

GROOVE MEASUREMENT IN THE PIPING SYSTEM

In the site works, the Groove should be checked and compared with the related values according to the following table by means of PT-101 Metric before groove application.

The Table taken from Instruction Manual /PT-101 Metric for Grooved Pipe

Victaulic Grooved Pipe Diameter Specifications for Steel and Stainless Steel Pipe

The groove diameters listed below correspond to the PT-101 Go/No-Go side of the tape. Refer to section 25 in the Victaulic G-100 General Catalog for additional sizes and types of pipe.

1	2					3	4					
	Dimensions – millimeters						Pipe Size mm	Dimensions – millimeters				
	Pipe Outside Dia.		Groove Dia. "C"		Max. Allow. Flare Dia.			Pipe Outside Dia.		Groove Dia. "C"		Max. Allow. Flare Dia.
Max.	Min.	Max.	Min.	Max.		Min.	Max.	Min.				
26.9	26.9	26.4	23.8	23.4	29.2	318.5	320.1	317.7	313.0	312.2	322.8	
33.7	33.7	33.1	30.2	29.9	36.3	323.9	325.5	323.1	318.3	317.5	328.2	
42.4	42.6	41.8	39.0	38.6	45.0	355.6	357.2	354.8	350.0	349.3	359.7	
48.3	48.7	47.8	45.1	44.7	51.1	377.0	379.4	376.2	371.1	370.4	381.0	
60.3	60.9	59.7	57.2	56.8	63.0	406.4	408.0	405.6	400.8	400.1	410.5	
73.0	73.8	72.3	69.1	68.6	75.7	426.0	428.4	425.2	419.5	418.6	430.0	
76.1	77.0	75.4	72.3	71.8	78.7	457.0	458.8	456.4	451.6	450.9	461.3	
88.9	89.8	88.1	84.9	84.5	91.4	480.0	482.4	479.2	473.1	472.2	484.1	
108.0	109.0	107.2	103.7	103.2	110.5	508.0	509.6	507.2	502.4	501.7	512.1	
114.3	115.4	113.5	110.1	109.6	116.8	530.0	532.4	529.2	522.5	521.6	534.2	
133.0	134.7	132.6	129.1	128.6	135.9	559.0	560.4	558.0	550.1	549.3	563.9	
139.7	141.1	138.9	135.5	135.0	142.2	610.0	611.2	608.8	600.9	600.1	614.7	
159.0	160.4	158.0	153.2	152.5	161.3	630.0	632.4	629.2	621.3	620.4	635.0	
165.1	166.7	164.3	160.8	160.2	167.6	355.6	358.0	354.8	342.9	341.8	361.4	
168.3	169.9	167.5	164.0	163.4	170.9	406.4	408.8	405.6	393.7	392.6	412.2	
216.3	217.9	215.5	211.6	211.0	220.7	457.0	459.6	456.4	444.5	443.4	463.0	
219.1	220.7	218.3	214.4	213.8	223.5	508.0	510.4	507.2	495.3	494.2	513.8	
267.4	269.0	266.6	262.6	262.0	271.8	559.0	561.2	558.0	546.1	544.9	564.6	
273.0	274.7	272.3	268.3	267.6	277.4	610.0	612.0	608.8	596.9	595.8	615.4	

NOTE: Shaded rows identify Advanced Groove System (AGS) sizes and dimensions.

COLUMN 1: Millimeter sizes per ISO 4200 and/or JIS G3452 and Republic of China Steel Pipe Standards

COLUMN 2: Pipe Outside Diameter – The average pipe outside diameter must not vary from the specifications listed in the table above. Maximum allowable pipe ovality should not vary by more than 1%. Greater variations between the major and minor diameters will result in difficult coupling assembly. The maximum allowable tolerance from square-cut pipe ends is 0.8mm for 26.9 – 88.9-mm sizes; 1.1 mm for 108.0 – 168.3-mm sizes; and 1.5mm for 216.3-mm and larger sizes. This dimension is measured from the true square line. Any internal and external weld beads or seams must be ground flush to the pipe surface for a distance sufficient to clear the grooving rolls. The inside diameter of the pipe end must be cleaned to remove coarse scale, dirt, and other foreign material that might interfere with or damage grooving rolls.

COLUMN 3: "C" Dimension – The "C" Dimension is the proper diameter at the base of the groove. This dimension must be within the diameter's tolerance and concentric with the OD for proper coupling fit. The groove must be of uniform depth for the entire pipe circumference.

