

VICTAULIC GROOVING SPECIFICATIONS

NPS	Nominal Pipe O.D.	Land Width E	Grove Width F	Groove Diameter G	Maximum Spacing H	Minimum Wall J	Actual For 4" Max.	Pipe O.D. From End Min.
3/4	1.050	5/8 = 1/32	5/16 = 1/32	.938 - 0 -- .015	1/8	.113	1.081	1.034
1	1.315	5/8 = 1/32	5/16 = 1/32	1.190 - 0 -- .015	1/8	.133	1.346	1.299
1 1/4	1.660	5/8 = 1/32	5/16 = 1/32	1.535 - 0 -- .015	1/8	.140	1.691	1.644
1 1/2	1.900	5/8 = 1/32	5/16 = 1/32	1.775 - 0 -- .015	1/8	.145	1.931	1.884
2	2.375	5/8 = 1/32	5/16 = 1/32	2.250 - 0 -- .015	1/8	.154	2.406	2.359
2 1/2	2.875	5/8 = 1/32	5/16 = 1/32	2.720 - 0 -- .018	1/8	.187	2.906	2.859
3	3.500	5/8 = 1/32	5/16 = 1/32	3.344 - 0 -- .018	1/8	.187	3.530	3.484
3 1/2	4.000	5/8 = 1/32	5/16 = 1/32	3.834 - 0 -- .020	1/8	.187	4.031	3.984
4	4.500	5/8 = 1/32	3/8 = 1/32	4.334 - 0 -- .020	1/4	.203	4.531	4.484
5	5.563	5/8 = 1/32	3/8 = 1/32	5.395 - 0 -- .022	1/4	.250	5.594	5.547
6	6.625	5/8 = 1/32	3/8 = 1/32	6.455 - 0 -- .022	1/4	.219	6.656	6.609
8	8.625	3/4 = 1/32	7/16 = 1/32	8.441 - 0 -- .025	1/4	.238	8.656	8.609
10	10.750	3/4 = 1/32	1/2 = 1/32	10.562 - 0 -- .027	1/4	.250	10.781	10.734
12	12.750	3/4 = 1/32	1/2 = 1/32	12.531 - 0 -- .030	1/4	.281	12.797	12.719
14	14.000	15/16 = 1/32	1/2 = 1/32	13.781 - 0 -- .030	1/4	.281	14.047	13.964
16	16.000	15/16 = 1/32	1/2 = 1/32	15.781 - 0 -- .030	1/4	.313	16.047	15.969
18	18.000	1 = 1/32	1/2 = 1/32	17.781 - 0 -- .030	1/4	.313	18.047	17.969
20	20.000	1 = 1/32	1/2 = 1/32	19.781 - 0 -- .030	1/4	.313	20.047	19.969
24	24.000	1 = 1/32	9/16 = 1/32	23.656 - 0 -- .030	1/4	.1438	24.047	23.969

All dimensions in inches except as indicated.

Actual pipe O.D. minimum from API standard 5L Line Pipe (plain end)

Actual pipe O.D. maximum is recommended for plain end pipe

Pipe O.D. tolerance 10.750" and smaller - 1/32" - 1/16"
12.750" and larger - 3/64" - 1/32" e

For machining fittings use land and groove tolerances.

