Roll Groove Specifications

GROOVJOINT STANDARD ROLL GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE										
-1-	-2-			-3-	-4-	-5-		-6-	-7-	-8-
Nominal Pipe Size	O.D.			"A" ±0.030/ ±0.76	"B" ±0.030/ ±0.76	"C" Actual	"C" Tol. +0.000	"D" (Ref. Only)	"T" Min. Allow. Wall Thick	Max. Flare Dia.
	Actual	Tolerance								
In./DN(mm)	In./mm	+In./mm	-In./mm	In./mm	In./mm	IIn./mm	-In./mm	In./mm	In./mm	In./mm
1	**1.315**	**+0.028**	**-0.015**	**0.625**	**0.281**	**1.190**	**-0.015**	**0.063**	**0.065**	**1.430**
25	33.4	+0.71	-0.38	15.88	7.14	30.23	-0.38	1.60	1.7	36.3
1-1/4	**1.660**	**+0.029**	**-0.016**	**0.625**	**0.281**	**1.535**	**-0.015**	**0.063**	**0.065**	**1.770**
32	42.2	+0.74	-0.41	15.88	7.14	38.99	-0.38	1.60	1.7	45.0
1-1/2	**1.900**	**+0.019**	**-0.019**	**0.625**	**0.281**	**1.775**	**-0.015**	**0.063**	**0.065**	**2.010**
40	48.3	+0.48	-0.48	15.88	7.14	45.09	-0.38	1.60	1.7	51.1
2	**2.375**	**+0.024**	**-0.024**	**0.625**	**0.344**	**2.250**	**-0.015**	**0.063**	**0.065**	**2.480**
50	60.3	+0.61	-0.61	15.88	8.74	57.15	-0.38	1.60	1.7	63.0
2-1/2	**2.875**	**+0.029**	**-0.029**	**0.625**	**0.344**	**2.720**	**-0.018**	**0.078**	**0.083**	**2.980**
65	73.0	+0.74	-0.74	15.88	8.74	69.09	-0.46	1.98	2.1	75.7
3	**3.500**	**+0.035**	**-0.031**	**0.625**	**0.344**	**3.344**	**-0.018**	**0.078**	**0.083**	**3.600**
80	88.9	+0.89	-0.79	15.88	8.74	84.94	-0.46	1.98	2.1	91.4
3-1/2	**4.000**	**+0.040**	**-0.031**	**0.625**	**0.344**	**3.834**	**-0.020**	**0.083**	**0.083**	**4.100**
90	101.6	+1.02	-0.79	15.88	8.74	97.38	-0.51	2.11	2.1	104.1
4	**4.500**	**+0.045**	**-0.031**	**0.625**	**0.344**	**4.334**	**-0.020**	**0.083**	**0.083**	**4.600**
100	114.3	+1.14	-0.79	15.88	8.74	110.08	-0.51	2.11	2.1	116.8
5	**5.563**	**+0.056**	**-0.031**	**0.625**	**0.344**	**5.395**	**-0.022**	**0.084**	**0.109**	**5.660**
125	141.3	+1.42	-0.79	15.88	8.74	137.03	-0.56	2.13	2.8	143.8
6	**6.625**	**+0.063**	**-0.031**	**0.625**	**0.344**	**6.455**	**-0.022**	**0.085**	**0.109**	**6.730**
150	168.3	+1.60	-0.79	15.88	8.74	163.96	-0.56	2.16	2.8	170.9
8	**8.625**	**+0.063**	**-0.031**	**0.750**	**0.469**	**8.441**	**-0.025**	**0.092**	**0.109**	**8.800**
200	219.1	+1.60	-0.79	19.05	11.91	214.40	-0.64	2.34	2.8	223.5
10	**10.750**	**+0.063**	**-0.031**	**0.750**	**0.469**	**10.562**	**-0.027**	**0.094**	**0.134**	**10.920**
250	273.1	+1.60	-0.79	19.05	11.91	268.27	-0.69	2.39	3.4	277.4
12	**12.750**	**+0.063**	**-0.031**	**0.750**	**0.469**	**12.531**	**-0.030**	**0.109**	**0.156**	**12.920**
300	323.9	+1.60	-0.79	19.05	11.91	318.29	-0.76	2.77	4.0	328.2
14 O.D.	**14.000**	**+0.063**	**-0.031**	**0.938**	**0.469**	**13.781**	**-0.030**	**0.109**	**0.156**	**14.100**
355.6	355.6	+1.60	-0.79	23.83	11.91	350.04	-0.76	2.77	4.0	358.1
16 O.D.	**16.000**	**+0.063**	**-0.031**	**0.938**	**0.469**	**15.781**	**-0.030**	**0.109**	**0.165**	**16.100**
406.4	406.4	+1.60	-0.79	23.83	11.91	400.84	-0.76	2.77	4.2	708.9
18 O.D.	**18.000**	**+0.063**	**-0.031**	**1.000**	**0.469**	**17.781**	**-0.030**	**0.109**	**0.165**	**18.160**
457.2	457.2	+1.60	-0.79	25.40	11.91	451.64	-0.76	2.77	4.2	461.3
20 O.D.	**20.000**	**+0.063**	**-0.031**	**1.000**	**0.469**	**19.781**	**-0.030**	**0.109**	**0.188**	**20.160**
508.0	508.0	+1.60	-0.79	25.40	11.91	502.44	-0.76	2.77	4.8	512.1
24 O.D.	**24.000**	**+0.063**	**-0.031**	**1.000**	**0.563**	**23.656**	**-0.030**	**0.172**	**0.218**	**24.200**
609.6	609.6	+1.60	-0.79	25.40	14.30	600.86	-0.76	4.37	5.5	614.7
30 O.D.	**30.000**	**+0.093**	**-0.031**	**1.750▼**	**0.625**	**29.500**	**-0.063**	**0.250**	**0.250**	**30.200**
762.0	762.0	2.36	0.79	44.45	15.88	749.30	1.60	6.35	6.35	761.1