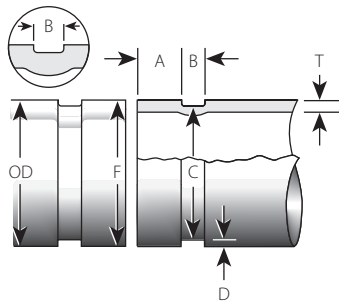


Original Groove System (OGS) Groove Specifications

1.0 DIMENSIONS

STANDARD ROLL GROOVE SPECIFICATIONS FOR STEEL AND OTHER IPS PIPE



Exaggerated for Clarity

Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵	Min Allow. Wall Thk. "T" ⁶	Max Allow. Flare Dia. "F" ⁷
	Actual	Tolerance				Actual	Tol. (+0.00)			
inches DN	inches mm	+ inches mm	- inches mm	±0.03 inches ±0.76 mm	±0.03 inches ±0.76 mm	inches mm	inches mm	inches mm	inches mm	inches mm
¾ DN20	1.050 26.9	0.010 0.25	0.010 0.25	0.625 15.88	0.281 7.14	0.938 23.83	-0.015 -0.38	0.056 1.42	0.065 1.65	1.15 29.2
1 DN25	1.315 33.7	0.013 0.33	0.013 0.33	0.625 15.88	0.281 7.14	1.190 30.23	-0.015 -0.38	0.063 1.60	0.065 1.65	1.43 36.3
1¼ DN32	1.660 42.4	0.016 0.41	0.016 0.41	0.625 15.88	0.281 7.14	1.535 38.99	-0.015 -0.38	0.063 1.60	0.065 1.65	1.77 45.0
1½ DN40	1.900 48.3	0.019 0.48	0.019 0.48	0.625 15.88	0.281 7.14	1.775 45.09	-0.015 -0.38	0.063 1.60	0.065 1.65	2.01 51.1
2 DN50	2.375 60.3	0.024 0.61	0.024 0.61	0.625 15.88	0.344 8.74	2.250 57.15	-0.015 -0.38	0.063 1.60	0.065 1.65	2.48 63.0
2½	2.875 73.0	0.029 0.74	0.029 0.74	0.625 15.88	0.344 8.74	2.720 69.09	-0.018 -0.46	0.078 1.98	0.083 2.11	2.98 75.7
DN65	3.000 76.1	0.030 0.76	0.030 0.76	0.625 15.88	0.344 8.74	2.845 72.26	-0.018 -0.46	0.078 1.98	0.083 2.11	3.10 78.7
3 DN80	3.500 88.9	0.035 0.89	0.031 0.79	0.625 15.88	0.344 8.74	3.344 84.94	-0.018 -0.46	0.078 1.98	0.083 2.11	3.60 91.4
3½ DN90	4.000 101.6	0.040 1.02	0.031 0.79	0.625 15.88	0.344 8.74	3.834 97.38	-0.020 -0.51	0.083 2.11	0.083 2.11	4.10 104.1

- 1 Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- 2 Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.
- 3 Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.
- 4 Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.
- 5 Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.
- 6 Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be grooved.
- 7 Maximum allowable pipe end flare diameter "F": Measured at the most extreme pipe end diameter square cut or beveled.

NOTES

- Roll grooving removes no metal, cold forming a groove by the action of an outer grooving roll being forced into pipe as it is rotated by an inner support roll.
- Roll groove configuration has rounded edges which reduce the available pipe end movement (expansion, contraction and deflection).
- The coating thickness applied to the gasket seating surface and within the groove on the pipe exterior should not exceed 0.010"/0.25 mm. Also, coatings applied to the interior surfaces, including bolt pad mating surfaces, of our grooved and bolted plain end couplings should not exceed 0.010"/0.25 mm.
- On roll grooved pipe, Allowable Pipe End Separation and Deflection from Centerline will be ½ values listed for cut grooved pipe.

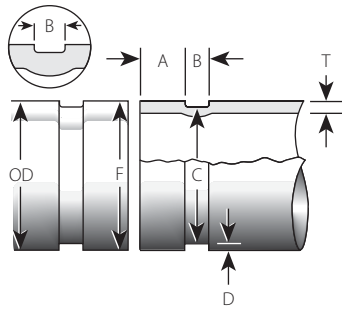
ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.

