

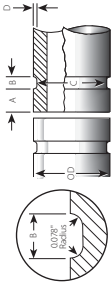
GROOVE SPECIFICATIONS

Cut Groove Specifications for Standard or Heavier-Wall Pipe or Plastic-Coated Pipe Joined with Style HP-70ES EndSeal Couplings †

Size		Dimensions – inches/millimeters														
		Actual Pipe Outside Diameter		Pipe Outside Diameter			Gasket Seat "A"			Groove Width "B"			Groove Diameter "C"		Groove Depth "D" (ref.)	Min. Allow. Wall Thick. "T"
Nominal Size Inches	Inches/mm	Max.	Min.	Basic	Max.	Min.	Basic	Max.	Min.	Basic	Max.	Min.	Max.	Min.		
2	2.375	2.399	2.351	0.562	0.572	0.552	0.255	0.265	0.250	0.255	0.265	0.250	2.250	2.235	0.063	0.154
	60.3	60.9	59.7	14.3	14.5	14.0	6.5	6.7	6.4	6.5	6.7	6.4	57.2	56.8		
2½	2.875	2.904	2.846	0.562	0.572	0.552	0.255	0.265	0.250	0.255	0.265	0.250	2.720	2.702	0.078	0.203
	73.0	73.8	72.3	14.3	14.5	14.0	6.5	6.7	6.4	6.5	6.7	6.4	69.1	68.6		
3	3.500	3.535	3.469	0.562	0.572	0.552	0.255	0.265	0.250	0.255	0.265	0.250	3.344	3.326	0.078	0.216
	88.9	89.8	88.1	14.3	14.5	14.0	6.5	6.7	6.4	6.5	6.7	6.4	84.9	84.5		
4	4.500	4.545	4.469	0.605	0.620	0.590	0.305	0.315	0.300	0.305	0.315	0.300	4.334	4.314	0.083	0.237
	114.3	115.4	113.5	15.4	15.7	15.0	7.7	8.0	7.6	7.7	8.0	7.6	110.1	109.6		
6	6.625	6.688	6.594	0.605	0.620	0.590	0.305	0.315	0.300	0.305	0.315	0.300	6.455	6.433	0.085	0.280
	168.3	169.9	167.5	15.4	15.7	15.0	7.7	8.0	7.6	7.7	8.0	7.6	164.0	163.4		
8	8.625	8.688	8.594	0.714	0.729	0.699	0.400	0.410	0.390	0.400	0.410	0.390	8.441	8.416	0.092	0.322
	219.1	220.7	218.3	18.1	18.5	17.8	10.2	10.4	9.9	10.2	10.4	9.9	214.4	213.8		
10	10.750	10.813	10.719	0.714	0.729	0.699	0.400	0.410	0.390	0.400	0.410	0.390	10.562	10.535	0.094	0.365
	273.0	274.7	272.3	18.1	18.5	17.8	10.2	10.4	9.9	10.2	10.4	9.9	268.3	267.6		
12	12.750	12.813	12.719	0.714	0.729	0.699	0.400	0.410	0.390	0.400	0.410	0.390	12.531	12.501	0.109	0.375
	323.9	325.5	323.1	18.1	18.5	17.8	10.2	10.4	9.9	10.2	10.4	9.9	318.3	317.5		

† Coatings applied to the interior surfaces, including bolt pad mating surfaces, must not exceed 0.010inch/0.3mm. In addition, the coating thickness applied to the gasket-sealing surface and within the groove on the pipe exterior must not exceed 0.010inch/0.3mm.

GROOVE SPECIFICATIONS



Standard Radius Cut Grooving Specifications for Schedule 80 or Schedule 40 PVC Plastic Pipe (ASTM D-1785-70) †

