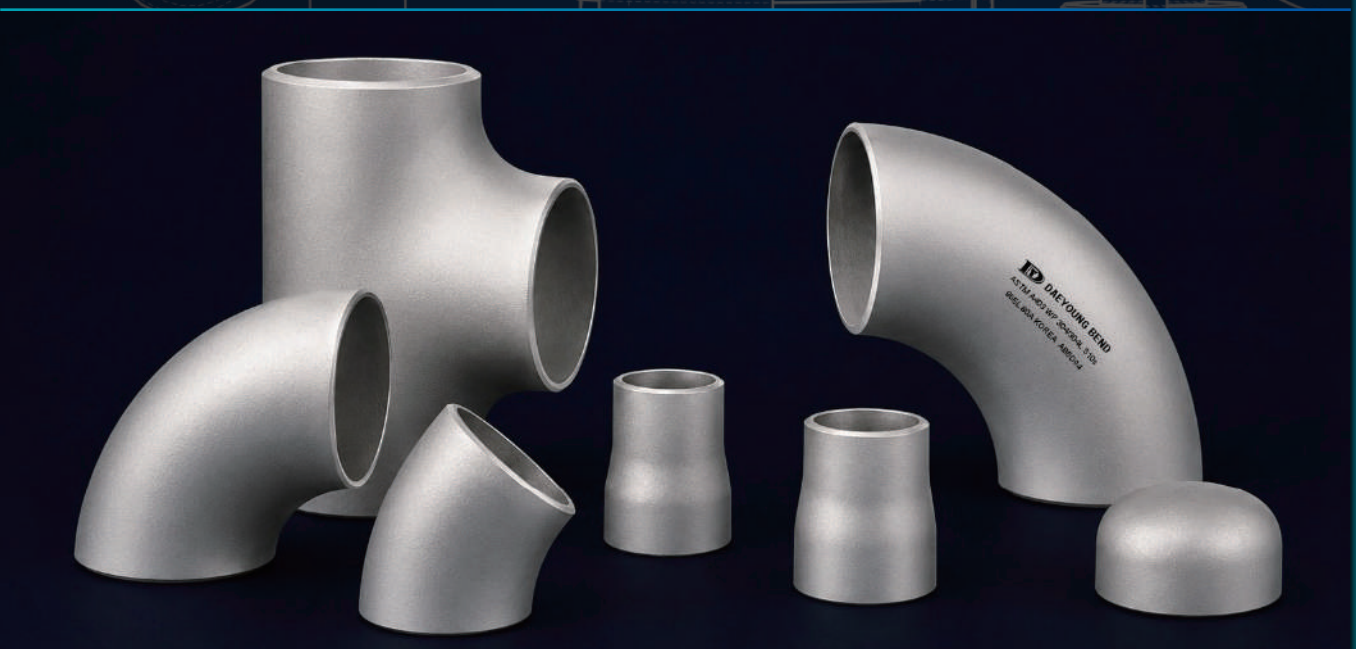
DEAYOUNG BEND

Stainless Steel Butt-Weld Fittings
Stainless Grooved Fittings
Pipe Grooving Machines



Vol.01

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A Powerful Partner in the Stainless Steel Piping Market

DAEYOUNG BEND

A Powerful Partner in the Stainless Steel Piping Market
Since its foundation, Daeyoung Bend has achieved steady growth by providing premium-quality products and machinery to a wide range of industries.
Our products are widely used in large-scale plant construction, research complexes, chemical facilities, commercial buildings, hotels, hospitals, and new city development projects.

"Competing through Customer Satisfaction and Quality"
Even amid unforeseen challenges, Daeyoung Bend has continued to grow through an unwavering commitment to quality. This commitment has been the foundation of our progress and remains at the heart of everything we do.
Looking ahead, we will continue to deliver products of the highest quality and reliability, creating greater value and satisfaction for our customers.
With your continued trust and support, Daeyoung Bend will create greater value through continuous innovation and responsible management, guided by its philosophy of "Quality Improvement and Customer Satisfaction."

Thank you.
DAEYOUNG BEND CO.LTD.

