

Nominal Size (Inches/DN)	Pipe Outside Diameter			Gasket Seat A ±0.03"	Groove Width B ±0.03"	Groove Diameter C		Groove Depth D (Ref.)	Min. Allow. Wall Thick. T
	Basic	Tolerance				Basic	Tol. +0.00"		
1" / 25	1,315	+ 0.013	- 0.013	0.625	0.313	1.190	- 0.015	0.063	0.133
1¼" / 32	1,660	+ 0.016	- 0.016	0.625	0.313	1.535	- 0.015	0.063	0.140
1½" / 40	1,900	+ 0.019	- 0.019	0.625	0.313	1.775	- 0.015	0.063	0.145
2" / 50	2,375	+ 0.024	- 0.024	0.625	0.313	2.250	- 0.015	0.063	1.154
2½" / 65	2,875	+ 0.029	- 0.029	0.625	0.313	2.720	- 0.018	0.078	0.188
3" OD	3,000	+ 0.030	- 0.030	0.625	0.313	2.845	- 0.018	0.078	0.188
3" / 80	3,500	+ 0.035	- 0.035	0.625	0.313	3.344	- 0.018	0.078	0.188
4" OD	4,250	+ 0.043	- 0.043	0.625	0.375	4.084	- 0.020	0.083	0.213
4" / 100	4,500	+ 0.045	- 0.045	0.625	0.375	4.334	- 0.020	0.083	0.203
5" OD	5,250	+ 0.053	- 0.053	0.625	0.375	5.084	- 0.020	0.083	0.213
5" OD	5,500	+ 0.056	- 0.056	0.625	0.375	5.334	- 0.020	0.083	0.203
5" / 125	5,563	+ 0.056	- 0.056	0.625	0.375	5.395	- 0.020	0.084	0.203
6" OD	6,250	+ 0.063	- 0.063	0.625	0.375	6.032	- 0.022	0.085	0.219
6" OD	6,500	+ 0.063	- 0.063	0.625	0.375	6.330	- 0.022	0.085	0.219
6" / 150	6,625	+ 0.063	- 0.063	0.625	0.375	6.455	- 0.022	0.085	0.219
8" / 200	8,625	+ 0.063	- 0.063	0.750	0.438	8.441	- 0.025	0.092	0.238
10" / 250	10,750	+ 0.063	- 0.063	0.750	0.500	10.562	- 0.027	0.094	0.250
12" / 300	12,750	+ 0.063	- 0.063	0.750	0.500	12.531	- 0.030	0.109	0.279
14" / 350	14,000	+ 0.063	- 0.063	0.938	0.500	13.781	- 0.030	0.109	0.281
16" / 400	16,000	+ 0.063	- 0.063	0.938	0.500	15.781	- 0.030	0.109	0.312

All sizes in inches unless otherwise stated.

**QUIKCOUP grooved-end pipe couplings are designed for use with pipe groove to meet Quikcoup pipe preparation instructions. The following notes are to clarify the headings and data listed in tables, pages 26 and 27.**

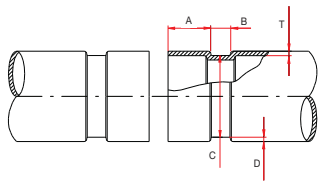
**Column 1**  
Nominal pipe size.

**Column 2**  
Pipe Outside Diameter. The outside diameter of grooved pipe shall not vary more than the tolerance listed. Internal or external weld bead or seams, must be ground flush with the pipe surface, extending 50mm back from the pipe end. Squariness of pipe ends (Max. Deviation from square cut ends):

- up to 3" -> 0.031" (0.8mm)
- 4" to 6" -> 0.047" (1.2mm)
- Over 6" -> 0.062" (1.6mm)

**Column 3**  
"A" Dimension- The "A" dimension or distance from pipe ends to groove provides gasket seating area. This area must be free from indentations, rust or roll marks from the end of the pipe to the groove to provide leaktight seat for the gasket.

**Column 4**  
"B" Dimension - The "B" dimension or groove width controls expansion and angular deflection by the distance it is located from the end of the pipe and its width in relation to the housing "key" width.



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	Basic	Tolerance				Basic	Tol. +0.00"			
1" / 25	1,315	+ 0.013	- 0.013	0.625	0.281	1.190	- 0.015	0.063	0.065	1.430
1¼" / 32	1,660	+ 0.016	- 0.016	0.625	0.281	1.535	- 0.015	0.063	0.065	1.770
1½" / 40	1,900	+ 0.019	- 0.019	0.625	0.281	1.775	- 0.015	0.063	0.065	2.010
2" / 50	2,375	+ 0.024	- 0.024	0.625	0.344	2.250	- 0.015	0.063	0.065	2.480
2½" / 65	2,875	+ 0.029	- 0.029	0.625	0.344	2.720	- 0.018	0.078	0.083	2.980
3" OD	3,000	+ 0.030	- 0.030	0.625	0.344	2.845	- 0.018	0.078	0.083	3.100
3" / 80	3,500	+ 0.035	- 0.035	0.625	0.344	3.344	- 0.018	0.078	0.083	3.600
4" OD	4,250	+ 0.043	- 0.043	0.625	0.344	4.084	- 0.020	0.083	0.091	4.350
4" / 100	4,500	+ 0.045	- 0.045	0.625	0.344	4.334	- 0.020	0.083	0.083	4.600
5" OD	5,250	+ 0.053	- 0.053	0.625	0.344	5.084	- 0.020	0.083	0.109	5.350
5" OD	5,500	+ 0.056	- 0.056	0.625	0.344	5.334	- 0.020	0.083	0.109	5.600
5" / 125	5,563	+ 0.056	- 0.056	0.625	0.344	5.395	- 0.020	0.084	0.109	5.660
6" OD	6,250	+ 0.063	- 0.063	0.625	0.344	6.032	- 0.022	0.085	0.109	6.350
6" OD	6,500	+ 0.063	- 0.063	0.625	0.344	6.330	- 0.022	0.085	0.109	6.600
6" / 150	6,625	+ 0.063	- 0.063	0.625	0.344	6.455	- 0.022	0.085	0.109	6.730
8" / 200	8,625	+ 0.063	- 0.063	0.750	0.469	8.441	- 0.025	0.092	0.109	8.800
10" / 250	10,750	+ 0.063	- 0.063	0.750	0.469	10.562	- 0.027	0.094	0.134	10.920
12" / 300	12,750	+ 0.063	- 0.063	0.750	0.469	12.531	- 0.030	0.109	0.156	12.920
14" / 350	14,000	+ 0.063	- 0.063	0.938	0.469	13.781	- 0.030	0.109	0.156	14.100
16" / 400	16,000	+ 0.063	- 0.063	0.938	0.469	15.781	- 0.030	0.109	0.156	16.100

All sizes in inches unless otherwise stated.

**Column 5**

"C" Dimension - The "C" dimension is the proper diameter at the base of the groove. This must be within diameter tolerance and concentric with the O.D. for proper coupling fit. The groove must be of uniform depth for the entire pipe circumference.

**Column 6**

"D" Dimension -The "D" dimension is the nominal depth of the groove and is reference for a Trial Groove Only. This dimension must be altered if necessary to keep dimension "c" within stated tolerance. The Groove must Conform to the "C" dimension.

**Column 7**

T Dimension - Minimum wall ("T" dimension) is the lightest grade or thickness of pipe suitable for roll grooving or for cut grooving.

**Column 8**

FLARE Standard (Roll Groove Only) - Maximum allowable pipe end flare diameter measured at the most extreme pipe end diameter.