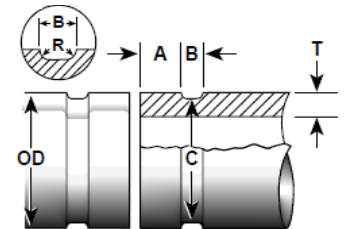


Ductile Iron Grooved Pipe



Flexible Radius Cut Grooved DI Pipe



1 Size	2 Pipe Outside Dia O.D.			3 Gasket Seat A+ +0.000 -0.020	4 Gasket Width B +0.31 -0.016	5 Groove Dia C**		6 Radius R	7 Min. Allow. Wall Thick T#
	Basic (in.)	Tolerance				Basic	ToL. +000.0		
		+(in.)	-(in.)						
03"	3.96	+0.045	-0.045	0.750	0.375	3.723	-0.020	0.120	0.31
04"	4.80	+0.045	-0.045	0.750	0.375	4.563	-0.020	0.120	0.32
06"	6.90	+0.060	-0.060	0.750	0.375	6.656	-0.020	0.120	0.34
08"	9.05	+0.060	-0.060	0.875	0.500	8.781	-0.025	0.145	0.36
10"	11.10	+0.060	-0.060	0.938	0.500	10.813	-0.030	0.145	0.38
12"	13.20	+0.060	-0.060	0.938	0.500	12.906	-0.030	0.145	0.40
14"	15.30	+0.050	-0.080	0.938	0.625	14.969	-0.030	0.165	0.42
16"	17.40	+0.050	-0.080	1.188	0.625	17.063	-0.030	0.165	0.43
18"	19.50	+0.050	-0.080	1.188	0.625	19.125	-0.030	0.185	0.44
20"	21.60	+0.050	-0.080	1.188	0.625	21.219	-0.030	0.185	0.45
24"	25.80	+0.050	-0.080	1.340	0.625	25.406	-0.030	0.185	0.47
30"	32.00	+0.080	-0.060	1.375	0.750	31.550	-0.035	0.215	0.51
36"	38.30	+0.080	-0.060	1.375	0.750	37.850	-0.035	0.215	0.58

Table 1

- * Ovality, or out-of-roundness, must lie within specified tolerances
- ** Groove must be uniform depth for entire pipe circumference. Groove must conform to "C" diameter shown.
- *** Must be smooth and free of deep pits or swells
- # Min. standard wall thickness that should be grooved. Tolerances are to conform to CL 53 AWWA C151.

Column 1: Nominal AWWA Pipe Size

Column 2: AWWA outside diameter. The outside diameter shall not vary more than the tolerance listed. The maximum allowable tolerance from square cut ends is 0.030" for 3", 0.045" for 4"-6", and 0.060" for sizes 8" and larger measured from true square line.

Column 3: Gasket seat: The pipe surface shall be free from indentations and projections from the end of the pipe to the groove, to provide a leak tight seat for the gasket

Column 4: Groove width

Column 5: Groove outside diameter: The groove must be uniform depth for the entire circumference. Groove must maintained within the "C" diameter tolerance listed.

Column 6: Groove depth: For reference only. Groove must conform to the groove diameter "C" listed.

Column 7: Minimum allowable wall thickness. This is the minimum wall thickness which may be cut grooved.

Coatings applied to the interior surfaces, including bolt pad mating surfaces, of our bolted grooved and bolted plain end couplings should not exceed 0.010". Also coating thickness applied to the gasket seating surface and within the groove on the pipe exterior should not exceed 0.010".