System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	

1.0 DIMENSIONS (CONTINUED)

STANDARD ROLL GROOVE SPECIFICATIONS FOR STEEL AND OTHER IPS PIPE



Exaggerated for Clarity

Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵	Min Allow. Wall Thk. "T" ⁶	Max Allow. Flare Dia. "F" ⁷
	Actual	Tolerance				Actual	Tol. (+0.00)			
inches DN	inches mm	+ inches mm	- inches mm	±0.03 inches ±0.76 mm	±0.03 inches ±0.76 mm	inches mm	inches mm	inches mm	inches mm	inches mm
4 DN100	4.500 114.3	0.045 1.14	0.031 0.79	0.625 15.88	0.344 8.74	4.334 110.08	-0.020 -0.51	0.083 2.11	0.083 2.11	4.60 116.8
	4.250 108.0	0.043 1.09	0.031 0.79	0.625 15.88	0.344 8.74	4.084 103.73	-0.020 -0.51	0.083 2.11	0.083 2.11	4.35 110.5
4½	5.000 127.0	0.050 1.27	0.031 0.79	0.625 15.88	0.344 8.74	4.834 122.78	-0.020 -0.51	0.083 2.11	0.095 2.41	5.10 129.5
	5.250 133.0	0.053 1.35	0.031 0.79	0.625 15.88	0.344 8.74	5.084 129.13	-0.020 -0.51	0.083 2.11	0.109 2.77	5.35 135.9
DN125	5.500 139.7	0.056 1.42	0.031 0.79	0.625 15.88	0.344 8.74	5.334 135.48	-0.020 -0.51	0.083 2.11	0.109 2.77	5.60 142.2
	5.563 141.3	0.056 1.42	0.031 0.79	0.625 15.88	0.344 8.74	5.395 137.03	-0.022 -0.56	0.084 2.13	0.109 2.77	5.66 143.8
5	6.000 152.4	0.056 1.42	0.031 0.79	0.625 15.88	0.344 8.74	5.830 148.08	-0.022 -0.56	0.085 2.16	0.109 2.77	6.10 154.9
	6.250 159.0	0.063 1.60	0.031 0.79	0.625 15.88	0.344 8.74	6.032 153.21	-0.030 -0.76	0.109 2.77	0.109 2.77	6.35 161.3

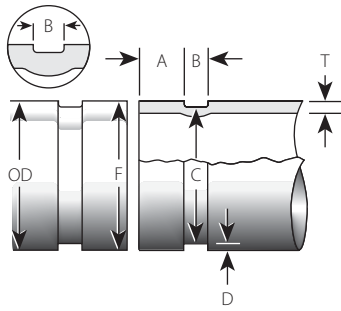
- ¹ Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- ² Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.
- ³ Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.
- ⁴ Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.
- ⁵ Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.
- ⁶ Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be grooved.
- ⁷ Maximum allowable pipe end flare diameter "F": Measured at the most extreme pipe end diameter square cut or beveled.

NOTES

- Roll grooving removes no metal, cold forming a groove by the action of an outer grooving roll being forced into pipe as it is rotated by an inner support roll.
- Roll groove configuration has rounded edges which reduce the available pipe end movement (expansion, contraction and deflection).
- The coating thickness applied to the gasket seating surface and within the groove on the pipe exterior should not exceed 0.010"/0.25 mm. Also, coatings applied to the interior surfaces, including bolt pad mating surfaces, of our grooved and bolted plain end couplings should not exceed 0.010"/0.25 mm.
- On roll grooved pipe, Allowable Pipe End Separation and Deflection from Centerline will be ½ values listed for cut grooved pipe.

