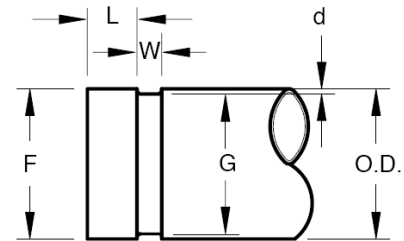


Roll Grooving Dimensions for KS D3507 & JIS G3452 Carbon Steel Pipe



$$C = \pi G$$

Nominal size		Pipe O.D.	Gasket Seat L +0.76*	Groove Width W +0.76*	Groove Dia. G		Groove Circumference C	Groove Depth d (ref)	Max. Flare Dia. F
A	B				Basic	Tolerance +0.00*			
mm	in	mm	mm	mm	mm	mm	mm	mm	
25A	1	34.0	16.0	7.1	30.4	-0.38	95.5 0 -3.1	1.80	35.5
32A	1¼	42.7	16.0	7.1	39.1	-0.38	122.8 0 -3.1	1.80	44.2
40A	1½	48.6	16.0	7.1	45.0	-0.38	141.4 0 -3.1	1.80	50.1
50A	2	60.5	16.0	8.7	56.9	-0.38	178.8 0 -3.1	1.80	62.0
65A	2½	76.3	16.0	8.7	72.2	-0.46	226.8 0 -3.1	2.05	77.8
80A	3	89.1	16.0	8.7	84.9	-0.46	266.7 0 -3.1	2.10	90.6
100A	4	114.3	16.0	8.7	110.1	-0.51	345.9 0 -3.1	2.10	116.8
125A	5	139.8	16.0	8.7	135.5	-0.56	425.7 0 -3.1	2.15	142.3
150A	6	165.2	16.0	8.7	160.8	-0.56	505.2 0 -3.1	2.20	167.7
200A	8	216.3	19.0	11.9	211.6	-0.64	664.8 0 -3.1	2.35	219.8
250A	10	267.4	19.0	11.9	262.6	-0.69	825.0 0 -3.1	2.40	270.9
300A	12	318.5	19.0	11.9	312.9	-0.76	983.0 0 -3.1	2.80	322.0

Groove Diameter:

Groove diameter "G" are only applicable to pipe sizes 150A or smaller. Grooves for 200A thru 300A are to be determined by the groove circumference.

Groove Depth:

The "d" is for reference use only.

Flare Diameter:

The maximum flare diameters (F) are target values.

* The tolerance for the JIS & KS pipe has a little difference.

Note:

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