of the pipe.

Note:

- Shurjoint** reserves the right to change specifications, designs and or standard equipment without notice and without incurring any obligations.