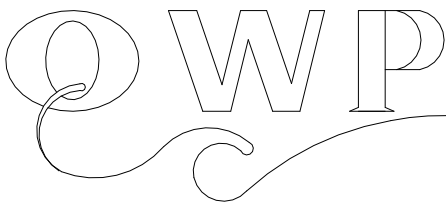


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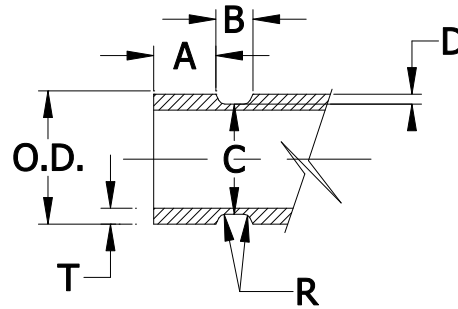
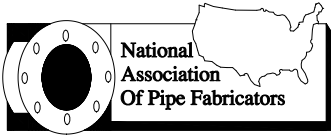
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PIPE GROOVING SPECS. FOR ANSI/AWWA PIPE

PIPE GROOVING SPECIFICATION FOR AWWA PIPE

DUCTILE -IRON PIPE OF AWWA DIMENSIONS AND FITTINGS ARE WITH A RADIUS CONFIGURATION TO ELIMINATE SHARP CORNERS AND POINTS OF STRESS CONCENTRATION. GROOVES MAY BE CAST OR SUBSEQUENTLY CUT INTO CAST PRESSURE PIPE, FITTINGS OR OTHER CONFIGURATIONS. THE RADIUS GROOVE ALLOWS FOR GREATER BEAM LOADS AND WORKING PRESSURE THAN CLASS 125 FLANGE SYSTEMS.

WHEN RIGID RADIUS IS USED, THE PIPE OR FITTING ENDS ARE DRAWN TOGETHER IN CONTACT AS THE COUPLING IS MADE UP , RESULTING IN A RIGID JOINT.

FLEXIBLE RADIUS GROOVING ALLOWS FOR MODERATE CONDITIONS OF PIPE MOVEMENT OF DEFLECTION FROM THERMAL ,SETTLING , SEISMIC OR OTHER ELEMENTS. PIPE IS NORMALLY GROOVE TO FLEXIBLE RADIUS GROOVING DIMENSIONS.

GROOVING DIMENSIONS ARE THE SAME FOR ANY ONE PIPE O.D. REGARDLESS OF PIPE CLASS AND PRESSURE. THE OUTSIDE SURFACE OF PIPE BETWEEN THE GROOVE AND PIPE END MUST BE SMOOTH AND FREE OF LOOSE SCALE, OIL, GREASE,DIRT ,RUST, DEEP PITS OR SWELLS TO PROVIDE A LEAKTIGHT GASKET SEAT.

SIZE IN.	PIPE OD IN.	FLEXIBLE JOINT GASKET SEAT IN. +.016 -.047	RIGID JOINT GASKET SEAT IN. +.0 -.020	GROOVE WIDTH IN. +.031 -.016	GROOVE DIA. 'C' IN.	RADIUS 'R' IN.	DUCTILE IRON PIPE ANSI A21. 51 AWWA C151		GROOVE DEPTH 'D' IN.	
							T (3) INCHES	CLASS	MIN. INCHES	MAX. INCHES
3"	3.96 ^{+0.060} / _{-.060}	.750	.840	.375	3.718 ^{+0.000} / _{-.020}	.120	.31	53	.096	.151
4"	4.80 ^{+0.060} / _{-.060}	.750	.840	.375	4.563 ^{+0.000} / _{-.020}	.120	.32	53	.096	.151
6"	6.90 ^{+0.060} / _{-.060}	.750	.840	.375	6.656 ^{+0.000} / _{-.020}	.120	.34	53	.100	.154
8"	9.05 ^{+0.060} / _{-.060}	.875	.950	.500	8.781 ^{+0.000} / _{-.025}	.145	.36	53	.104	.177
10"	11.10 ^{+0.060} / _{-.060}	.938	1.015	.500	10.813 ^{+0.000} / _{-.025}	.145	.38	53	.114	.186
12"	13.20 ^{+0.060} / _{-.060}	.938	1.015	.500	12.906 ^{+0.000} / _{-.030}	.145	.40	53	.117	.192
14"	15.30 ^{+0.050} / _{-.080}	.938	1.015	.625	14.969 ^{+0.000} / _{-.030}	.165	.42	53	.126	.206
16"	17.40 ^{+0.050} / _{-.080}	1.188	1.340	.625	17.063 ^{+0.000} / _{-.030}	.165	.43	54	.128	.208
18"	19.50 ^{+0.050} / _{-.080}	1.188	1.340	.625	19.125 ^{+0.000} / _{-.030}	.185	.47	55	.148	.228
20"	21.60 ^{+0.050} / _{-.080}	1.188	1.340	.625	21.219 ^{+0.000} / _{-.030}	.185	.51	56	.150	.230
24"	25.80 ^{+0.050} / _{-.080}	1.188	1.340	.625	25.406 ^{+0.000} / _{-.030}	.185	.56	56	.157	.237
30"	32.00 ^{+0.080} / _{-.060}	1.375	1.625	.750	31.500 ^{+0.000} / _{-.035}	.215	.63	56	.195	.283
36"	38.30 ^{-.060} / _{+0.080}	1.375	1.625	.750	37.850 ^{+0.000} / _{-.035}	.215	.73	56	.195	.283
42"	44.50 ^{-.060} / _{+0.080}	1.375	1.625	.750	44.050 ^{+0.000} / _{-.035}	.215	.83	56	.195	.283
48"	50.80 ^{-.060} / _{+0.080}	1.375	1.625	.750	50.350 ^{+0.000} / _{-.035}	.215	.93	56	.195	.283

- (1) GROOVING SPECIFICATIONS FOR NOMINAL PIPE SIZES 4" THRU 24" ARE IN ACCORD WITH AWWA C606 STANDARD FOR GROOVES AND SHOULDRED TYPE JOINTS. OTHER SIZES, NOT COVERED BY THE STANDARD, ARE MANUFACTURERS GROOVING SPECIFICATIONS.
- (2) OVALITY OR OUT-OF-ROUNDNESS MUST LIE WITHIN SPECIFIED TOLERANCES AND CONFORM TO ANSI/AWWA A21.51/C151 AS APPLICABLE TO TYPE PIPE BEING GROOVED.
- (3) MINIMUM STANDARD WALL THICKNESS THAT SHOULD BE GROOVED.