Certification Status









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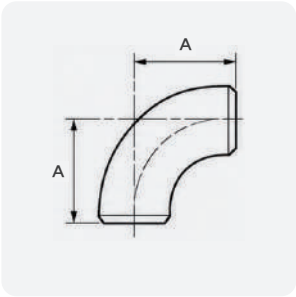
01 STAINLESS STEEL BUTT-WELD FITTINGS



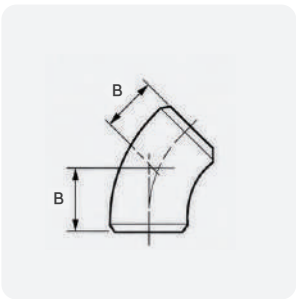
90° / 45° Long Radius Elbows

ASTM A403 / ASME B16.9

Unit: mm (in.)



90° Long Radius Elbows



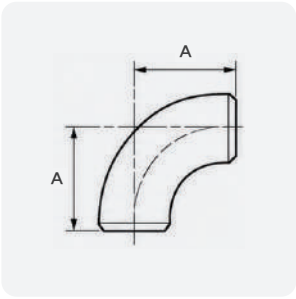
45° Long Radius Elbows

Nominal Pipe Size [NPS]	OD at Bevel	Center-to-End		Wall Thickness (t)		
		90-deg Elbows,A	45-deg Elbows,B	SCH 10S	SCH 40S	SCH 80S
1/2	21.3 (0.84)	38 (1.50)	16 (0.62)	2.11 (0.083)	2.77 (0.109)	3.73 (0.147)
3/4	26.7 (1.05)	38 (1.50)	19 (0.75)	2.11 (0.083)	2.87 (0.113)	3.91 (0.154)
1	33.4 (1.32)	38 (1.50)	22 (0.88)	2.77 (0.109)	3.38 (0.133)	4.55 (0.179)
1-1/4	42.2 (1.66)	48 (1.88)	25 (1.00)	2.77 (0.109)	3.56 (0.140)	4.85 (0.191)
1-1/2	48.3 (1.90)	57 (2.25)	29 (1.12)	2.77 (0.109)	3.68 (0.145)	5.08 (0.200)
2	60.3 (2.38)	76 (3.00)	35 (1.38)	2.77 (0.109)	3.91 (0.154)	5.54 (0.218)
2-1/2	73.0 (2.88)	95 (3.75)	44 (1.75)	3.05 (0.120)	5.16 (0.203)	7.01 (0.276)
3	88.9 (3.50)	114 (4.50)	51 (2.00)	3.05 (0.120)	5.49 (0.216)	7.62 (0.300)
3-1/2	101.6 (4.00)	133 (5.25)	57 (2.25)	3.05 (0.120)	5.74 (0.226)	8.08 (0.318)
4	114.3 (4.50)	152 (6.00)	64 (2.50)	3.05 (0.120)	6.02 (0.237)	8.56 (0.337)
5	141.3 (5.56)	190 (7.50)	79 (3.12)	3.40 (0.134)	6.55 (0.258)	9.53 (0.375)
6	168.3 (6.62)	229 (9.00)	95 (3.75)	3.40 (0.134)	7.11 (0.280)	10.97 (0.432)
8	219.1 (8.62)	305 (12.00)	127 (5.00)	3.76 (0.148)	8.18 (0.322)	12.70 (0.500)
10	273.0 (10.75)	381 (15.00)	159 (6.25)	4.19 (0.165)	9.27 (0.365)	12.70 (0.500)
12	323.8 (12.75)	457 (18.00)	190 (7.50)	4.57 (0.180)	9.53 (0.375)	12.70 (0.500)
14	355.6 (14.00)	533 (21.00)	222 (8.75)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
16	406.4 (16.00)	610 (24.00)	254 (10.00)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
18	457.0 (18.00)	686 (27.00)	286 (11.25)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
20	508.0 (20.00)	762 (30.00)	318 (12.50)	5.54 (0.218)	9.53 (0.375)	12.70 (0.500)
22	559.0 (22.00)	838 (33.00)	343 (13.50)	5.54 (0.218)	-	-
24	610.0 (24.00)	914 (36.00)	381 (15.00)	6.35 (0.250)	9.53 (0.375)	12.70 (0.500)

90° Short Radius Elbows

Unit: mm (in.)

