SERRAGE HYDRAULIQUE
ULTRA TORQ
HYDRAULIC BOLTING
VENTE ET LOCATION
SALES & RENTALS

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Technical Data

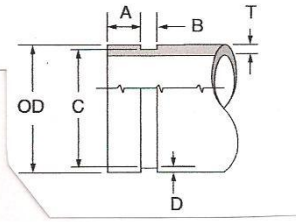
1- The maximum allowable tolerances for IPS Pipe from square cut ends is: 0.030" (0.76mm) for sizes 1¼" thru 3"; 0.045" (1.14mm) for sizes 4" thru 6"; and 0.060" (1.52mm) for sizes 8" and above.

2- Gasket Seating Surface "A" must be free from score marks, ridges, indentations, projections, loose paint, scale, dirt chips, grease, rust, etc. that would prevent a positive seal.

3- Groove Diameter "C" must be uniform depth around the circumference of the pipe.

4- Groove Depth "D" is a reference dimension only. The Groove Diameter "C" must be maintained.

5- Minimum Wall Thickness "T" is the minimum wall thickness that should be cut grooved.



Standard Cut Groove Specifications

Nominal Pipe Size	Pipe O.D. Inches / mm	Tolerance +	Tolerance -	A ± 0.030" ± 0.76mm Inches / mm	B ± 0.030" ± 0.76mm Inches / mm	C Groove Diameter Inches / mm Actual	C Tol.+0.000	D Nominal Groove Depth Inches / mm	T Minimum Wall Inches / mm
1¼"	1.660	0.016	0.016	0.625	0.313	1.535	-0.015	0.062	0.140
	42.4	*0.41*	*0.41*	*15.88*	*7.95*	*38.99*	*-0.38*	*1.60*	*3.56*
1½"	1.900	0.019	0.019	0.625	0.313	1.775	-0.015	0.062	0.145
	48.3	*0.48*	*0.48*	*15.88*	*7.95*	*45.09*	*-0.38*	*1.60*	*3.68*
2"	2.375	0.024	0.024	0.625	0.313	2.250	-0.015	0.062	0.154
	60.3	*0.61*	*0.61*	*15.88*	*7.95*	*57.15*	*-0.38*	*1.60*	*3.91*
2½"	2.875	0.029	0.029	0.625	0.313	2.720	-0.018	0.078	0.188
	73.0	*0.74*	*0.74*	*15.88*	*7.95*	*69.09*	*-0.46*	*1.98*	*4.78*
76.1mm	3.000	0.030	0.030	0.625	0.313	2.845	-0.018	0.076	0.188
	76.1	*0.76*	*0.76*	*15.88*	*7.95*	*72.26*	*-0.46*	*1.93*	*4.78*
3"	3.500	0.035	0.031	0.625	0.313	3.344	-0.018	0.078	0.188
	88.9	*0.89*	*0.79*	*15.88*	*7.95*	*84.94*	*-0.46*	*1.98*	*4.78*
108.0mm	4.250	0.042	0.031	0.625	0.375	4.084	-0.020	0.083	0.203
	108.0	*1.07*	*0.79*	*15.88*	*9.53*	*103.73*	*-0.51*	*2.11*	*5.16*
4"	4.500	0.045	0.031	0.625	0.375	4.334	-0.020	0.083	0.203
	114.3	*1.14*	*0.79*	*15.88*	*9.53*	*110.08*	*-0.51*	*2.11*	*5.16*
133.0mm	5.250	0.052	0.031	0.625	0.375	5.084	-0.020	0.083	0.203
	133.0	*1.32*	*0.79*	*15.88*	*9.53*	*129.13*	*-0.51*	*2.11*	*5.16*
139.7mm	5.500	0.056	0.031	0.625	0.375	5.334	-0.020	0.083	0.203
	139.7	*1.42*	*0.79*	*15.88*	*9.53*	*135.48*	*-0.51*	*2.11*	*5.16*
5"	5.563	0.056	0.031	0.625	0.375	5.395	-0.022	0.084	0.203
	141.3	*1.42*	*0.79*	*15.88*	*9.53*	*137.03*	*-0.56*	*2.13*	*5.16*
159.0mm	6.250	0.063	0.031	0.625	0.375	6.084	-0.022	0.083	0.219
	159.0	*1.60*	*0.79*	*15.88*	*9.53*	*154.53*	*-0.56*	*2.11*	*5.56*
165.1mm	6.500	0.063	0.031	0.625	0.375	6.330	-0.022	0.085	0.219
	165.1	*1.60*	*0.79*	*15.88*	*9.53*	*160.78*	*-0.56*	*2.16*	*5.56*
6"	6.625	0.063	0.031	0.625	0.375	6.455	-0.022	0.085	0.219
	168.3	*1.60*	*0.79*	*15.88*	*9.53*	*163.96*	*-0.56*	*2.16*	*5.56*
216.3mm	8.516	0.063	0.031	0.750	0.438	8.331	-0.025	0.092	0.238
	216.3	*1.60*	*0.79*	*19.05*	*11.13*	*211.61*	*-0.64*	*2.34*	*6.05*
8"	8.625	0.063	0.031	0.750	0.438	8.441	-0.025	0.092	0.238
	219.1	*1.60*	*0.79*	*19.05*	*11.13*	*214.40*	*-0.64*	*2.34*	*6.05*
10"	10.750	0.063	0.031	0.750	0.500	10.562	-0.027	0.094	0.250
	273.0	*1.60*	*0.79*	*19.05*	*12.70*	*268.27*	*-0.69*	*2.39*	*6.35*
12"	12.750	0.063	0.031	0.750	0.500	12.531	-0.030	0.109	0.279
	323.9	*1.60*	*0.79*	*19.05*	*12.70*	*318.19*	*-0.76*	*2.77*	*7.09*