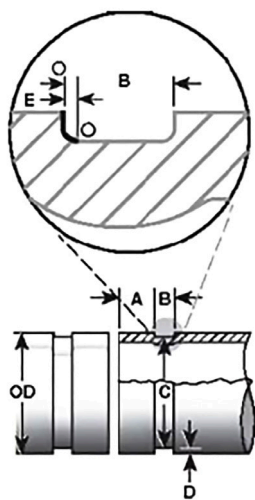


STANDARD ROLL GROOVE SPECIFICATIONS FOR ROLL GROOVED STEEL PIPE SYSTEM

1		2		3		4		5		6		7		8	
Dimensions (mm)															
Outside Diameter			Gasket seat A $\pm 0,76$	Groove width B $\pm 0,76$	Groove Diameter C		Groove Depth D (ref.)	Groove Corner E (max.)	Pipe Wall Thickness (min.)	Flare Diameter (max.)					
Basic	Tolerance				Basic	Tolerance									
	+	-													
33,7	0,33	0,33	15,88	7,14	30,23	-0,38	1,6	2	1,65	36,3					
42,4	0,41	0,41	15,88	7,14	38,99	-0,38	1,6	2	1,65	45					
48,3	0,48	0,48	15,88	7,14	45,09	-0,38	1,6	2	1,65	51,1					
60,3	0,61	0,61	15,88	8,74	57,15	-0,38	1,6	2	1,65	63					
76,1	0,76	0,76	15,88	8,74	72,26	-0,46	1,98	2	2,11	78,7					
88,9	0,89	0,79	15,88	8,74	84,94	-0,46	1,98	2	2,11	91,4					
114,3	1,14	0,79	15,88	8,74	110,08	-0,51	2,11	2	2,11	116,8					
139,7	1,42	0,79	15,88	8,74	135,48	-0,51	2,11	2	2,77	142,2					
165,1	1,6	0,79	15,88	8,74	160,78	-0,56	2,16	2	2,77	167,6					
168,3	1,6	0,79	15,88	8,74	163,96	-0,56	2,16	2	2,77	170,9					
219,1	1,6	0,79	19,05	11,91	214,4	-0,64	2,34	1,5	2,77	223,5					
273	1,6	0,79	19,05	11,91	268,28	-0,69	2,39	1,5	3,4	277,4					
323,9	1,6	0,79	19,05	11,91	318,29	-0,76	2,77	1,5	3,96	328,2					



- **COLUMN 1:** Outside diameter of the pipe. The outside diameter of roll grooved pipe will not be above, or below, the listed tolerances.
- **COLUMN 2:** Gasket seat. The surface of the pipe will be free of indentations, roll marks, and projections from the end of the pipe to the groove, to provide a leak-tight seal to the joint. All the chipped paint, dirt, grease, and rust must be removed. The gasket seat 'A' is measured from the end of the pipe.
- **COLUMN 3:** Groove width. The surface of the groove will be free of dirt and rust that could interfere with the montage of the grooved accessory. The corners of the groove must be radiused.
- **COLUMN 4:** Outside Diameter of the groove. The groove will be of uniform depth for the entire pipe circumference. The groove must be inside the tolerance of the diameter of the list.
- **COLUMN 5:** Groove Depth. For reference only, the groove depth must be the one that accomplishes the groove diameter listed in the column 4.
- **COLUMN 6:** Groove Corner. It is the distance between points (o) of the picture. The dimension 'E' starts in the reduction of the outside diameter of the pipe and ends in the bottom of the groove.
- **COLUMN 7:** Minimum allowable wall thickness. This is the minimum pipe wall thickness which may be roll grooved.
- **COLUMN 8:** Maximum allowable flare diameter. Diameter is measured at the grooved end pipe.