ASTM A403 / ASME B16.9



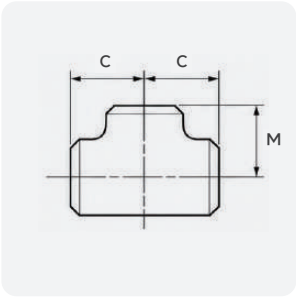
90° Short Radius Elbows

Nominal Pipe Size [NPS]	OD at Bevel	Center-to-End	Wall Thickness (t)		
			SCH 10S	SCH 40S	SCH 80S
1	33.4 (1.32)	25 (1.00)	2.77 (0.109)	3.38 (0.133)	4.55 (0.179)
1-1/4	42.2 (1.66)	32 (1.25)	2.77 (0.109)	3.56 (0.140)	4.85 (0.191)
1-1/2	48.3 (1.90)	38 (1.50)	2.77 (0.109)	3.68 (0.145)	5.08 (0.200)
2	60.3 (2.38)	51 (2.00)	2.77 (0.109)	3.91 (0.154)	5.54 (0.218)
2-1/2	73.0 (2.88)	64 (2.50)	3.05 (0.120)	5.16 (0.203)	7.01 (0.276)
3	88.9 (3.50)	76 (3.00)	3.05 (0.120)	5.49 (0.216)	7.62 (0.300)
3-1/2	101.6 (4.00)	89 (3.50)	3.05 (0.120)	5.74 (0.226)	8.08 (0.318)
4	114.3 (4.50)	102 (4.00)	3.05 (0.120)	6.02 (0.237)	8.56 (0.337)
5	141.3 (5.56)	127 (5.00)	3.40 (0.134)	6.55 (0.258)	9.53 (0.375)
6	168.3 (6.62)	152 (6.00)	3.40 (0.134)	7.11 (0.280)	10.97 (0.432)
8	219.1 (8.62)	203 (8.00)	3.76 (0.148)	8.18 (0.322)	12.70 (0.500)
10	273.0 (10.75)	254 (10.00)	4.19 (0.165)	9.27 (0.365)	12.70 (0.500)
12	323.8 (12.75)	305 (12.00)	4.57 (0.180)	9.53 (0.375)	12.70 (0.500)
14	355.6 (14.00)	356 (14.00)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
16	406.4 (16.00)	406 (16.00)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
18	457.0 (18.00)	457 (18.00)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
20	508.0 (20.00)	508 (20.00)	5.54 (0.218)	9.53 (0.375)	12.70 (0.500)
22	559.0 (22.00)	559 (22.00)	5.54 (0.218)	-	-
24	610.0 (24.00)	610 (24.00)	6.35 (0.250)	9.53 (0.375)	12.70 (0.500)

Straight Tees

Unit: mm (in.)

