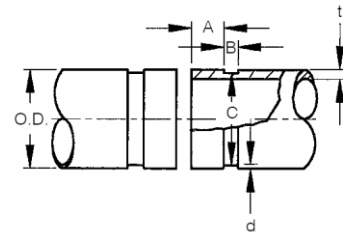


Cut Grooving Dimensions for IPS / BS / AS / ISO / JIS / KS PIPE



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