TECHNICAL DATA SHEET
ROLL GROOVE DIMENSIONS

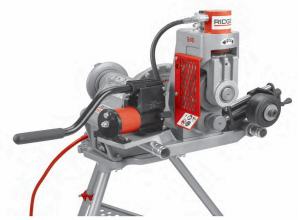
Version 1. 01.04.2025

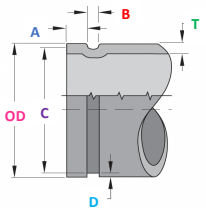
We reserve the right to change the technical data sheet without prior notice and without any obligation.

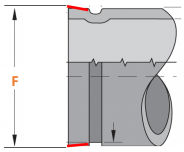
"ROLL GROOVE" DIMENSIONS

Roll groove dimensions

Grooving machine







Common sizes

Nom. size mm/in	Pipe outs.dia. OD			Gasket seat A ±0.76/±0.03 mm/in	Gasket width B ±0.76/±0.03 mm/in	Groove dia C		Groove depth D (ref) mm/in	Max. allow flare dia. F mm/in	Min. allow wall thickness T mm/in
	Basic mm/in	Tolerance mm/in				Basic mm/in	Tolerance mm/in			
25	**33.7**	**+0.41**	**-0.68**	**15.88**	**7.14**	**30.23**	**-0.38**	**1.60**	**34.5**	**1.8**
1	1.327	+0.016	-0.026	0.625	0.281	1.190	-0.015	0.063	1.358	0.071
32	**42.4**	**+0.50**	**-0.60**	**15.88**	**7.14**	**38.99**	**-0.38**	**1.60**	**43.3**	**1.8**
1¼	1.669	+0.020	-0.023	0.625	0.281	1.535	-0.015	0.063	1.705	0.071
40	**48.3**	**+0.44**	**-0.52**	**15.88**	**7.14**	**45.09**	**-0.38**	**1.60**	**49.4**	**1.8**
1½	1.900	+0.017	-0.020	0.625	0.281	1.779	-0.015	0.063	1.945	0.071
50	**60.3**	**+0.61**	**-0.61**	**15.88**	**8.74**	**57.15**	**-0.38**	**1.60**	**62.2**	**1.8**
2	2.375	+0.024	-0.024	0.625	0.344	2.250	-0.015	0.063	2.449	0.071
65	**73.0**	**+0.74**	**-0.74**	**15.88**	**8.74**	**69.09**	**-0.46**	**1.98**	**75.2**	**2.3**
2½	2.875	+0.029	-0.029	0.625	0.344	2.720	-0.018	0.078	2.961	0.091
65	**76.1**	**+0.76**	**-0.76**	**15.88**	**8.74**	**72.26**	**-0.46**	**1.99**	**77.7**	**2.3**
2½	3.000	+0.030	-0.030	0.625	0.344	2.845	-0.018	0.078	3.059	0.091
80	**88.9**	**+0.89**	**-0.79**	**15.88**	**8.74**	**84.94**	**-0.46**	**1.98**	**90.6**	**2.3**
3	3.500	+0.035	-0.031	0.625	0.344	3.344	-0.018	0.078	3.567	0.091
100	**108.0**	+1.07	-0.79	15.88	8.74	103.73	-0.51	2.11	109.7	2.3
4	4.250	+0.042	-0.031	0.625	0.344	4.084	-0.020	0.083	4.319	0.091
100	**114.3**	**+1.14**	**-0.79**	**15.88**	**8.74**	**110.08**	**-0.51**	**2.11**	**116.2**	**2.3**
4	4.500	+0.045	-0.031	0.625	0.344	4.334	-0.020	0.083	4.575	0.091
125	**133.0**	+1.32	-0.79	15.88	8.74	129.13	-0.51	2.11	134.9	2.9
5	5.250	+0.052	-0.031	0.625	0.344	5.084	-0.020	0.083	5.311	0.114
125	**139.7**	**+1.40**	**-0.79**	**15.88**	**8.74**	**135.48**	**-0.51**	**2.11**	**141.7**	**2.9**
5	5.500	+0.055	-0.031	0.625	0.344	5.334	-0.020	0.083	5.579	0.114
125	**141.3**	+1.42	-0.79	15.88	8.74	137.03	-0.56	2.13	143.5	2.9
5	5.563	+0.056	-0.031	0.625	0.344	5.395	-0.022	0.084	5.650	0.114
150	**159.0**	+1.60	-0.79	15.88	8.74	154.50	-0.56	2.16	161.0	2.9
6	6.250	+0.063	-0.031	0.625	0.344	6.083	-0.022	0.085	6.339	0.114
150	**165.1**	+1.60	-0.79	15.88	8.74	160.8	-0.56	2.16	167.1	2.9
6	6.500	+0.063	-0.031	0.625	0.344	6.330	-0.022	0.085	6.579	0.114
150	**168.3**	**+1.60**	**-0.79**	**15.88**	**8.74**	**163.96**	**-0.56**	**2.16**	**170.7**	**2.9**
6	6.625	+0.063	-0.031	0.625	0.344	6.455	-0.022	0.085	6.720	0.114
200A	**216.3**	+1.60	-0.79	19.05	11.91	211.60	-0.64	2.35	219.8	2.9
8	8.516	+0.063	-0.031	0.750	0.469	8.331	-0.025	0.093	8.653	0.114
200	**219.1**	**+1.60**	**-0.79**	**19.05**	**11.91**	**214.40**	**-0.64**	**2.34**	**221.5**	**2.9**
8	8.625	+0.063	-0.031	0.750	0.469	8.441	-0.025	0.092	8.720	0.114
250A	**267.4**	+1.60	-0.79	19.05	11.91	262.60	-0.69	2.40	270.9	3.6
10	10.528	+0.063	-0.031	0.750	0.469	10.339	-0.027	0.095	10.665	0.142
250	**273.0**	**+1.60**	**-0.79**	**19.05**	**11.91**	**268.28**	**-0.69**	**2.39**	**275.4**	**3.6**
10	10.750	+0.063	-0.031	0.750	0.469	10.562	-0.027	0.094	10.842	0.142
300A	**318.5**	+1.60	-0.79	19.05	11.91	312.90	-0.76	2.77	322.0	4.0
12	12.539	+0.063	-0.031	0.750	0.469	12.319	-0.030	0.109	12.677	0.158
300	**323.9**	**+1.60**	**-0.79**	**19.05**	**11.91**	**318.29**	**-0.76**	**2.77**	**326.2**	**4.0**
12	12.750	+0.063	-0.031	0.750	0.469	12.531	-0.030	0.109	12.842	0.158
350	**377.0**	**+1.60**	**-0.79**	**23.83**	**11.91**	**371.44**	**-0.76**	**2.77**	**379.5**	**4.5**
14	14.842	+0.063	-0.031	0.938	0.469	14.623	-0.030	0.109	14.941	0.177
400	**426.0**	**+1.60**	**-0.79**	**23.83**	**11.91**	**420.46**	**-0.76**	**2.77**	**428.5**	**4.5**
16	16.772	+0.063	-0.031	0.938	0.469	16.553	-0.030	0.109	16.870	0.177
500	**529.0**	**+1.60**	**-0.79**	**25.40**	**11.91**	**523.46**	**-0.76**	**2.77**	**533.0**	**5.0**
20	20.827	+0.063	-0.031	1.000	0.469	20.608	-0.030	0.109	20.984	0.197

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