ASTM A403 / ASME B16.9



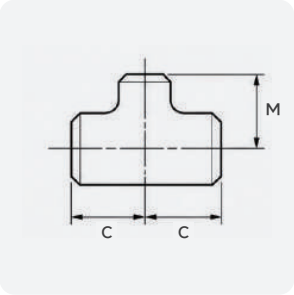
Straight Tees

Nominal Pipe Size [NPS]	OD at Bevel	Run, C	Outlet, M	Wall Thickness (t)		
				SCH 10S	SCH 40S	SCH 80S
1/2	21.3 (0.84)	25 (1.00)	25 (1.00)	2.11 (0.083)	2.77 (0.109)	3.73 (0.147)
3/4	26.7 (1.05)	29 (1.12)	29 (1.12)	2.11 (0.083)	2.87 (0.113)	3.91 (0.154)
1	33.4 (1.32)	38 (1.50)	38 (1.50)	2.77 (0.109)	3.38 (0.133)	4.55 (0.179)
1-1/4	42.2 (1.66)	48 (1.88)	48 (1.88)	2.77 (0.109)	3.56 (0.140)	4.85 (0.191)
1-1/2	48.3 (1.90)	57 (2.25)	57 (2.25)	2.77 (0.109)	3.68 (0.145)	5.08 (0.200)
2	60.3 (2.38)	64 (2.50)	64 (2.50)	2.77 (0.109)	3.91 (0.154)	5.54 (0.218)
2-1/2	73.0 (2.88)	76 (3.00)	76 (3.00)	3.05 (0.120)	5.16 (0.203)	7.01 (0.276)
3	88.9 (3.50)	86 (3.38)	86 (3.38)	3.05 (0.120)	5.49 (0.216)	7.62 (0.300)
3-1/2	101.6 (4.00)	95 (3.75)	95 (3.75)	3.05 (0.120)	5.74 (0.226)	8.08 (0.318)
4	114.3 (4.50)	105 (4.12)	105 (4.12)	3.05 (0.120)	6.02 (0.237)	8.56 (0.337)
5	141.3 (5.56)	124 (4.88)	124 (4.88)	3.40 (0.134)	6.55 (0.258)	9.53 (0.375)
6	168.3 (6.62)	143 (5.62)	143 (5.62)	3.40 (0.134)	7.11 (0.280)	10.97 (0.432)
8	219.1 (8.62)	178 (7.00)	178 (7.00)	3.76 (0.148)	8.18 (0.322)	12.70 (0.500)
10	273.0 (10.75)	216 (8.50)	216 (8.50)	4.19 (0.165)	9.27 (0.365)	12.70 (0.500)
12	323.8 (12.75)	254 (10.00)	254 (10.00)	4.57 (0.180)	9.53 (0.375)	12.70 (0.500)
14	355.6 (14.00)	279 (11.00)	279 (11.00)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
16	406.4 (16.00)	305 (12.00)	305 (12.00)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
18	457.0 (18.00)	343 (13.50)	343 (13.50)	4.78 (0.188)	9.53 (0.375)	12.70 (0.500)
20	508.0 (20.00)	381 (15.00)	381 (15.00)	5.54 (0.218)	9.53 (0.375)	12.70 (0.500)
22	559.0 (22.00)	419 (16.50)	419 (16.50)	5.54 (0.218)	-	-
24	610.0 (24.00)	432 (17.00)	432 (17.00)	6.35 (0.250)	9.53 (0.375)	12.70 (0.500)

Reducing Outlet Tees 1/2

Unit: mm (in.)

