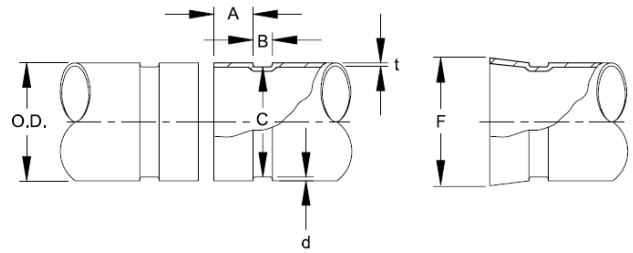


STANDARD ROLL GROOVE FOR LARGE DIAMETER IPS PIPE



1	2		3		4	5	6	7	8
Nominal Size	Pipe Outside Diameter		A		B	C	Groove Depth (ref)	t	Max. Allowed Flare Dia.
	Basic	Tolerance	± 0.03		± 0.03	$+0, -0.063$		Min. Allow Wall thick	
in	in	in	in	in	in	in	in	in	in
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
26 650	26.0 660.4	+0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	25.5 647.7	0.25 6.4	0.25 6.4	26.2 665.5
28 700	28.0 711.2	+0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	27.5 698.5	0.25 6.4	0.25 6.4	28.2 716.3
30 750	30.0 762.0	+0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	29.5 749.3	0.25 6.4	0.25 6.4	30.2 767.1
32 800	32.0 812.8	+0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	31.5 800.1	0.25 6.4	0.25 6.4	32.2 817.9
36 900	36.0 914.4	+0.093 +2.36	-0.031 -0.79	1.75 44.5	0.625 15.9	35.5 901.7	0.25 6.4	0.25 6.4	36.2 919.5
40 1000	40.0 1016.0	+0.093 +2.36	-0.031 -0.79	2.00 50.8	0.625 15.9	39.5 1003.3	0.25 6.4	0.25 6.4	40.4 1026.2
42 1050	42.0 1066.8	+0.093 +2.36	-0.031 -0.79	2.00 50.8	0.625 15.9	41.5 1054.1	0.25 6.4	0.25 6.4	42.2 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.