# GDC-AC Go/No-Go Groove Diameter Cable for DN50 – DN200 Australian Standard (AS 1432) Copper Tubing

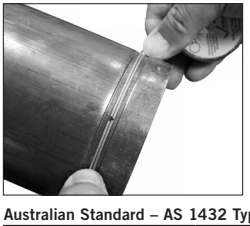
## ⚠ WARNING

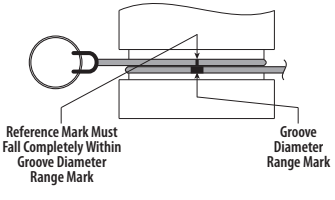
- **Read and understand all instructions before attempting to use this Go/No-Go groove diameter cable.**
- **Wear safety glasses, hardhat, foot protection, and hearing protection when working with Victaulic pipe preparation tools.**
- **Verify that the outside diameter of the tubing is within Victaulic specifications.**
- **After grooving, make sure all diameters are measured in accordance with Victaulic specifications.**

**Installation and pressurization of grooved copper tubing that does not conform to Victaulic specifications could cause joint failure, resulting in death or serious personal injury and property damage.**

## NOTICE

- **THE GDC-AC GROOVE DIAMETER CABLE IS NOT A REPLACEMENT FOR A ROUTINELY CALIBRATED DIAMETER MEASURING INSTRUMENT AND PROPER INSPECTION PROCEDURES. THIS GROOVE DIAMETER CABLE SHOULD BE USED ONLY AS AN AID FOR CHECKING GROOVE DIAMETERS. A MEASURING INSTRUMENT THAT IS ROUTINELY CALIBRATED TO TRACEABLE STANDARDS IS RECOMMENDED FOR THE MOST ACCURATE GROOVE DIMENSION MEASUREMENT.**
- **The GDC-AC contains Go/No-Go markings with tubing sizes and must be used ONLY to check roll-grooved tubing to Victaulic Australian Standard (AS 1432) groove specifications (DN50 – DN200 tubing sizes). DO NOT use the GDC-AC to check tubing grooved to any other specifications.**






**CHECK GROOVE DIAMETER:**
Remove all loose dirt, scale, and paint from the groove and gasket sealing surface. Wrap the cable around the tubing groove and overlap the two ends, as shown. Make sure the cable seats in the base of the groove.

Firmly pull on each end of the overlapped cable. Determine if the reference mark is completely within the groove diameter range mark for the applicable tubing size. The reference mark must be completely within the groove diameter range mark for conformance to Victaulic specifications.

**Australian Standard – AS 1432 Types A, B, and D Copper Tubing**

| Australian Standard Copper Tubing Nominal Size (Actual Size)† | Dimensions – mm/inches | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | Actual OD* | | Gasket Seat | | | Groove Width | | Groove Diameter | | Groove Depth (Reference Only) | Maximum Allowable Flare Diameter |
| | Max. | Min. | Basic | Max. | Min. | Max. | Min. | Max. | Min. | | |
| DN 50 (50.8) | 50.80<br>2.000 | 50.67<br>1.995 | 15.87<br>0.625 | 16.64<br>0.655 | 15.11<br>0.595 | 8.38<br>0.330 | 7.62<br>0.300 | 48.23<br>1.899 | 47.73<br>1.879 | 1.25<br>0.049 | 53.06<br>2.089 |
| DN 65 (63.5) | 63.50<br>2.500 | 63.35<br>2.494 | 15.87<br>0.625 | 16.64<br>0.655 | 15.11<br>0.595 | 8.38<br>0.330 | 7.62<br>0.300 | 60.88<br>2.397 | 60.38<br>2.377 | 1.27<br>0.050 | 65.83<br>2.592 |
| DN 80 (76.2) | 76.20<br>3.000 | 76.02<br>2.993 | 15.87<br>0.625 | 16.64<br>0.655 | 15.11<br>0.595 | 8.38<br>0.330 | 7.62<br>0.300 | 73.56<br>2.896 | 73.05<br>2.876 | 1.27<br>0.050 | 78.51<br>3.091 |
| DN 100 (101.6) | 101.60<br>4.000 | 101.35<br>3.990 | 15.87<br>0.625 | 16.64<br>0.655 | 15.11<br>0.595 | 8.38<br>0.330 | 7.62<br>0.300 | 98.78<br>3.889 | 98.27<br>3.869 | 1.35<br>0.053 | 103.88<br>4.090 |
| DN 125 (127.0) | 127.00<br>5.000 | 126.75<br>4.990 | 15.87<br>0.625 | 16.64<br>0.655 | 15.11<br>0.595 | 8.38<br>0.330 | 7.62<br>0.300 | 123.67<br>4.869 | 123.16<br>4.849 | 1.60<br>0.063 | 128.77<br>5.070 |
| DN 150 (152.4) | 152.40<br>6.000 | 152.10<br>5.988 | 15.87<br>0.625 | 16.64<br>0.655 | 15.11<br>0.595 | 8.38<br>0.330 | 7.62<br>0.300 | 149.05<br>5.868 | 148.54<br>5.848 | 1.60<br>0.063 | 154.66<br>6.089 |
| DN 200 (203.2) | 203.20<br>8.000 | 202.80<br>7.984 | 15.87<br>0.625 | 16.64<br>0.655 | 15.11<br>0.595 | 8.38<br>0.330 | 7.62<br>0.300 | 199.80<br>7.866 | 199.29<br>7.846 | 1.60<br>0.063 | 205.80<br>8.102 |

† Nominal AS 1432 drawn copper tubing size
* The outside diameter of roll grooved copper tubing cannot vary from the tolerance listed. The maximum allowable tolerance from square cut ends is 0.8 mm/0.030 inch for DN 50 – DN 80-mm sizes and 1.1 mm/0.045 inch for DN 100 and larger sizes; this is measured from the true square line.