

GDC-EC Go/No-Go Groove Diameter Cable for 54 - 159-mm European Standard EN 1057 R250 (Half-Hard) Copper Tubing

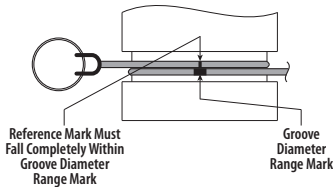
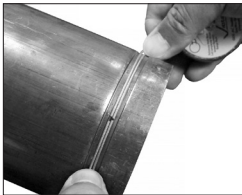
WARNING



- 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 roll grooving 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-EC 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-EC contains go/no-go markings with tubing sizes and must be used ONLY to check roll-grooved tubing to Victaulic European Standard EN 1057 R250 (Half-Hard) specifications (54 – 159-mm tubing sizes). DO NOT use the GDC-EC 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.

European Standard – EN 1057 R250 (Half-Hard) Copper Tubing

European Standard Copper Tubing Nominal Size mm†	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.		
54	54.07 2.129	53.93 2.123	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	51.51 2.028	51.00 2.008	1.25 0.049	56.38 2.220
64	64.07 2.522	63.93 2.517	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	61.47 2.420	60.96 2.400	1.27 0.050	66.41 2.615
66.7	66.77 2.629	66.63 2.623	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	64.14 2.525	63.63 2.505	1.27 0.050	69.09 2.720
76.1	76.17 2.999	76.03 2.993	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	73.41 2.890	72.90 2.870	1.35 0.053	78.61 3.095
88.9	88.97 3.503	88.83 3.497	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	85.70 3.374	85.19 3.354	1.60 0.063	91.63 3.607
108	108.07 4.255	107.93 4.249	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	104.80 4.126	104.29 4.106	1.60 0.063	110.54 4.352
133	133.20 5.244	132.80 5.228	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	129.29 5.090	128.78 5.070	1.85 0.073	135.79 5.346
159	159.20 6.280	158.80 6.252	15.87 0.625	16.64 0.655	15.11 0.595	8.38 0.330	7.62 0.300	155.30 6.114	154.79 6.094	1.85 0.073	161.80 6.370

† European Standard Copper Tubing; Nominal EN 1057 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 0.8mm/0.030inch for 54 – 88.9-mm sizes and 1.1mm/0.045inch for 108 – 159-mm sizes; this is measured from the true square line.

For complete contact information, visit victaulic.com
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