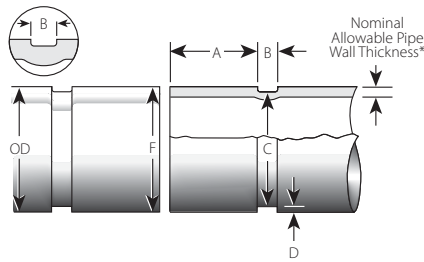


Victaulic OGS-200 Roll Groove Specifications for IPS and Metric Steel Pipe



25.12

1.0 DIMENSIONS



Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵ (ref.)	Max. Allow. Flare Diameter "F" ⁶
	Actual	Tolerance				Max	Min		
inches DN	inches mm	Max inches mm	Min inches mm	inches mm	±0.010 inches ±0.25 mm	inches mm	inches mm	inches mm	inches mm
2 DN50	2.375 60.3	2.399 60.9	2.351 59.7	1.000 ±0.031 25.40 ±0.79	0.344 ±0.010 8.74 ±0.25	2.250 57.2	2.235 56.8	0.063 1.6	2.404 61.1
2½	2.875 73.0	2.904 73.8	2.846 72.3			2.720 69.1	2.702 68.6	0.078 2.0	2.909 73.9
DN65	3.000 76.1	3.030 77.0	2.970 75.4			2.845 72.3	2.827 81.8	0.078 2.0	3.035 77.1
3 DN80	3.500 88.9	3.535 89.8	3.469 88.1			3.344 84.9	3.326 84.5	0.078 2.0	3.540 89.9
4 DN100	4.500 114.3	4.545 115.4	4.469 113.5	1.125 ±0.031/-0.063 28.58 ±0.79/-1.60		4.334 110.1	4.314 109.6	0.083 2.1	4.575 116.2
DN125	5.500 139.7	5.556 141.1	5.469 138.9			5.334 135.5	5.314 135.0	0.083 2.1	5.586 141.9
6 DN150	6.500 165.1	6.563 166.7	6.469 164.3			6.330 160.8	6.308 160.2	0.085 2.2	6.593 167.5
8 DN200	8.625 219.1	8.688 220.7	8.594 218.3			8.441 214.4	8.416 213.8	0.092 2.3	8.698 220.8

- Outside diameter:** The outside diameter of roll grooved pipe shall not vary more than the tolerance listed. For IPS pipe, the maximum allowable tolerance from square cut ends is 0.032"/0.81 mm for 2 – 3"/DN50 – DN80; and 0.063"/1.60 mm for 4 – 8"/DN100 – DN200, measured from true square line.
- Gasket seat "A":** The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled end pipe, the gasket seat "A" is measured from the end of the pipe. IMPORTANT: Roll grooving of beveled end pipe may result in unacceptable pipe end flare. See Maximum Allowable Flare Diameter column.
- Groove width "B":** Bottom of groove to be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembling.
- Groove diameter "C":** The groove must be of uniform depth for the entire pipe circumference. Groove must be maintained within the "C" diameter tolerance listed.
- Groove depth "D":** For reference only. Groove must conform to the groove diameter "C" listed.
- Maximum allowable pipe end flare diameter "F":** Measured at the most extreme pipe end diameter square cut or beveled.

NOTES

- Do not apply coatings to the gasket seat "A" nor within the groove width "B" on the pipe exterior.
- Any corrective action to gasket seat "A" to provide a good sealing surface as required in footnote #2 (listed above) must not result in file, grind or sand marks going across gasket seat "A."
- Roll grooving removes no metal, cold forming a groove by the action of an outer grooving roll being forced into pipe as it is rotated by an inner support roll.
- For use on Schedules 40 and 80 carbon steel pipe; metric carbon steel pipe of equivalent thickness per EN 10216-2 P265GH and EN 10217-1 P265TR1/P265TR2; thin wall metric carbon steel pipe per EN 10216-1 P235TR1; and Schedule 40S stainless steel pipe per ASTM A312 Grade TP316 as specified in [publication 100.02](#): Victaulic High Performance Rigid Coupling: Style 870.

ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.

System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	



2.0 GROOVING

Tools Recommended for OGS-200 Roll Sets

Carbon Steel Pipe: Schedules 40 & 80 and Metric Pipe of Equivalent Thickness, and Thin Wall Metric Pipe⁷

Pipe Material		VE272SFS VE270FSD VE268 inches DN	Part Number	VE416FSD inches DN	Part Number	VE460 inches DN	Part Number
Carbon Steel	Schedule 40	2 – 3 DN50 – DN80	R9S2268003	4 – 6 DN100 – DN150	R9S4416006	8 DN200	R9QS460008
		4 – 6 DN100 – DN150	R9S4268006				
	Schedule 80	2 – 3 DN50 – DN80	R9S2268003	4 – 6 DN100 – DN150	R9S4416006	8 DN200	R9QS460008

Stainless Steel Pipe: Schedule 40

Pipe Material		VE272SFS VE270FSD VE268 inches DN	Part Number	VE416FSD inches DN	Part Number	VE460 inches DN	Part Number
Stainless Steel	Schedule 40	2 – 3 DN50 – DN80	RXS2268003	4 – 6 DN100 – DN150	RXS4416006	8 DN200	RXS8460008
		4 – 6 DN100 – DN150	RXS4268006				

⁷ As specified in [publication 100.02](#): Victaulic High Performance Rigid Coupling; Style 870

NOTES

- Victaulic R9S roll sets must be used when grooving Schedules 40 and 80 carbon steel pipe; metric carbon steel pipe of equivalent thickness and thin wall metric carbon steel pipe to Victaulic OGS-200 groove specifications. Victaulic R9S roll sets must be ordered separately. They are identified by the designation "R9S" on the front of the roll set, as well as a red color stripe on both the upper and lower roll.
- Victaulic RXS roll sets must be used when grooving schedule 40 stainless steel pipe to Victaulic OGS-200 groove specifications. Victaulic RXS roll sets must be ordered separately. They are identified by the designation "RXS" on the front of the roll set, as well as a red color stripe on both the upper and lower roll.

Model RG1200 Maximum Pipe Size and Wall Thickness Capacity

Model	Pipe Material	Pipe Size inches DN				
		2 DN50	2½	3 DN80	4 DN100	6 DN150
RG1200	Carbon Steel	Schedule 40 - 80 3.91 - 7.62 mm			Schedule 40 6.02 - 7.11 mm	

Model RG1210 Maximum Pipe Size and Wall Thickness Capacity

Model	Pipe Material	Pipe Size inches DN							
		2 50	2½	76.1 mm	3 80	4 100	139.7 mm	6 150	165.1 mm
RG1210	Carbon steel	Sch. 40 – 80 3.9 – 8.6 mm				Sch. 40 6.0 – 8.2 mm			

3.0 REFERENCE MATERIALS

[05.10: Victaulic Chemical Compatibility Guide for the Style 870 High Performance Rigid Coupling Seal Assembly](#)

[24.01: Victaulic Pipe Preparation Tools](#)

[24.11: Victaulic In-Place OGS-200 Roll Grooving Tool Model RG1200](#)

[24.14: Victaulic OGS-200 Roll Grooving Tool Model RG1210](#)

[100.01: Victaulic OGS-200 Grooved End Fittings](#)

[100.02: Victaulic Rigid Coupling Style 870](#)

[100.12: Victaulic Gate Valve Series 871](#)

[100.13: Victaulic Flexible Loop for Steam Series 159](#)

[I-870 Installation Instructions Style 870 Rigid Coupling](#)

[TM-RG1200: Victaulic Operating and Maintenance Instructions Manual RG1200 Roll Grooving Tool](#)

[TM-RG1210: Victaulic Operating and Maintenance Instructions Manual RG1210 Roll Grooving Tool](#)

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