1.0 DIMENSIONS (CONTINUED)

STANDARD ROLL GROOVE SPECIFICATIONS FOR STEEL AND OTHER IPS PIPE



Exaggerated for Clarity

Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵	Min Allow. Wall Thk. "T" ⁶	Max Allow. Flare Dia. "F" ⁷
	Actual	Tolerance				Actual	Tol. (+0.00)			
inches DN	inches mm	+ inches mm	- inches mm	±0.03 inches ±0.76 mm	±0.03 inches ±0.76 mm	inches mm	inches mm	inches mm	inches mm	inches mm
6 DN150	6.500 165.1	0.063 1.60	0.031 0.79	0.625 15.88	0.344 8.74	6.330 160.78	-0.022 -0.56	0.085 2.16	0.109 2.77	6.60 167.6
	6.625 168.3	0.063 1.60	0.031 0.79	0.625 15.88	0.344 8.74	6.455 163.96	-0.022 -0.56	0.085 2.16	0.109 2.77	6.73 170.9
8 DN200	8.000 203.2	0.063 1.60	0.031 0.79	0.750 19.05	0.469 11.91	7.816 198.53	-0.025 -0.64	0.092 2.34	0.109 2.77	8.17 207.5
	8.625 219.1	0.063 1.60	0.031 0.79	0.750 19.05	0.469 11.91	8.441 214.40	-0.025 -0.64	0.092 2.34	0.109 2.77	8.80 223.5
10 DN250	10.000 254.0	0.063 1.60	0.031 0.79	0.750 19.05	0.469 11.91	9.812 249.23	-0.027 -0.69	0.094 2.39	0.134 3.40	10.17 258.3
	10.750 273.0	0.063 1.60	0.031 0.79	0.750 19.05	0.469 11.91	10.562 268.28	-0.027 -0.69	0.094 2.39	0.134 3.40	10.92 277.4
12 DN300	12.000 304.8	0.063 1.60	0.031 0.79	0.750 19.05	0.469 11.91	11.781 299.24	-0.030 -0.76	0.109 2.77	0.156 3.96	12.17 309.1
	12.750 323.9	0.063 1.60	0.031 0.79	0.750 19.05	0.469 11.91	12.531 318.29	-0.030 -0.76	0.109 2.77	0.156 3.96	12.92 328.2
14	14.842 377.0	0.093 2.36	0.031 0.79	0.938 23.83	0.469 11.91	14.611 371.1	-0.030 -0.76	0.116 2.94	0.177 4.50	15.00 381.00
	16.772 426.0	0.093 2.36	0.031 0.79	0.938 23.83	0.469 11.91	16.514 419.5	-0.035 -0.89	0.129 3.28	0.177 4.50	16.93 430.00
16	18.898 480.0	0.093 2.36	0.031 0.79	1.000 25.40	0.469 11.91	18.626 473.1	-0.035 -0.89	0.136 3.45	0.236 5.99	19.06 484.1
	20.866 530.0	0.093 2.36	0.031 0.79	1.000 25.40	0.469 11.91	20.572 522.5	-0.035 -0.89	0.147 3.73	0.236 5.99	21.03 534.2
20	24.803 630.0	0.093 2.36	0.031 0.79	1.000 25.40	0.500 12.70	24.459 621.3	-0.035 -0.89	0.172 4.37	0.276 7.01	25.00 635.00

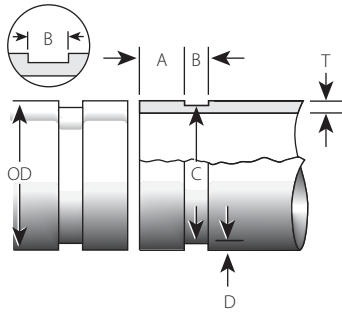
- 1 Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- 2 Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.
- 3 Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.
- 4 Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.
- 5 Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.
- 6 Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be grooved.
- 7 Maximum allowable pipe end flare diameter "F": Measured at the most extreme pipe end diameter square cut or beveled.

NOTES

- Roll grooving removes no metal, cold forming a groove by the action of an outer grooving roll being forced into pipe as it is rotated by an inner support roll.
- Roll groove configuration has rounded edges which reduce the available pipe end movement (expansion, contraction and deflection).
- The coating thickness applied to the gasket seating surface and within the groove on the pipe exterior should not exceed 0.010"/0.25 mm. Also, coatings applied to the interior surfaces, including bolt pad mating surfaces, of our grooved and bolted plain end couplings should not exceed 0.010"/0.25 mm.
- On roll grooved pipe, Allowable Pipe End Separation and Deflection from Centerline will be ½ values listed for cut grooved pipe.

