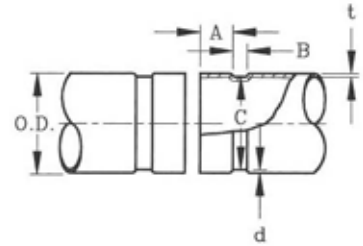


## STANDARD ROLL GROOVE for DIN 2440 & DIN 2448 (ISO 4200) CARBON STEEL PIPE



1 Pipe Or Tube	2 Pipe O.D.		3 Gasket Seat A ±0.76	4 Groove Width B ±0.76	5 Groove Dia. Basic C Tolerance +0.00		6 Groove Depth d (ref)	7 Min. Allow Wall Thickness t	8 Max. Flare f
	Basic	Tolerance			mm	mm			
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
25	33.7	+0.41 -0.68	15.88	7.14	30.23	-0.38	1.70	1.8	34.5
32	42.4	+0.50 -0.60	15.88	7.14	38.99	-0.38	1.70	1.8	43.3
40	48.3	+0.44 -0.52	15.88	7.14	45.09	-0.38	1.60	1.8	49.4
50	60.3	+0.61 -0.61	15.88	8.74	57.15	-0.38	1.60	1.8	62.2
65	76.1	+0.76 -0.76	15.88	8.74	72.26	-0.46	1.93	2.3	77.7
80	88.9	+0.89 -0.79	15.88	8.74	84.94	-0.46	1.98	2.3	90.6
100	108.0	+1.07 -0.79	15.88	8.74	103.73	-0.51	2.11	2.3	109.7
100	114.3	+1.14 -0.79	15.88	8.74	110.08	-0.51	2.11	2.3	116.2
125	133.0	+1.32 -0.79	15.88	8.74	129.13	-0.51	1.93	2.9	134.9
125	139.7	+1.40 -0.79	15.88	8.74	135.48	-0.51	2.11	2.9	141.7
150	159.0	+1.60 -0.79	15.88	8.74	154.50	-0.56	2.20	2.9	161.0
150	168.3	+1.60 -0.79	15.88	8.74	163.96	-0.56	2.16	2.9	170.7
200	219.1	+1.60 -0.79	19.05	11.91	214.40	-0.64	2.34	2.9	221.5
250	273.0	+1.60 -0.79	19.05	11.91	268.28	-0.69	2.39	3.6	275.4
300	323.9	+1.60 -0.79	19.05	11.91	318.29	-0.76	2.77	4.0	326.2

### Nominal Pipe Size (Column 1):

Nominal pipe size, DIN 2440 & DIN 2448 (ISO 4200) 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 shoulder shall be free from burs metal removed up to max. 0.3mm x 45°.

### Groove Diameter (Column 5):

The "C" diameters are average values. The groove must be of uniform depth around the entire pipe circumference. Groove bottom with radius up to max. 0.8mm.

### Minimum Wall Thickness (Column 6):

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

### Groove Depth (Column 7):

The "td" 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.

### 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.