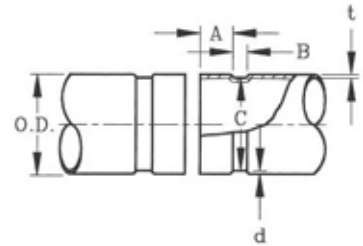


STANDARD ROLL GROOVE for BS1387 (ISO 65) Carbon Steel Pipe



1 Nominal Size	2 Pipe O.D.			3 A	4 B	5 C	6 Min. Wall t	7 Groove Depth d(ref.)	8 Max. Allowed Flare Dia.
	Basic	Max	Min	+0.38/-0.76	+0.76/-0.38	+0.00			
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
20	26.9	27.3	26.5	15.88	7.14	23.83-0.38	1.65	1.42	29.2
25	33.7	34.2	33.3	15.88	7.14	30.23-0.38	1.65	1.60	36.3
32	42.4	42.9	42.0	15.88	7.14	38.99-0.38	1.65	1.60	45.0
40	48.3	48.8	47.9	15.88	7.14	45.09-0.38	1.65	1.60	51.1
50	60.3	60.8	59.7	15.88	8.74	57.15-0.38	1.65	1.60	63.0
65	76.1	76.6	75.3	15.88	8.74	72.26-0.46	2.11	1.98	75.7
80	88.9	89.5	88.0	15.88	8.74	84.94-0.46	2.11	1.98	91.4
100	114.3	115.0	113.1	15.88	8.74	110.08-0.51	2.11	2.11	116.8
125	139.7	140.8	138.5	15.88	8.74	135.48-0.56	2.77	2.11	143.8
150	165.1	166.5	163.9	15.88	8.74	160.78-0.56	2.77	2.16	170.9

Nominal Pipe Size (Column 1):

Nominal pipe size, BS1387 (ISO 65) Carbon Steel Pipe.

Pipe OD (Column 2):

Maximum allowable tolerances from square of ends is 0.03" for sizes up to 3-1/2"; 0.045" for 4" thru 6", and 0.060" for sizes 8" and above.

Gasket Seating Surface (Column 3):

The gasket seating surface shall be free from deep scores, marks, or ridges that could 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" diameters are average values. The groove must be of uniform depth around the entire pipe circumference.

Minimum Wall Thickness (Column 6):

The "t" is the minimum allowable wall thickness that may be roll-grooved.

Groove Depth (Column 7):

The "d" is for reference use only. The groove dimension shall be determined by the groove diameter "C".

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.

General Notes:

- Pressure ratings listed are CWP (cold water pressure) or maximum working pressure within the service temperature range of the gasket used in the coupling. This rating may occasionally differ from maximum working pressures listed and/or approved by UL, ULc, and/or FM as testing conditions and test pipes differ. For additional information contact **Shurjoint**.
- Maximum working pressures and end loads listed are total of internal and external pressures and loads based on Sch. 40 steel pipe with roll grooves to ANSI/AWWA C606-97 specifications. For information on other pipe schedules contact **Shurjoint**.
- **For one time field test only** the maximum joint working pressure may be increased 1-1/2 times the figures shown.
- **Warning:** Piping systems must always be depressurized and drained before attempting disassembly and or removal of any components.
- **Shurjoint** reserves the right to change specifications, designs and or standard equipment without notice and without incurring any obligations.