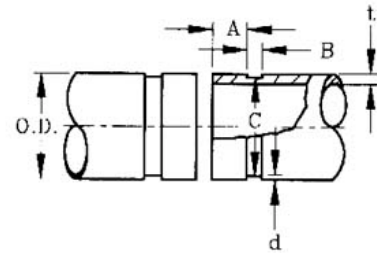


CUT GROOVE SPECIFICATIONS FOR LARGE DIAMETER IPS PIPE



1 Nominal Size	2 Pipe Outside Diameter				3 Gasket Seat A +0.03, -0.06 +0.8, -1.5	4 Groove Width B ±0.03 ±0.76	5 Groove Dia. C +0.00 +0.000	6 Groove Depth d (ref)	7 Min. Allow Wall thickness t
	Basic	Tolerances							
in mm	in mm	in mm	in mm	in mm	in mm	in mm	in mm	in mm	
26 650	26.0 660.4	-0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	25.5 -0.063 647.7 -1.60	0.25 6.35	0.625 15.88	
28 700	28.0 711.2	-0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	27.50 -0.063 698.5 -1.60	0.25 6.35	0.625 15.88	
30 750	30.0 762.0	-0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	29.5 -0.063 749.3 -1.60	0.25 6.35	0.625 15.88	
32 800	32.0 812.8	-0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	31.50 -0.063 800.10 -1.60	0.25 6.35	0.625 15.88	
34 850	34.0 863.6	-0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	33.50 -0.063 850.9 -1.60	0.25 6.35	0.625 15.88	
36 900	36.0 914.4	-0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	35.50 -0.063 901.70 -1.60	0.25 6.35	0.625 15.88	
40 1000	40.0 1016.0	-0.093 +2.36	-0.031 -0.79	2.00 50.8	0.625 15.9	39.50 -0.063 1003.30 -1.60	0.25 6.35	0.625 15.88	
42 1050	42.0 1066.8	-0.093 +2.36	-0.031 -0.79	2.00 50.8	0.625 15.9	41.50 -0.063 1054.10 -1.60	0.25 6.35	0.625 15.88	

Nominal Pipe Size (Column 1):

Nominal pipe size, IPS pipe to ANSI B36.10 and ISO 4200.

Pipe O.D. (Column 2):

Maximum allowable tolerances from square of ends is 0.060".

Gasket Seating Surface (Column 3):

The gasket seating surface shall be free from deep scores, marks, or ridges that could 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.

Groove Depth (Column 6):

The "d" is for reference use only. The groove dimension shall be determined by the groove diameter "C".

Minimum Wall Thickness (Column 7):

The "t" is the minimum allowable wall thickness that may be roll-grooved.

Note:

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