Size		Dimensions – inches/millimeters											
		Pipe Outside Diameter		Gasket Seat "A"		Groove Width "B"			Groove Diameter "C"		Groove Depth "D" (ref.)		
Nominal Size inches	Actual Pipe Outside Diameter inches/mm	Max.	Min.	Max.	Min.	Basic	Max.	Min.	Max.	Min.	Max.	Min.	Max.
¾	1.050	1.062	1.038	0.656	0.594	0.312	0.343	0.281	0.938	0.923	0.056		
	26.9	27.0	26.4	16.7	15.1	7.9	8.7	7.1	23.8	23.4	1.4		
1	1.315	1.327	1.303	0.656	0.594	0.312	0.343	0.281	1.190	1.175	0.062		
	33.7	33.7	33.1	16.7	15.1	7.9	8.7	7.1	30.2	29.8	1.6		
1 ¼	1.660	1.672	1.648	0.656	0.594	0.312	0.343	0.281	1.535	1.520	0.062		
	42.4	42.5	41.9	16.7	15.1	7.9	8.7	7.1	39.0	38.6	1.6		
1 ½	1.900	1.912	1.888	0.656	0.594	0.312	0.343	0.281	1.775	1.760	0.062		
	48.3	48.6	48.0	16.7	15.1	7.9	8.7	7.1	45.1	44.7	1.6		
2	2.375	2.387	2.363	0.656	0.594	0.312	0.343	0.281	2.250	2.235	0.062		
	60.3	60.6	60.0	16.7	15.1	7.9	8.7	7.1	57.2	56.8	1.6		
2 ½	2.875	2.887	2.863	0.656	0.594	0.312	0.343	0.281	2.720	2.702	0.078		
	73.0	73.3	72.7	16.7	15.1	7.9	8.7	7.1	69.1	68.6	2.0		
3	3.500	3.515	3.485	0.656	0.594	0.312	0.343	0.281	3.344	3.326	0.078		
	88.9	89.3	88.5	16.7	15.1	7.9	8.7	7.1	84.9	84.5	2.0		
4	4.500	4.520	4.480	0.656	0.594	0.375	0.406	0.344	4.334	4.314	0.083		
	114.3	114.8	113.8	16.7	15.1	9.5	10.3	8.7	110.1	109.6	2.1		

† See note on page 34
Rigid, angle-bolt-pad couplings are not recommended for use with PVC plastic pipe.

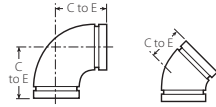
FITTINGS FOR JIS PIPE

No. 10 – JIS 90 Elbow

No. 11 – JIS 45 Elbow

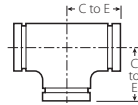
No. 20 – JIS Tee

Size		No. 10 90° Elbow	No. 11 45° Elbow	No. 20 Tee
Nominal Size mm/inches	JIS OD mm/inches	C to E mm/inches	C to E mm/inches	C to E mm/inches
200A 8	216.3 8.515	197 7.75	108 4.25	197 7.75
250A 10	267.4 10.528	229 9.00	121 4.75	229 9.00
300A 12	318.5 12.539	254 10.00	133 5.25	254 10.00



No. 10

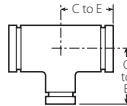
No. 11



No. 20

Fittings made to US standard sizes are available from 200A – 600A, which are compatible with JIS standards. Contact Victaulic for details.

No. 25 – JIS Reducing Tee



No. 25

Size				C to E Run		C to E Branch	
Nominal Size mm/inches		JIS OD mm/inches		mm/ inches	mm/ inches	mm/ inches	mm/ inches
200A 8	200A 8	165 6½	216.3 8.515	216.3 8.515	165.1 6.500	198.1 7.8	198.1 7.8
250A 10	250A 10	200A 8	267.4 10.528	267.4 10.528	216.3 8.515	228.6 9.0	228.6 9.0
300A 12	300A 12	250A 10	318.5 12.539	318.5 12.539	267.4 10.528	254.0 10.0	254.0 10.0

Fittings made to US standard sizes are available from 200A – 600A, which are compatible with JIS standards. Contact Victaulic for details.

No. 50 – JIS Concentric Reducer

Size		E to E		
Nominal Size mm/inches	JIS OD mm/inches	mm/ inches	mm/ inches	
200A 8	165 6½	216.3 8.515	165.1 6.500	127.0 5.00
250A 10	200A 8	267.4 10.528	216.3 8.515	152.4 6.00
300A 12	250A 10	318.5 12.539	267.4 110.528	177.8 7.00



No. 50

Fittings made to US standard sizes are available from 200A – 600A, which are compatible with JIS standards. Contact Victaulic for details.



Always refer to the current Victaulic submittal publication in the G-100 General Catalog or on the website www.victaulic.com for the most up-to-date dimensional information.

