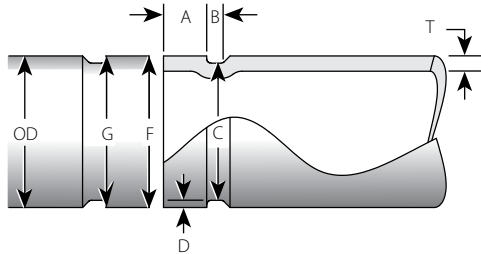


DIMENSIONS

IGS Roll Groove Specifications



Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵ (ref.)	Groove Shoulder "G" ⁶	Minimum Nominal Allowable Pipe Wall Thk. "T" ⁷	Allowable Flare Diameter "F" ⁸
	Actual	Tolerance				Max	Min				
		inches	mm								
1	1.315	1.346	1.300	.375±.030	.150 + .010/ -.010	1.190	1.170	0.063	1.260	0.109	1.370
DN25	33.4	34.2	33.0	9.53±0.76	3.81 + 0.25/ -0.25	30.2	29.7	1.6	32.0	2.77	34.8

- ¹ **Outside Diameter:** The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- ² **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. The maximum allowable tolerance from square-cut pipe ends is 1/32"/0.79 mm. This is measured from the true square line. When using beveled end pipe, the gasket seat "A" is measured from the end of the pipe.
- ³ **Groove Width "B":** Bottom of groove to be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembling. Corners at bottom of groove must be radiused.
- ⁴ **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.
- ⁵ **Groove Depth "D":** For reference only. Groove must conform to the groove diameter "C" listed.
- ⁶ **Groove Shoulder "G":** The minimum diameter of the front side of the groove after the pipe has been roll grooved.
- ⁷ **Minimum Nominal Allowable Pipe Wall Thickness "T":** This is the minimum nominal allowable pipe wall thickness which shall be roll grooved.
- ⁸ **Maximum Allowable Flare "F":** Measured at the most extreme pipe end diameter square cut or beveled.

NOTES

- The coating thickness applied to the gasket seating surface and within the groove on the pipe exterior shall not exceed .010"/0.25mm.
- For use on schedule 10 and 40 IPS carbon steel pipe. Contact Victaulic for all other pipe material inquiries
- Roll grooving removes no metal, cold forming a groove by the action of outer grooving rolls being forced into pipe as it is rotated.

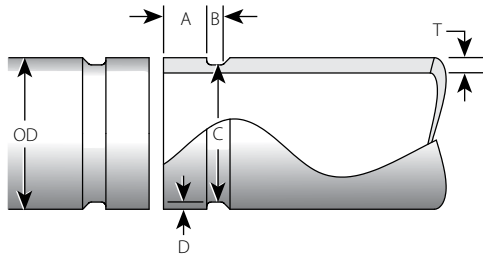
ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.

System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	

DIMENSIONS

IGS Cut Groove Specifications



Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵ (ref.)	Minimum Nominal Allowable Pipe Wall Thickness "T" ⁶
	Actual	Tolerance				Max	Min		
		inches	mm						
1	1.315	1.346	1.300	.375±.030	.140 +.010/-0.000	1.190	1.175	0.063	0.133
DN25	33.4	34.2	33.0	9.53±0.76	3.56 + 0.25/-0.00	30.2	29.9	1.6	3.4

- ¹ **Outside diameter:** The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- ² **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. The maximum allowable tolerance from square-cut pipe ends is 1/32"/0.79 mm. This is measured from the true square line. When using beveled end pipe, the gasket seat "A" is measured from the end of the pipe.
- ³ **Groove width "B":** Bottom of groove to be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembling. Corners at bottom of groove must be radiused. (.040"±/.015")
- ⁴ **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.
- ⁵ **Groove depth "D":** For reference only. Groove must conform to the groove diameter "C" listed.
- ⁶ **Minimum Nominal Allowable Pipe Wall Thickness "T":** This is the minimum nominal allowable pipe wall thickness which may be cut grooved.

NOTES

- The coating thickness applied to the gasket seating surface and within the groove on the pipe exterior shall not exceed .010"/0.25mm.
- For use on schedule 40 IPS carbon steel pipe. Contact Victaulic for all other pipe material inquiries.

REFERENCE MATERIALS

[10.54: Victaulic IGS Groove System](#)

[10.85: VicFlex™ Series AH2-CC Hose](#)

[24.01: Victaulic Pipe Preparation Tools](#)

[I-100: Victaulic Field Installation Handbook](#)

[I-101-103: FireLock™ Installation-Ready™ Fittings Installation Instructions](#)

[I-102: FireLock™ Installation-Ready™ Fittings Installation Instructions](#)

[I-108: Style 108 FireLock™ Installation-Ready™ Coupling Installation Instructions](#)

[TM-RG2100: Operating and Maintenance Instructions Manual](#)

User Responsibility for Product Selection and Suitability

Each user bears final responsibility for making a determination as to the suitability of Victaulic products for a particular end-use application, in accordance with industry standards and project specifications, and the applicable building codes and related regulations as well as Victaulic performance, maintenance, safety, and warning instructions. Nothing in this or any other document, nor any verbal recommendation, advice, or opinion from any Victaulic employee, shall be deemed to alter, vary, supersede, or waive any provision of Victaulic Company's standard conditions of sale, installation guide, or this disclaimer.

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