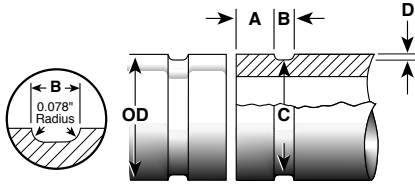


PVC Pipe Groove Specifications

STANDARD RADIUS CUT GROOVING SPECIFICATIONS

For Schedule 80 or Schedule 40 PVC plastic pipe* (ASTM D-1785-70)



Exaggerated for Clarity

1		2		3	4	5		6
Pipe Size		Pipe Outside Dia. Inches/mm				Dimensions – Inches/millimeters		
Nominal Dia. Inches/mm	Actual Out. Dia. Inches/mm	Tolerance		Gasket Seat A +0.031 -0.031	Groove Width B +0.031 -0.031	Groove Dia. C		Trial Groove Depth D
		+	-			Basic	Tol. +0.000	
3/4 20	1.050 26.7	+0.012 +0.30	-0.012 -0.30	0.625 15.9	0.312 7.9	0.938 23.8	-0.015 -0.38	0.056 1.4
1 25	1.315 33.7	+0.012 +0.30	-0.012 -0.30	0.625 15.9	0.312 7.9	1.190 30.2	-0.015 -0.38	0.062 1.6
1 1/4 32	1.660 42.4	+0.012 +0.30	-0.012 -0.30	0.625 15.9	0.312 7.9	1.535 39.0	-0.015 -0.38	0.062 1.6
1 1/2 40	1.900 48.3	+0.012 +0.30	-0.012 -0.30	0.625 15.9	0.312 7.9	1.775 45.1	-0.015 -0.38	0.062 1.6
2 50	2.375 60.3	+0.012 +0.30	-0.012 -0.30	0.625 15.9	0.312 7.9	2.250 57.2	-0.015 -0.38	0.062 1.6
2 1/2 65	2.875 73.0	+0.012 +0.30	-0.012 -0.30	0.625 15.9	0.312 7.9	2.720 69.1	-0.018 -0.46	0.078 2.0
3 80	3.500 88.9	+0.015 +0.38	-0.015 -0.38	0.625 15.9	0.312 7.9	3.344 84.9	-0.018 -0.46	0.078 2.0
4 100	4.500 114.3	+0.020 +0.51	-0.020 -0.51	0.625 15.9	0.375 9.5	4.334 110.1	-0.020 -0.51	0.083 2.1
6 150	6.625 168.3	+0.035 +0.89	-0.035 -0.89	0.625 15.9	0.375 9.5	6.455 164.0	-0.022 -0.56	0.085 2.2
8 200	8.625 219.1	+0.062 +1.57	-0.031 -0.79	0.750 19.1	0.437 11.1	8.441 214.4	-0.025 -0.64	0.092 2.3
10 250	10.750 273.0	+0.062 +1.57	-0.031 -0.79	0.750 19.1	0.500 12.7	10.562 268.2	-0.027 -0.69	0.094 2.4
12 300	12.750 323.9	+0.062 +1.57	-0.031 -0.79	0.750 19.1	0.500 12.7	12.531 318.2	-0.030 -0.76	0.109 2.8
14 350	14.000 355.6	+0.062 +1.57	-0.031 -0.79	0.938 23.8	0.500 12.7	13.781 350.0	-0.030 -0.76	0.109 2.8
16 400	16.000 406.4	+0.062 +1.57	-0.031 -0.79	0.938 23.8	0.500 12.7	15.781 400.8	-0.030 -0.76	0.109 2.8

NOTES:

COLUMN 1 – Nominal pipe size.

COLUMN 2 – IPS outside diameter. The nominal outside diameter of grooved pipe shall not vary more than the tolerance listed. Maximum allowable tolerance from square cut ends is 0.030" (0.8 mm) for sizes 3/4 – 31/2"(20 – 90 mm), 0.045" (1.1 mm) for sizes 4 – 6" (100 – 150 mm) and 0.060" (1.5 mm) for sizes 8" (200 mm) and above. Measured from true square line.

COLUMN 3 – Gasket seat: The pipe shall be free from indentations, projections, or roll marks from the end of the pipe to the groove, to provide a leaktight seat for the gasket.

COLUMN 4 – Groove width.

COLUMN 5 – Groove Outside Diameter. The groove must be uniform depth for the entire pipe circumference. The "C" diameter must be maintained.

COLUMN 6 – Groove depth: Trial use only GROOVE MUST CONFORM TO "C" DIAMETER SHOWN.

*PVC Plastic Pipe – based on modified PVC plastic pipe conforming to ASTM D-1785-70. Type I, Grade I-PVC 1120 or Grade II-PVC 1220 at operating temperatures of +75°F maximum. For other types of PVC pipe and other operating temperatures, contact Victaulic.

JOB/OWNER

System No. _____
Location _____

CONTRACTOR

Submitted By _____
Date _____

ENGINEER

Spec Sect _____ Para _____
Approved _____
Date _____

PVC Pipe Groove Specifications

STANDARD RADIUS CUT GROOVING SPECIFICATIONS

INSTALLATION

Reference should always be made to the I-100 Victaulic Field Installation Handbook for the product you are installing. Handbooks are included with each shipment of Victaulic products for complete installation and assembly data, and are available in PDF format on our website at www.victaulic.com.

WARRANTY

Refer to the Warranty section of the current Price List or contact Victaulic for details.

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.



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For complete contact information, visit www.victaulic.com

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