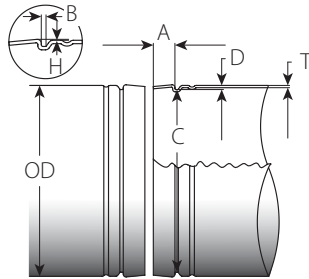


## 1.0 DIMENSIONS

### STRENGTHIN™ 100 ROLL GROOVE SPECIFICATIONS



Pipe per BS EN 10217-7 304/304L and 316/316L

Nominal Size	Pipe Outside Diameter <sup>1</sup>		Gasket Seat "A" <sup>2</sup>	Groove Width "B" <sup>3</sup>	Groove Diameter "C" <sup>4</sup>		Groove Depth "D" <sup>5</sup> (ref.)	Nominal Allowable Pipe Wall Thickness "T" <sup>6</sup>		
	Actual	Tolerance			Max	Min		Max	Min	Max
inches DN	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	
2 DN50	2.375 60.3	2.399 60.93	2.351 59.72	±0.031 ±0.79	0.110 2.79	2.139 54.33	2.091 53.11	0.130 3.30	0.106 2.7	0.063 1.6
2½	2.875 73.0	2.904 73.76	2.846 72.29	0.750 19.05	0.110 2.79	2.644 67.16	2.586 65.68	0.130 3.30	0.106 2.7	0.063 1.6
DN65	3.000 76.2	3.030 76.96	2.970 75.43	0.750 19.05	0.110 2.79	2.770 70.36	2.710 68.83	0.130 3.30	0.106 2.7	0.063 1.6
3 DN80	3.500 88.9	3.535 89.79	3.469 88.11	0.750 19.05	0.110 2.79	3.275 83.19	3.209 81.51	0.130 3.30	0.106 2.7	0.063 1.6
4 DN100	4.500 114.3	4.545 115.44	4.469 113.51	0.750 19.05	0.110 2.79	4.285 108.84	4.209 106.91	0.130 3.30	0.106 2.7	0.063 1.6
DN125	5.500 139.7	5.556 141.12	5.469 138.91	0.750 19.05	0.110 2.79	5.296 134.52	5.209 132.31	0.130 3.30	0.106 2.7	0.063 1.6
5	5.563 141.3	5.619 142.72	5.532 140.51	0.750 19.05	0.110 2.79	5.359 136.12	5.272 133.91	0.130 3.30	0.106 2.7	0.063 1.6

- 1 Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.
- 2 Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.
- 3 Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.
- 4 Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.
- 5 Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.
- 6 Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be roll grooved.

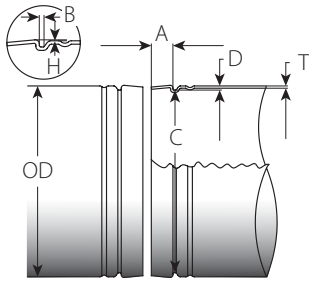
ALWAYS REFER TO ANY NOTIFICATIONS AT THE END OF THIS DOCUMENT REGARDING PRODUCT INSTALLATION, MAINTENANCE OR SUPPORT.

System No.		Location	
Submitted By		Date	

Spec Section		Paragraph	
Approved		Date	

1.0 DIMENSIONS (CONTINUED)

STRENGTHIN™ 100 ROLL GROOVE SPECIFICATIONS



Pipe per BS EN 10217-7 304/304L and 316/316L

Nominal Size	Pipe Outside Diameter <sup>1</sup>		Gasket Seat "A" <sup>2</sup>	Groove Width "B" <sup>3</sup>	Groove Diameter "C" <sup>4</sup>		Groove Depth "D" <sup>5</sup> (ref.)	Nominal Allowable Pipe Wall Thickness "T" <sup>6</sup>		
	Actual	Tolerance			Max	Min		Max	Min	Max
inches DN	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	inches mm	
	6.500 165.1	6.563 166.70	6.649 164.31	±0.031 ±0.79	±0.005 ±0.13	6.303 160.10	6.209 157.71	0.130 3.30	0.106 2.7	0.063 1.6
6 DN150	6.625 168.3	6.688 169.88	6.594 167.49	0.750 19.05	0.110 2.79	6.428 163.27	6.334 160.88	0.130 3.30	0.106 2.7	0.063 1.6
200A <sup>7</sup>		8.578 217.88	8.484 215.49	0.875 22.23	0.200 5.08	8.205 208.41	8.111 206.02	0.187 4.75	0.177 4.5	0.079 2.0
8 DN200	8.625 219.1	8.688 220.68	8.594 218.29	0.875 22.23	0.200 5.08	8.315 211.20	8.221 208.81	0.187 4.75	0.177 4.5	0.079 2.0
250A <sup>7</sup>		10.591 269.01	10.497 266.62	0.875 22.23	0.200 5.08	10.218 259.54	10.124 257.15	0.187 4.75	0.177 4.5	0.079 2.0
10 DN250	10.750 273.0	10.813 274.65	10.719 272.26	0.875 22.23	0.200 5.08	10.440 265.18	10.346 262.79	0.187 4.75	0.177 4.5	0.079 2.0
300A <sup>7</sup>		12.602 320.09	12.508 317.70	0.875 22.23	0.200 5.08	12.228 310.59	12.135 308.23	0.187 4.75	0.177 4.5	0.079 2.0
12 DN300	12.750 323.9	12.813 325.45	12.719 323.06	0.875 22.23	0.200 5.08	12.440 315.98	12.346 313.59	0.187 4.75	0.177 4.5	0.079 2.0

<sup>1</sup> Outside diameter: The outside diameter of roll grooved pipe shall not vary more than the tolerance listed.

<sup>2</sup> Gasket seat "A": The pipe surface shall be free from indentations, roll marks and projections from the end of the pipe to the groove to provide a leak-tight seal for the gasket. All loose paint, scale, dirt, chips, grease and rust must be removed. It continues to be Victaulic's first recommendation that pipe be square cut. When using beveled pipe, contact Victaulic for details. Gasket seat "A" is measured from the end of the pipe.

<sup>3</sup> Groove width "B": The bottom of the groove shall be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembly.

<sup>4</sup> Groove diameter "C": The groove must be of uniform depth for the entire pipe circumference. The groove must be maintained within the "C" diameter tolerance listed.

<sup>5</sup> Groove depth "D": For reference only. Groove must conform to the groove diameter "C" listed.

<sup>6</sup> Nominal allowable pipe wall thickness "T": This is the nominal allowable pipe wall thickness which may be roll grooved.

<sup>7</sup> Japanese Industrial Standard (JIS) size

## 2.0 REFERENCE MATERIALS

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[24.01: Victaulic Pipe Preparation Tools](#)

[31.02: Victaulic StrengThin™ 100 System Style E497 Rigid Coupling for Stainless Steel Pipe](#)

[31.04: Victaulic StrengThin™ 100 Fittings for Stainless Steel](#)

[31.11: Victaulic StrengThin™ 100 System Style E485 Rigid Coupling for Stainless Steel Pipe](#)

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

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