

CUT GROOVE SPECIFICATIONS

GROOVJOINT STANDARD CUT GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE

-1- Nominal IPS Pipe Size	-2- O.D.			-3- Gasket Seat "A" ±0.030/ ±0.76	-4- Groove Width "B" ±0.030/ ±0.76	-5- Groove Diameter "C"		-6- Actual Groove Depth "D" (Ref. Only)	-7- Min. Allow. Wall Thick. "T"
	Actual	Tolerance				Actual	Tol. +0.000		
		In./mm	+In./mm						
1	1.315	+0.028	-0.015	0.625	0.312	1.190	-0.015	0.062	0.133
25	33.4	+0.71	-0.38	15.88	7.92	30.23	-0.38	1.6	3.4
1-1/4	1.660	+0.029	-0.016	0.625	0.312	1.535	-0.015	0.062	0.140
32	42.2	+0.74	-0.41	15.88	7.92	38.99	-0.38	1.6	3.6
1-1/2	1.900	+0.019	-0.019	0.625	0.312	1.775	-0.015	0.062	0.145
40	48.3	+0.48	-0.48	15.88	7.92	45.09	-0.38	1.6	3.7
2	2.375	+0.024	-0.024	0.625	0.312	2.250	-0.015	0.062	0.154
50	60.3	+0.61	-0.61	15.88	7.92	57.15	-0.38	1.6	3.9
2-1/2	2.875	+0.029	-0.029	0.625	0.312	2.720	-0.018	0.078	0.187
65	73.0	+0.74	-0.74	15.88	7.92	69.09	-0.46	2.0	4.8
3	3.500	+0.035	-0.031	0.625	0.312	3.344	-0.018	0.078	0.188
80	88.9	+0.89	-0.79	15.88	7.92	84.94	-0.46	2.0	4.8
3-1/2	4.000	+0.040	-0.031	0.625	0.312	3.834	-0.020	0.083	0.188
90	101.6	+1.02	-0.79	15.88	7.92	97.38	-0.51	2.1	4.8
4	4.500	+0.045	-0.031	0.625	0.375	4.334	-0.020	0.083	0.203
100	114.3	+1.14	-0.79	15.88	9.53	110.08	-0.51	2.1	5.2
5	5.563	+0.056	-0.031	0.625	0.375	5.395	-0.022	0.084	0.203
125	141.3	+1.42	-0.79	15.88	9.53	137.03	-0.56	2.1	5.2
6	6.625	+0.063	-0.031	0.625	0.375	6.455	-0.022	0.085	0.219
150	168.3	+1.60	-0.79	15.88	9.53	163.96	-0.56	2.2	5.6
8	8.625	+0.063	-0.031	0.750	0.437	8.441	-0.025	0.092	0.238
200	219.1	+1.60	-0.79	19.05	11.10	214.40	-0.64	2.3	6.1
10	10.750	+0.063	-0.031	0.750	0.500	10.562	-0.027	0.094	0.250
250	273.1	+1.60	-0.79	19.05	12.70	268.27	-0.69	2.4	6.4
12	12.750	+0.063	-0.031	0.750	0.500	12.531	-0.030	0.109	0.279
300	323.9	+1.60	-0.79	19.05	12.70	318.29	-0.76	2.8	7.1
14 O.D.	14.000	+0.063	-0.031	0.938	0.500	13.781	-0.030	0.109	0.281
355.6	355.6	+1.60	-0.79	23.83	12.70	350.04	-0.76	2.8	7.1
16 O.D.	16.000	+0.063	-0.031	0.938	0.500	15.781	-0.030	0.109	0.312
406.4	406.4	+1.60	-0.79	23.83	12.70	400.84	-0.76	2.8	7.9
18 O.D.	18.000	+0.063	-0.031	1.000	0.500	17.781	-0.030	0.109	0.312
457.2	457.2	+1.60	-0.79	25.40	12.70	451.64	-0.76	2.8	7.9
20 O.D.	20.000	+0.063	-0.031	1.000	0.500	19.781	-0.030	0.109	0.312
508.0	508.0	+1.60	-0.79	25.40	12.70	502.44	-0.76	2.8	7.9
24 O.D.	24.000	+0.063	-0.031	1.000	0.563	23.656	-0.030	0.172	0.375
609.6	609.6	+1.60	-0.79	25.40	14.30	600.86	-0.76	4.4	9.5
28 I.D.	28.875	+0.063	-0.031	1.000	0.563	28.531	-0.030	0.172	0.437
733.4	733.4	+1.60	-0.79	25.40	14.30	724.69	-0.76	4.4	11.1
30 I.D.	31.000	+0.063	-0.031	1.250	0.625	30.594	-0.030	0.203	0.500
787.4	787.4	+1.60	-0.79	31.75	15.88	777.09	-0.76	5.2	12.7
30 O.D.	30.000	0.093	0.031	1.750▼	0.625	29.500	0.063	0.250	0.625
762.0	762.0	2.36	0.79	44.45	15.88	749.30	1.60	6.35	15.88

