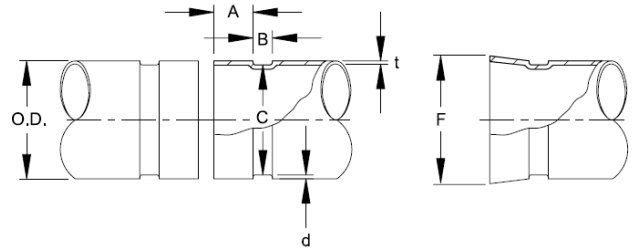


STANDARD ROLL GROOVE FOR LARGE DIAMETER IPS PIPE



1	2		3		4	5	6	7	8
Nominal Size	Pipe Outside Diameter		A		B	C	Groove Depth (ref)	Min. Allow Wall thick	Max. Allowed Flare Dia.
	Basic	Tolerance						t	
in	in	in	in	in	in	in	in	in	in
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
26	26.0	+0.093	-0.031	1.75	0.625	25.5	0.25	0.25	26.2
650	660.4	+2.36	-0.79	44.5	15.9	647.7	6.4	6.4	665.5
28	28.0	+0.093	-0.031	1.75	0.625	27.5	0.25	0.25	28.2
700	711.2	+2.36	-0.79	44.5	15.9	698.5	6.4	6.4	716.3
30	30.0	+0.093	-0.031	1.75	0.625	29.5	0.25	0.25	30.2
750	762.0	+2.36	-0.79	44.5	15.9	749.3	6.4	6.4	767.1
32	32.0	+0.093	-0.031	1.75	0.625	31.5	0.25	0.25	32.2
800	812.8	+2.36	-0.79	44.5	15.9	800.1	6.4	6.4	817.9
36	36.0	+0.093	-0.031	1.75	0.625	35.5	0.25	0.25	36.2
900	914.4	+2.36	-0.79	44.5	15.9	901.7	6.4	6.4	919.5
40	40.0	+0.093	-0.031	2.00	0.625	39.5	0.25	0.25	40.4
1000	1016.0	+2.36	-0.79	50.8	15.9	1003.3	6.4	6.4	1026.2
42	42.0	+0.093	-0.031	2.00	0.625	41.5	0.25	0.25	42.2
1050	1066.8	+2.36	-0.79	50.8	15.9	1054.1	6.4	6.4	1071.9

Nominal Pipe Size (Column 1):

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

Pipe OD (Column 2):

Maximum allowable tolerances from square cut are 0.060" (1.6mm).

Gasket Seating Surface (Column 3):

The gasket seating surface 'A' 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' dimensions are average values. The groove must be of uniform depth around the entire circumference. Use a *Shurjoint* groove or rule to check the groove diameter.

Groove Depth (Column 6):

The 'd' is for reference use only. The groove depth 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.

Flare Diameter (Column 8):

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.