1.0 DIMENSIONS (CONTINUED)

STANDARD CUT GROOVE SPECIFICATIONS FOR STEEL AND OTHER IPS PIPE



Exaggerated for Clarity

Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵	Min Allow. Wall Thk. "T" ⁶
	Actual	Tolerance				Actual	Tol. (+0.00)		
		inches	+	-	inches			inches	
inches	inches	inches	inches	±0.03 inches	±0.03 inches	inches	inches	inches	inches
DN	mm	mm	mm	±0.76 mm	±0.76 mm	mm	mm	mm	mm
3/4 DN20	1.050 26.9	0.010 0.25	0.010 0.25	0.625 15.88	0.313 7.95	0.938 23.83	-0.015 -0.38	0.056 1.42	0.113 2.87
1 DN25	1.315 33.7	0.013 0.33	0.013 0.33	0.625 15.88	0.313 7.95	1.190 30.23	-0.015 -0.38	0.063 1.60	0.133 3.38
1 1/4 DN32	1.660 42.4	0.016 0.41	0.016 0.41	0.625 15.88	0.313 7.95	1.535 38.99	-0.015 -0.38	0.063 1.60	0.140 3.56
1 1/2 DN40	1.900 48.3	0.019 0.48	0.019 0.48	0.625 15.88	0.313 7.95	1.775 45.09	-0.015 -0.38	0.063 1.60	0.145 3.68
2 DN50	2.375 60.3	0.024 0.61	0.024 0.61	0.625 15.88	0.313 7.95	2.250 57.15	-0.015 -0.38	0.063 1.60	0.154 3.91
2 1/2	2.875 73.0	0.029 0.74	0.029 0.74	0.625 15.88	0.313 7.95	2.720 69.09	-0.018 -0.46	0.078 1.98	0.188 4.78
DN65	3.000 76.1	0.030 0.76	0.030 0.76	0.625 15.88	0.313 7.95	2.845 72.26	-0.018 -0.46	0.078 1.98	0.188 4.78
3 DN80	3.500 88.9	0.035 0.89	0.031 0.79	0.625 15.88	0.313 7.95	3.344 84.94	-0.018 -0.46	0.078 1.98	0.188 4.78
3 1/2 DN90	4.000 101.6	0.040 1.02	0.031 0.79	0.625 15.88	0.313 7.95	3.834 97.38	-0.020 -0.51	0.083 2.11	0.188 4.78
4 DN100	4.500 114.3	0.045 1.14	0.031 0.79	0.625 15.88	0.375 9.53	4.334 110.08	-0.020 -0.51	0.083 2.11	0.203 5.16
4 1/2	5.000 127.0	0.050 1.27	0.031 0.79	0.625 15.88	0.375 9.53	4.834 122.78	-0.020 -0.51	0.083 2.11	0.203 5.16

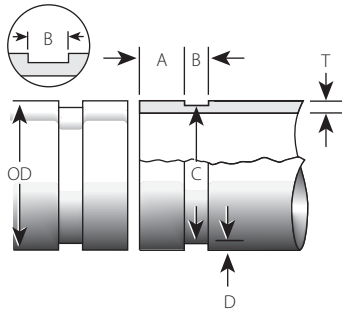
- ¹ Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- ² Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.
- ³ Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.
- ⁴ Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.
- ⁵ Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.
- ⁶ Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be grooved.

NOTES

- Cut grooving standard steel pipe removes less metal, to less depth, than threading, maintaining the desired integrity of the pipe.
- 3/16"/14 mm width groove is required in sizes 22 – 24"/DN550 – DN600 in order to obtain the maximum allowable pipe end movement listed in Performance Data Charts. 1/2"/12 mm width groove will give 1/2 the maximum allowance shown for 22 – 24"/DN550 – DN600. For double groove tool bit information, contact Victaulic.

