

# PIPE ROLL GROOVE SPECIFICATIONS

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Nominal Size		Pipe O.D.	Tolerance	A1 ±0.76	B1 ±0.76	C1	Groove Dia C		Min. Thickness T Casting Thickness	Max Allow Flare Dia F
Inch	mm	mm	mm	mm	mm	mm	Basic size	Tolerance	mm	mm
1	25	33.7	+0.30 -0.50	15.9	7.2	1.7	30.2	-0.38	1.65	34.5
1 1/4	32	42(42.4)		15.9	7.2	1.7	39.0	-0.38	1.65	43.3
1 1/2	40	48(48.3)		15.9	7.2	1.6	45.1	-0.38	1.65	49.4
2	50	57	+0.80 -0.60	15.9	8.8	1.6	53.8	-0.38	1.65	58.9
2	50	60(60.3)		15.9	8.8	1.6	57.2	-0.38	1.65	62.2
2 1/2	65	73		15.9	8.8	2.0	69.1	-0.46	2.11	75.2
2 1/2	65	76(76.1)	+1.00 -0.80	15.9	8.8	1.9	72.3	-0.46	2.11	77.7
3	80	89(88.9)		15.9	8.8	2.0	84.9	-0.46	2.11	90.6
4	100	108		15.9	8.8	2.1	103.7	-0.51	2.11	109.7
4	100	114(114.3)	+1.40 -0.80	15.9	8.8	2.1	110.1	-0.51	2.11	116.2
5	125	133		15.9	8.8	2.0	129.1	-0.51	2.77	134.9
5	125	140(139.7)		15.9	8.8	2.1	135.5	-0.51	2.77	141.7
5	125	141.3	+1.60 -0.80	15.9	8.8	2.2	137.0	-0.51	2.77	143.5
6	150	159		15.9	8.8	2.2	154.6	-0.56	2.77	161.0
6	150	165(165.1)		15.9	8.8	2.2	160.8	-0.56	2.77	167.1
6	150	168(168.3)	+1.80 -0.80	15.9	8.8	2.2	164.0	-0.56	2.77	170.7
8	200	216.3		19.1	11.9	2.4	211.6	-0.64	2.77	220.7
8	200	219(219.1)		19.1	11.9	2.4	214.4	-0.64	2.77	221.5
10	250	267.4	+1.80 -0.80	19.1	11.9	2.4	262.6	-0.69	3.40	271.8
10	250	273		19.1	11.9	2.4	268.3	-0.69	3.40	275.4
12	300	318.5		19.1	11.9	2.8	312.9	-0.76	3.96	322.8
12	300	325/323.9	+1.80 -0.80	19.1	13/11.9	3/2.8	319/318.3	-0.76	3.96	327.3/326.2
14	350	377/355.6		25/23.8	13/11.9	5.5/2.8	366/350	-0.76	3.96	381.1/359.7
16	400	426/406.4		25/23.8	13/11.9	5.5/2.8	415/400.8	-0.76	4.19	430.1/410.5
18	450	480/457.2	+1.80 -0.80	25/25.4	13/11.9	5.5/2.8	469/451.6	-0.76	4.19	484.1/461.3
20	500	530/508		25/25.4	13/11.9	5.5/2.8	519/502.4	-0.76	4.78	534.1/512.1
24	600	630/610		25/25.4	13/12.7	5.5/4.4	619/600.9	-0.76	5.54	634.7/614.7

