

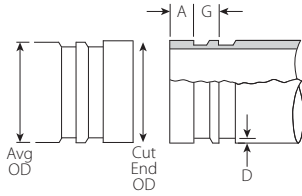
High Density Polyethylene (HDPE) Cut Groove Specifications



25.16

DIMENSIONS

High Density Polyethylene (HDPE) Cut Groove Specifications



IPS Size		Cut End OD Min. ¹ inches	Dimensions							
Nominal inches	Average Outside Diameter inches mm		Gasket Seat "A"			Groove Depth "D"		Groove Index "G"		
			Basic inches mm	Maximum inches mm	Minimum inches mm	Maximum inches mm	Minimum inches mm	Basic inches mm	Maximum inches mm	Minimum inches mm
8	8.625 219.1	8.460	1.518 38.56	1.543 39.20	1.493 37.92	.235 5.97	.195 4.95	.800 20.32	.810 20.57	.790 20.07
10	10.750 273.1	10.54	1.518 38.56	1.543 39.20	1.493 37.92	.280 7.12	.240 6.10	.800 20.32	.810 20.57	.790 20.07
12	12.750 323.9	12.50	1.518 38.56	1.543 39.20	1.493 37.92	.300 7.62	.260 6.60	.800 20.32	.810 20.57	.790 20.07
14	14.000 355.6	13.73	1.518 38.56	1.543 39.20	1.493 37.92	.300 7.62	.260 6.60	.800 20.32	.810 20.57	.790 20.07
16	16.000 406.4	15.69	2.074 52.68	2.099 53.32	2.049 52.04	.340 8.64	.300 7.62	1.239 31.47	1.249 31.72	1.229 31.22
18	18.000 457.2	17.65	2.074 52.68	2.099 53.32	2.049 52.04	.380 9.66	.340 8.64	1.239 31.47	1.249 31.72	1.229 31.22
20	20.000 508.0	19.61	2.074 52.68	2.099 53.32	2.049 52.04	.430 10.93	.390 9.91	1.239 31.47	1.249 31.72	1.229 31.22
22	22.000 558.8	21.57	2.074 52.68	2.099 53.32	2.049 52.04	.460 11.69	.420 10.67	1.239 31.47	1.249 31.72	1.229 31.22
24	24.000 609.6	23.53	2.750 69.85	2.775 70.49	2.725 69.21	.490 12.45	.450 11.43	1.837 46.66	1.847 46.91	1.827 46.41
28	28.000 711.2	27.45	2.750 69.85	2.775 70.49	2.725 69.21	.460 11.69	.420 10.67	1.837 46.66	1.847 46.91	1.827 46.41
30	30.000 762.0	29.42	2.750 69.85	2.775 70.49	2.725 69.21	.510 12.96	.470 11.94	1.837 46.66	1.847 46.91	1.827 46.41
32	32.000 812.8	31.38	2.750 69.85	2.775 70.49	2.725 69.21	.510 12.96	.470 11.94	1.837 46.66	1.847 46.91	1.827 46.41
36	36.000 914.4	35.30	2.750 69.85	2.775 70.49	2.725 69.21	.575 14.61	.535 13.59	1.837 46.66	1.847 46.91	1.827 46.41

¹ Cut End Minimum (measured at cut end of pipe) = average OD - OD tolerance per ASTM F714 - 1.5% toe in.

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

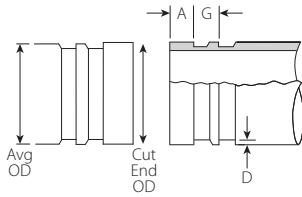
System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	



DIMENSIONS (Continued)

High Density Polyethylene (HDPE) Cut Groove Specifications



ISO Size		Cut End OD Min. ² mm	Dimensions							
Nominal mm	Minimum Outside Diameter mm inches		Gasket Seat "A"			Groove Depth "D"		Groove Index "G"		
			Basic mm inches	Maximum mm inches	Minimum mm inches	Maximum mm inches	Minimum mm inches	Basic mm inches	Maximum mm inches	Minimum mm inches
250	250.0 9.843	246.20	38.56 1.518	39.20 1.543	37.92 1.493	6.61 .260	5.59 .220	20.32 .800	20.57 .810	20.07 .790
280	280.0 11.024	275.80	38.56 1.518	39.20 1.543	37.92 1.493	7.37 .290	6.35 .250	20.32 .800	20.57 .810	20.07 .790
315	315.0 12.402	310.30	38.56 1.518	39.20 1.543	37.92 1.493	7.62 .300	6.60 .260	20.32 .800	20.57 .810	20.07 .790
355	355.0 13.976	349.70	38.56 1.518	39.20 1.543	37.92 1.493	7.62 .300	6.60 .260	20.32 .800	20.57 .810	20.07 .790
400	400.0 15.748	394.00	52.68 2.074	53.32 2.099	52.04 2.049	8.64 .340	7.62 .300	31.47 1.239	31.72 1.249	31.22 1.229
450	450.0 17.717	443.20	52.68 2.074	53.32 2.099	52.04 2.049	9.66 .380	8.64 .340	31.47 1.239	31.72 1.249	31.22 1.229
500	500.0 19.685	492.50	52.68 2.074	53.32 2.099	52.04 2.049	10.93 .430	9.91 .390	31.47 1.239	31.72 1.249	31.22 1.229
560	560.0 22.047	551.60	52.68 2.074	53.32 2.099	52.04 2.049	11.69 .460	10.67 .420	31.47 1.239	31.72 1.249	31.22 1.229
630	630 24.803	620.50	69.85 2.750	70.49 2.775	69.21 2.725	12.45 .490	11.43 .450	46.66 1.837	46.91 1.847	46.41 1.827
710	710.0 27.953	699.30	69.85 2.750	70.49 2.775	69.21 2.725	11.69 .460	10.67 .420	46.66 1.837	46.91 1.847	46.41 1.827
800	800.0 31.496	787.90	69.85 2.750	70.49 2.775	69.21 2.725	12.96 .510	11.94 .470	46.66 1.837	46.91 1.847	46.41 1.827
900	900.0 35.433	886.40	69.85 2.750	70.49 2.775	69.21 2.725	14.61 .575	13.59 .535	46.66 1.837	46.91 1.847	46.41 1.827

² Cut End Minimum (measured at cut end of pipe) = average OD - OD tolerance per ISO 4427-2 - 1.5% toe in.

REFERENCE MATERIALS

[19.09: Victaulic Coupling for Double Grooved HDPE Pipe Style 908](#)

[24.06: Cut Grooving Tools for HDPE Pipe Models CG3100, CG3300 and CG3500](#)

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

[I-900: Field Installation Handbook](#)

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