1.0 DIMENSIONS (CONTINUED)

STANDARD CUT GROOVE SPECIFICATIONS FOR STEEL AND OTHER IPS PIPE



Exaggerated for Clarity

Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵	Min Allow. Wall Thk. "T" ⁶
	Actual	Tolerance				Actual	Tol. (+0.00)		
inches DN	inches mm	+ inches mm	- inches mm	±0.03 inches ±0.76 mm	±0.03 inches ±0.76 mm	inches mm	inches mm	inches mm	
DN125	5.500	0.056	0.031	0.625	0.375	5.334	-0.020	0.083	0.203
	139.7	1.42	0.79	15.88	9.53	135.48	-0.51	2.11	5.16
5	5.563	0.056	0.031	0.625	0.375	5.395	-0.020	0.084	0.203
	141.3	1.42	0.79	15.88	9.53	137.03	-0.51	2.13	5.16
	6.000	0.056	0.031	0.625	0.375	5.830	-0.022	0.085	0.219
	152.4	1.42	0.79	15.88	9.53	148.08	-0.56	2.16	5.56
	6.250	0.063	0.031	0.625	0.375	6.032	-0.030	0.109	0.249
	159	1.60	0.79	15.88	9.53	153.2	-0.76	2.77	6.30
	6.500	0.063	0.031	0.625	0.375	6.330	-0.022	0.085	0.219
	165.1	1.60	0.79	15.88	9.53	160.78	-0.56	2.16	5.56
6 DN150	6.625	0.063	0.031	0.625	0.375	6.455	-0.022	0.085	0.219
	168.3	1.60	0.79	15.88	9.53	163.96	-0.56	2.16	5.56
	8.000	0.063	0.031	0.750	0.438	7.816	-0.022	0.092	0.238
	203.2	1.60	0.79	19.05	11.13	198.53	-0.56	2.34	6.05
8 DN200	8.625	0.063	0.031	0.750	0.438	8.441	-0.025	0.092	0.238
	219.1	1.60	0.79	19.05	11.13	214.40	-0.64	2.34	6.05
	10.000	0.063	0.031	0.750	0.500	9.812	-0.025	0.094	0.250
	254.0	1.60	0.79	19.05	12.70	249.23	-0.64	2.39	6.35
10 DN250	10.750	0.063	0.031	0.750	0.500	10.562	-0.027	0.094	0.250
	273.0	1.60	0.79	19.05	12.70	268.28	-0.69	2.39	6.35
	12.000	0.063	0.031	0.750	0.500	11.781	-0.027	0.109	0.279
	304.8	1.60	0.79	19.05	12.70	299.24	-0.69	2.77	7.09

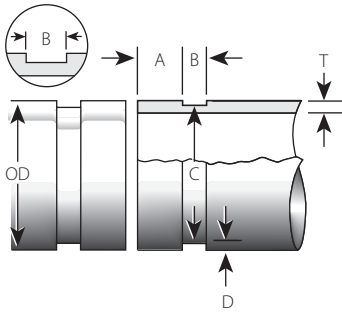
- ¹ Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- ² Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.
- ³ Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.
- ⁴ Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.
- ⁵ Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.
- ⁶ Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be grooved.

NOTES

- Cut grooving standard steel pipe removes less metal, to less depth, than threading, maintaining the desired integrity of the pipe.
- 3/16" / 14 mm width groove is required in sizes 22 – 24" / DN550 – DN600 in order to obtain the maximum allowable pipe end movement listed in Performance Data Charts. 1/2" / 12 mm width groove will give 1/2 the maximum allowance shown for 22 – 24" / DN550 – DN600. For double groove tool bit information, contact Victaulic.

