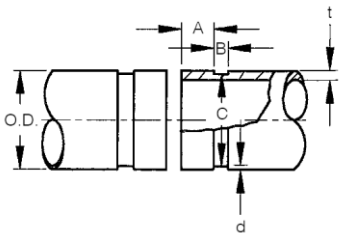
Cut Grooving Dimensions for IPS / BS / AS / ISO /JIS / KS PIPE



1	2			3	4	5	6	7
Nominal Size	Basic	Pipe O.D. Tolerance		A ±0.031 ±0.79	B ±0.031 ±0.79	C +0.000 +0.00	Min. Wall t	Groove Depth d (ref.)
in mm	in mm	in mm	in mm	in mm	in mm	in mm	in mm	in mm
¾ 20	1.050 26.7	+0.010 +0.25	-0.010 -0.25	0.625 15.88	0.313 7.95	0.938-0.015 23.83-0.38	0.113 2.87	0.056 1.42
1 25	1.315 33.4	+0.028 +0.71	-0.015 -0.38	0.625 15.88	0.313 7.95	1.190-0.015 30.23-0.38	0.133 3.38	0.063 1.60
1¼ 32	1.660 42.2	+0.029 +0.74	-0.016 -0.41	0.625 15.88	0.313 7.95	1.535-0.015 38.99-0.38	0.140 3.56	0.063 1.60
1½ 40	1.900 48.3	+0.019 +0.48	-0.019 -0.48	0.625 15.88	0.313 7.95	1.775-0.015 45.09-0.38	0.145 3.68	0.063 1.60
2 50	2.375 60.3	+0.024 +0.61	-0.024 -0.61	0.625 15.88	0.313 7.95	2.250-0.015 57.15-0.38	0.154 3.91	0.063 1.60
2½ 65	2.875 73.0	+0.029 +0.74	-0.029 -0.74	0.625 15.88	0.313 7.95	2.720-0.018 69.09-0.46	0.188 4.78	0.078 1.98
76.1 mm	3.000 76.1	+0.030 +0.76	-0.030 -0.76	0.625 15.88	0.313 7.95	2.845-0.018 72.26-0.46	0.188 4.78	0.076 1.93
3 80	3.500 88.9	+0.035 +0.89	-0.031 -0.79	0.625 15.88	0.313 7.95	3.344-0.018 84.94-0.46	0.188 4.78	0.078 1.98
101.6 mm	4.000 101.6	+0.040 +1.02	-0.031 -0.79	0.625 15.88	0.313 7.95	3.834-0.020 97.38-0.51	0.188 4.78	0.078 1.98
108.0 mm	4.250 108.0	+0.042 +1.07	-0.031 -0.79	0.625 15.88	0.375 9.53	4.084-0.020 103.73-0.51	0.203 5.16	0.083 2.11
4 100	4.500 114.3	+0.045 +1.14	-0.031 -0.79	0.625 15.88	0.375 9.53	4.334-0.020 110.08-0.51	0.203 5.16	0.083 2.11
133.0 mm	5.250 133.0	+0.052 +1.32	-0.031 -0.79	0.625 15.88	0.375 9.53	5.084-0.020 129.13-0.51	0.203 5.16	0.083 2.11
139.7 mm	5.500 139.7	+0.056 +1.42	-0.031 -0.79	0.625 15.88	0.375 9.53	5.334-0.022 135.48-0.56	0.203 5.16	0.083 2.11
5 125	5.563 141.3	+0.056 +1.42	-0.031 -0.79	0.625 15.88	0.375 9.53	5.395-0.022 137.03-0.56	0.203 5.16	0.084 2.13
159.0 mm	6.250 159.0	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.375 9.53	6.084-0.022 154.53-0.56	0.219 5.56	0.083 2.11
165.1 mm	6.500 165.1	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.375 9.53	6.330-0.022 160.78-0.56	0.219 5.56	0.085 2.16
6 150	6.625 168.3	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.375 9.53	6.455-0.022 163.96-0.56	0.219 5.56	0.085 2.16
8 200	8.625 219.1	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.438 11.13	8.441-0.025 214.40-0.64	0.238 6.05	0.092 2.34
10 250	10.750 273.0	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.500 12.70	10.562-0.027 268.27-0.69	0.250 6.35	0.094 2.39
12 300	12.750 323.9	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.500 12.70	12.531-0.030 318.29-0.76	0.279 7.09	0.109 2.77
200 JIS	8.516 216.3	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.438 11.13	8.331-0.022 211.61-0.56	0.238 6.05	0.092 2.34
250 JIS	10.528 267.4	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.500 12.70	10.339-0.027 262.60-0.69	0.250 6.35	0.094 2.39
300 JIS	12.539 318.5	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.500 12.70	12.319-0.030 312.90-0.76	0.279 7.09	0.109 2.77
14 350	14.000 355.6	+0.063 +1.60	-0.031 -0.79	0.938 23.83	0.500 12.70	13.781-0.030 350.04-0.76	0.281 7.14	0.109 2.77
16 400	16.000 406.4	+0.063 +1.60	-0.031 -0.79	0.938 23.83	0.500 12.70	15.781-0.030 400.84-0.76	0.312 7.92	0.109 2.77
18 450	18.000 457.2	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.500 12.70	17.781-0.030 451.64-0.76	0.312 7.92	0.109 2.77
20 500	20.000 508.0	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.500 12.70	19.781-0.030 502.44-0.76	0.312 7.92	0.109 2.77
22 550	22.000 558.8	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.563 14.30	21.656-0.030 550.06-0.76	0.375 9.53	0.172 4.37
24 600	24.000 609.6	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.562 14.27	23.656-0.030 600.86-0.76	0.375 9.53	0.172 4.37

Pipe O.D. (Column 2):
Maximum allowable tolerances from square of ends is 0.03” for sizes up to 3-1/2”; 0.045” for 4” thru 6”, and 0.060” for sizes 8” and above.

Gasket Seating Surface (Column 3):
The gasket seating surface shall be free from deep scores, marks, or ridges that would prevent a positive seal.

Groove Width (Column 4):
Groove width is to be measured between vertical flanks of the groove side walls.

Groove Diameter (Column 5):
The “C” diameters are average values. The groove must be of uniform depth around the entire pipe circumference.

Minimum Wall Thickness (Column 6):
The “t” is the minimum allowable wall thickness that may be cut-grooved.

Groove Depth (Column 7):
The “d” is for reference use only. The groove dimension shall be determined by the groove diameter “C”.

Note:

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