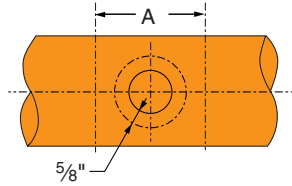


## PIPE-PREPARATION:

### BRANCH OUTLET PIPE: CLAMP-T®

Clamp-T installations require the cutting of a hole through the pipe wall. The hole must be properly sized and located on the centerline of the pipe to assure reliable performance of the Clamp-T gaskets.



After the hole has been cut into the pipe wall, any burrs and sharp or rough edges must be removed from the hole. The outside pipe surfaces within 5/8" of the hole must be clean and smooth. Any scale, projections or indentation which might effect the gasket sealing on the pipe must be removed. The surface around the entire circumference of the pipe within the "A" dimension in the charts must be free from dirt, scale, or projections which might effect the proper assembly of the Clamp-T.

| Branch Size               | Hole Dimensions |                     | Surface Prep. "A" |
|---------------------------|-----------------|---------------------|-------------------|
|                           | Hole Saw Size   | Max. Perm. Diameter |                   |
| DN/mm                     | In./mm          | In./mm              | In./mm            |
| 1/2, 3/4, 1<br>15, 20, 25 | 1 1/2<br>38.1   | 1 5/8<br>41.3       | 3 1/2<br>88.9     |
| 1 1/4, 1 1/2<br>32, 40    | 2<br>50.8       | 2 1/8<br>54.0       | 4<br>101.6        |
| 2<br>50                   | 2 1/2<br>63.5   | 2 5/8<br>66.7       | 4 1/2<br>114.3    |
| 2 1/2<br>65               | 2 3/4<br>69.9   | 2 7/8<br>73.0       | 4 3/4<br>120.7    |
| 3<br>80                   | 3 1/2<br>88.9   | 3 5/8<br>92.1       | 5 1/2<br>139.7    |
| 4<br>100                  | 4 1/2<br>114.3  | 4 5/8<br>117.5      | 6 1/2<br>165.1    |

### SOCK-IT®

For Sock-It Fittings, the pipe ends must be square cut as measured from a true square line.

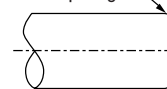
The maximum allowable tolerance is 0.030" (0.76mm) for all sizes. Any sharp edges, burrs, etc. left on the pipe from cutting must be removed. If these are not removed, they may damage the gasket as the pipe is inserted into the Sock-It Fitting.

After cutting, pipe ends must be completely cleaned a minimum of 1" (25.4mm) back from the pipe end to remove all pipe coating, weld beads, indentations caused by the pipe weld, rust, sharp projections, etc., which might effect gasket sealing integrity.

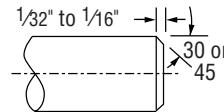
### ACCEPTABLE PIPE END CONFIGURATION



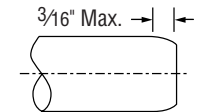
Remove Burr & Sharp Edge



Square cut pipe with O.D. burr & sharp edge removed is preferred configuration.



Beveled pipe. Bevel not to exceed 1/16".

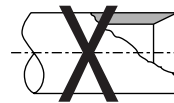


Soft pipe when roll cut may be swaged inward. Swaged portion not to exceed 3/16"

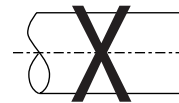
| Size  | PIPE TOLERANCES  |           |           |              |
|-------|------------------|-----------|-----------|--------------|
|       | Schedule 10 & 40 |           | Min. O.D. | XL Min. O.D. |
|       | Nom O.D.         | Max. O.D. |           |              |
| DN/mm | In./mm           | In./mm    | In./mm    | In./mm       |
| 1     | 1.315            | 1.325     | 1.295     | 1.285        |
| 25    | 33.4             | 33.6      | 32.9      | 32.6         |
| 1 1/4 | 1.660            | 1.670     | 1.642     | 1.630        |
| 32    | 42.2             | 42.4      | 41.7      | 41.4         |
| 1 1/2 | 1.900            | 1.910     | 1.882     | 1.875        |
| 40    | 48.3             | 48.5      | 47.8      | 47.6         |
| 2     | 2.375            | 2.385     | 2.357     | 2.352        |
| 50    | 60.3             | 60.6      | 59.9      | 59.7         |
| 2 1/2 | 2.875            | 2.904     | 2.846     | 2.837        |
| 65    | 73.0             | 73.8      | 72.3      | 72.1         |

**NOTE:** When Allied XL pipe is used it is necessary only to remove sharp edges and burrs at the end of the pipe. No additional cleaning is required.

### UNACCEPTABLE



Excessive chamfer on I.D. will tend to cut gasket during assembly.



Abrasive wheels & saws leave edge burrs especially pronounced on one side.



Dull wheel cutter produces a raised ridge at the pipe O.D. giving an oversize diameter.

The sharp O.D. edge left by different methods of cutting pipe **must be removed**. If this sharp edge is not removed, it may damage the gasket as the pipe is inserted into the Sock-It Fitting.

### ROUGHNECK®

Plain-End pipe for use with Fig. 7005 Roughneck Couplings must be free of any notches, bumps, weld bead, score marks, etc. for at least 1 1/2" (38mm) back from the pipe end to provide a smooth sealing surface for the gasket. Pipe ends (plain or beveled end) must be square cut as measured from a true square line with the maximum allowable tolerance as follows: 0.030" (0.7mm) for 2" through 3"; 0.045 (1.1mm) for 4" through 6"; and 0.060" (1.5mm)

for 8" sizes. The nominal outside diameter of pipe should not vary more than ±1% for sizes up to 2 1/2", +1%-1/32" for sizes 3"-5"; +1/16"-1/32" for sizes 6" and larger. Pipe ends must be marked a distance of 1" from the pipe end for Sizes 2"-4" and 1 1/4" from the pipe end for Sizes 5"-8" as a guide for centering of the gasket on the pipe ends.