1.0 DIMENSIONS (CONTINUED)

STANDARD CUT GROOVE SPECIFICATIONS FOR STEEL AND OTHER IPS PIPE



Exaggerated for Clarity

Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵	Min Allow. Wall Thk. "T" ⁶	
	Actual	Tolerance				Actual	Tol. (+0.00)			
		+	-							
12 DN300	12.750 323.9	0.063 1.60	0.031 0.79	±0.03 inches ±0.76 mm	0.750 19.05	0.500 12.70	12.531 318.29	-0.030 -0.76	0.109 2.77	0.279 7.09
14 DN350	14.000 355.6	0.063 1.60	0.031 0.79	0.938 23.83	0.500 12.70	13.781 350.04	-0.030 -0.76	0.109 2.77	0.281 7.14	
15 DN375	15.000 381.0	0.063 1.60	0.031 0.79	0.938 23.83	0.500 12.70	14.781 375.44	-0.030 -0.76	0.109 2.77	0.312 7.92	
	14.842 377.0	0.063 2.36	0.031 0.79	0.938 23.83	0.500 12.70	14.611 371.1	-0.030 -0.76	0.116 2.94	0.315 8.00	
16 DN400	16.000 406.4	0.063 1.60	0.031 0.79	0.938 23.83	0.500 12.70	15.781 400.84	-0.030 -0.76	0.109 2.77	0.312 7.92	
	16.772 426.0	0.063 2.36	0.031 0.79	0.938 23.83	0.500 12.70	16.514 419.5	-0.030 -0.76	0.129 3.28	0.335 8.51	
18 DN450	18.000 457.2	0.063 1.60	0.031 0.79	1.000 25.40	0.500 12.70	17.781 451.64	-0.030 -0.76	0.109 2.77	0.312 7.92	
	18.898 480.0	0.063 2.36	0.031 0.79	1.000 25.40	0.500 12.70	18.626 473.1	-0.030 -0.76	0.136 3.45	0.354 8.99	
20 DN500	20.000 508.0	0.063 1.60	0.031 0.79	1.000 25.40	0.500 12.70	19.781 502.44	-0.030 -0.76	0.109 2.77	0.312 7.92	
	20.866 530.0	0.063 2.36	0.031 0.79	1.000 25.40	0.500 12.70	20.572 522.5	-0.030 -0.76	0.147 3.73	0.354 8.99	
22 DN550	22.000 558.8	0.063 1.60	0.031 0.79	1.000 25.40	0.563* 14.30	21.656 550.06	-0.030 -0.76	0.172 4.37	0.375 9.53	
24 DN600	24.000 609.6	0.063 1.60	0.031 0.79	1.000 25.40	0.563* 14.30	23.656 600.86	-0.030 -0.76	0.172 4.37	0.375 9.53	
	24.803 630.0	0.093 2.36	0.031 0.79	1.000 25.40	0.563 14.30	24.459 621.3	-0.035 -0.89	0.172 4.37	0.394 10.00	

- ¹ Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- ² Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.
- ³ Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.
- ⁴ Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.
- ⁵ Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.
- ⁶ Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be grooved.

NOTES

- Do not apply coatings to the gasket seat "A" nor within the groove width "B" on the pipe exterior.
- Cut grooving standard steel pipe removes less metal, to less depth, than threading, maintaining the desired integrity of the pipe.
- 9/16"/14 mm width groove is required in sizes 22 – 24"/DN550 – DN600 in order to obtain the maximum allowable pipe end movement listed in Performance Data Charts. 1/2"/12 mm width groove will give 1/2 the maximum allowance shown for 22 – 24"/DN550 – DN600. For double groove tool bit information, contact Victaulic.

2.0 NOTIFICATIONS

NOTICE

- **Victaulic does not recommend the use of any furnace butt-welded pipe with sizes NPS 2”/DN50 and smaller Victaulic gasketed joint products. This includes, but is not limited to, ASTM A53 Type F pipe.**

3.0 REFERENCE MATERIALS

[24.01: Victaulic Pipe Preparation Tools](#)

[25.09: AGS Roll Groove Specifications for 14-72”/DN350-DN1800 roll groove dimensions](#)

[29.01: Victaulic® Terms and Conditions of Sale](#)

[I-100: Victaulic Field Installation Handbook](#)

User Responsibility for Product Selection and Suitability

Each user bears final responsibility for making a determination as to the suitability of Victaulic products for a particular end-use application, in accordance with industry standards and project specifications, and the applicable building codes and related regulations as well as Victaulic performance, maintenance, safety, and warning instructions. Nothing in this or any other document, nor any verbal recommendation, advice, or opinion from any Victaulic employee, shall be deemed to alter, vary, supersede, or waive any provision of Victaulic Company’s standard conditions of sale, installation guide, or this disclaimer.

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Note

This product shall be manufactured by Victaulic or to Victaulic specifications. All products to be installed in accordance with current Victaulic installation/assembly instructions. Victaulic reserves the right to change product specifications, designs and standard equipment without notice and without incurring obligations.

Installation

Reference should always be made to the Victaulic installation handbook or installation instructions of the product you are installing. Handbooks are included with each shipment of Victaulic products, providing complete installation and assembly data, and are available in PDF format on our website at www.victaulic.com.

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