COLUMN 4: Maximum Allowable Pipe-End Flare (for roll-grooved pipe only) – This dimension is measured at the extreme pipe-end diameter of square-cut or beveled-end grooved pipe.

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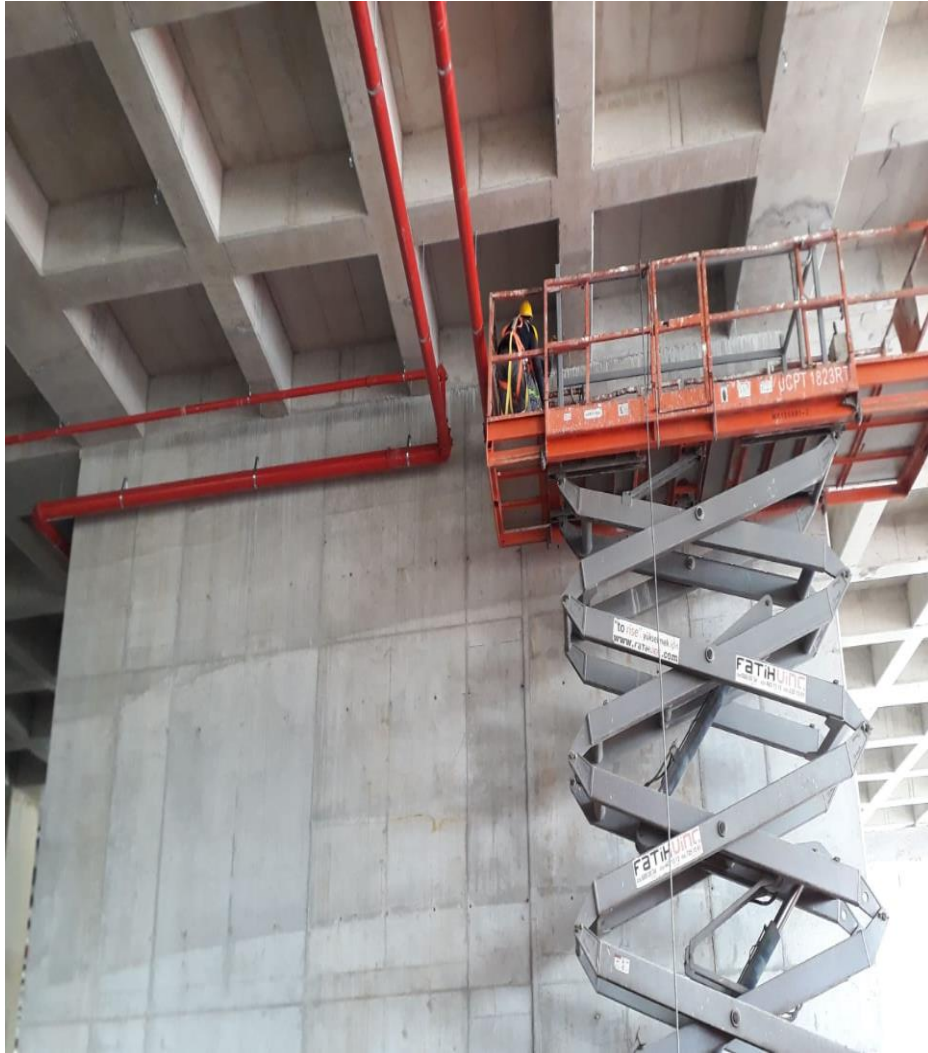
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Groove Application/Measurement/PT-101 Metric for Grooved Pipe



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Firefighting Pipelines&Sprinkler (NFPA 13)

The Pipe DN 65 (76.1 mm)

**The Allowable Max.-Min. Of Groove Dia. as per the related table
72.3-71.8 mm**

The measured dia. 72.10 mm (Suitable)

Also kindly note that check the flare diameter to be occurred during Groove application done by the grooving tool.



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	Dimensions – millimeters				
	Max.	Min.	Max.	Min.	
26.9	26.9	26.4	23.8	23.4	29.2
33.7	33.7	33.1	30.2	29.9	36.3
42.4	42.6	41.8	39.0	38.6	45.0
48.3	48.7	47.8	45.1	44.7	51.1
60.3	60.9	59.7	57.2	56.8	63.0
73.0	73.8	72.3	69.1	68.6	75.7
76.1	77.0	75.4	72.3	71.8	78.7

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