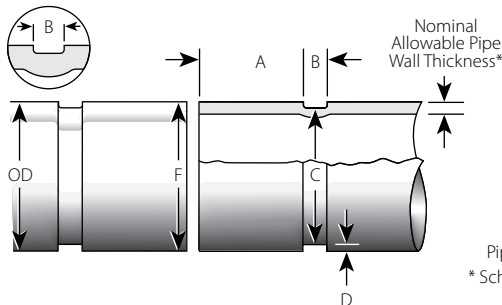


1.0 DIMENSIONS

OGS-200 Roll Groove Specifications For Use With Style 870 Rigid Coupling



Pipe per ASTM A53 and A106, Grade B
 * Schedule 40 and 80 pipe wall thicknesses satisfying ASTM A53 and A106.

Nominal Size	Pipe Outside Diameter ¹			Gasket Seat "A" ²	Groove Width "B" ³	Groove Diameter "C" ⁴		Groove Depth "D" ⁵ (ref.)	Max. Allow. Flare Diameter "F" ⁶
	Actual	Tolerance				Max	Min		
inches DN	inches mm	inches mm	inches mm	inches mm	±0.010 inches ±0.25 mm	inches mm	inches mm	inches mm	inches mm
2 DN50	2.375 60.3	2.399 60.9	2.351 59.7	1.000±.031 25.40±0.79	0.344 8.7	2.250 57.2	2.235 56.8	0.063 1.6	2.404 61.1
2½	2.875 73.0	2.904 73.8	2.846 72.3			2.720 69.1	2.702 68.6	0.078 2.0	2.909 73.9
3 DN80	3.500 88.9	3.535 89.8	3.469 88.1			3.344 84.9	3.326 84.5	0.078 2.0	3.540 89.9
4 DN100	4.500 114.3	4.545 115.4	4.469 113.5	1.125 +.031/-0.063 28.58 +0.79/-1.60	0.469 11.9	4.334 110.1	4.314 109.6	0.083 2.1	4.575 116.2
6 DN150	6.625 168.3	6.688 169.9	6.594 167.5	6.455 164.0		6.433 163.4	0.085 2.2	6.718 170.6	
8 DN200	8.625 219.1	8.688 220.7	8.594 218.3	1.250 +.031/-0.063 31.75 +0.79/-1.60		8.441 214.4	8.416 213.8	0.092 2.3	8.698 220.8

- Outside diameter:** The outside diameter of roll grooved pipe shall not vary more than the tolerance listed. For IPS pipe, the maximum allowable tolerance from square cut ends is 0.032"/0.81 mm for 2 – 3"/DN50 – DN80; and 0.063"/1.60 mm for 4 – 8"/DN100 – DN200, measured from true square line.
- 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 end pipe, the gasket seat "A" is measured from the end of the pipe. IMPORTANT: Roll grooving of beveled end pipe may result in unacceptable pipe end flare. See Maximum Allowable Flare Diameter column.
- Groove width "B":** Bottom of groove to be free of loose dirt, chips, rust and scale that may interfere with proper coupling assembling.
- Groove diameter "C":** The groove must be of uniform depth for the entire pipe circumference. Groove must be maintained within the "C" diameter tolerance listed.
- Groove depth "D":** For reference only. Groove must conform to the groove diameter "C" listed.
- Maximum allowable pipe end flare diameter "F":** Measured at the most extreme pipe end diameter square cut or beveled.

NOTES

- Do not apply coatings to the gasket seat "A" nor within the groove width "B" on the pipe exterior.
- Any corrective action to gasket seat "A" to provide a good sealing surface as required in footnote #2 (listed above) must not result in file, grind or sand marks going across gasket seat "A."
- Roll grooving removes no metal, cold forming a groove by the action of an outer grooving roll being forced into pipe as it is rotated by an inner support roll.
- For use on schedule 40 and 80 IPS carbon steel pipe. Contact Victaulic for all other pipe material inquiries.

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	

2.0 GROOVING

TOOLS RECOMMENDED FOR OGS-200 ROLL SETS

Pipe Material		VE272SFS VE270FSD VE268	Part Number	VE416FSD	Part Number	VE460	Part Number
Carbon Steel	Schedule 40	2 – 3"/DN50 – DN80	R9S2268003	4 – 6"/DN100 – DN150	R9S4416006	8"/DN200	R9S4416006
		4 – 6"/DN100 – DN150	R9S4268006			8"/DN200	
	Schedule 80	2 – 3"/DN50 – DN80	Same as for Sch 40 (R9S2268003)	4 – 6"/DN100 – DN150		8"/DN200	

NOTE

- Victaulic R9S roll sets must be used when grooving schedule 40 and 80 carbon steel pipe to Victaulic OGS-200 groove specifications. Victaulic R9S roll sets must be ordered separately. They are identified by the designation "R9S" on the front of the roll set, as well as a red color stripe on both the upper and lower roll.

3.0 REFERENCE MATERIALS

- [24.01: Victaulic Pipe Preparation Tools](#)
- [100.01: Victaulic OGS-200 Grooved End Fittings](#)
- [100.02: Victaulic Rigid Coupling Style 870](#)
- [I-870 Installation Instructions Style 870 Rigid Coupling](#)

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