ASTM A403 / ASME B16.9



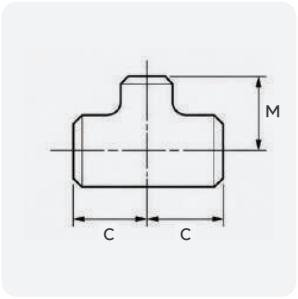
Reducing Outlet Tees

Nominal Pipe Size [NPS]	OD at Bevel		Run, C	Outlet, M
	Run	Outlet		
3/4 x 3/4 x 1/2	26.7 (1.05)	21.3 (0.84)	29 (1.12)	29 (1.12)
1 x 1 x 3/4	33.4 (1.32)	26.7 (1.05)	38 (1.50)	38 (1.50)
1 x 1 x 1/2	33.4 (1.32)	21.3 (0.84)	38 (1.50)	38 (1.50)
1-1/4 x 1-1/4 x 1	42.2 (1.66)	33.4 (1.32)	48 (1.88)	48 (1.88)
1-1/4 x 1-1/4 x 3/4	42.2 (1.66)	26.7 (1.05)	48 (1.88)	48 (1.88)
1-1/4 x 1-1/4 x 1/2	42.2 (1.66)	21.3 (0.84)	48 (1.88)	48 (1.88)
1-1/2 x 1-1/2 x 1-1/4	48.3 (1.90)	42.2 (1.66)	57 (2.25)	57 (2.25)
1-1/2 x 1-1/2 x 1	48.3 (1.90)	33.4 (1.32)	57 (2.25)	57 (2.25)
1-1/2 x 1-1/2 x 3/4	48.3 (1.90)	26.7 (1.05)	57 (2.25)	57 (2.25)
1-1/2 x 1-1/2 x 1/2	48.3 (1.90)	21.3 (0.84)	57 (2.25)	57 (2.25)
2 x 2 x 1-1/2	60.3 (2.38)	48.3 (1.90)	64 (2.50)	60 (2.38)
2 x 2 x 1-1/4	60.3 (2.38)	42.2 (1.66)	64 (2.50)	57 (2.25)
2 x 2 x 1	60.3 (2.38)	33.4 (1.32)	64 (2.50)	51 (2.00)
2 x 2 x 3/4	60.3 (2.38)	26.7 (1.05)	64 (2.50)	44 (1.75)
2-1/2 x 2-1/2 x 2	73.0 (2.88)	60.3 (2.38)	76 (3.00)	70 (2.75)
2-1/2 x 2-1/2 x 1-1/2	73.0 (2.88)	48.3 (1.90)	76 (3.00)	67 (2.62)
2-1/2 x 2-1/2 x 1-1/4	73.0 (2.88)	42.2 (1.66)	76 (3.00)	64 (2.50)
2-1/2 x 2-1/2 x 1	73.0 (2.88)	33.4 (1.32)	76 (3.00)	57 (2.25)
3 x 3 x 2-1/2	88.9 (3.50)	73.0 (2.88)	86 (3.38)	83 (3.25)
3 x 3 x 2	88.9 (3.50)	60.3 (2.38)	86 (3.38)	76 (3.00)
3 x 3 x 1-1/2	88.9 (3.50)	48.3 (1.90)	86 (3.38)	73 (2.88)
3 x 3 x 1-1/4	88.9 (3.50)	42.2 (1.66)	86 (3.38)	70 (2.75)
3-1/2 x 3-1/2 x 3	101.6 (4.00)	88.9 (3.50)	95 (3.75)	92 (3.62)
3-1/2 x 3-1/2 x 2-1/2	101.6 (4.00)	73.0 (2.88)	95 (3.75)	89 (3.50)
3-1/2 x 3-1/2 x 2	101.6 (4.00)	60.3 (2.38)	95 (3.75)	83 (3.25)
3-1/2 x 3-1/2 x 1-1/2	101.6 (4.00)	48.3 (1.90)	95 (3.75)	79 (3.12)
4 x 4 x 3-1/2	114.3 (4.50)	101.6 (4.00)	105 (4.12)	102 (4.00)
4 x 4 x 3	114.3 (4.50)	88.9 (3.50)	105 (4.12)	98 (3.88)
4 x 4 x 2-1/2	114.3 (4.50)	73.0 (2.88)	105 (4.12)	95 (3.75)
4 x 4 x 2	114.3 (4.50)	60.3 (2.38)	105 (4.12)	89 (3.50)
4 x 4 x 1-1/2	114.3 (4.50)	48.3 (1.90)	105 (4.12)	86 (3.38)
5 x 5 x 4	141.3 (5.56)	114.3 (4.50)	124 (4.88)	117 (4.62)
5 x 5 x 3-1/2	141.3 (5.56)	101.6 (4.00)	124 (4.88)	114 (4.50)
5 x 5 x 3	141.3 (5.56)	88.9 (3.50)	124 (4.88)	111 (4.38)
5 x 5 x 2-1/2	141.3 (5.56)	73.0 (2.88)	124 (4.88)	108 (4.25)
5 x 5 x 2	141.3 (5.56)	60.3 (2.38)	124 (4.88)	105 (4.12)
6 x 6 x 5	168.3 (6.62)	141.3 (5.56)	143 (5.62)	137 (5.38)
6 x 6 x 4	168.3 (6.62)	114.3 (4.50)	143 (5.62)	130 (5.12)
6 x 6 x 3-1/2	168.3 (6.62)	101.6 (4.00)	143 (5.62)	127 (5.00)
6 x 6 x 3	168.3 (6.62)	88.9 (3.50)	143 (5.62)	124 (4.88)
6 x 6 x 2-1/2	168.3 (6.62)	73.0 (2.88)	143 (5.62)	121 (4.75)
8 x 8 x 6	219.1 (8.62)	168.3 (6.62)	178 (7.00)	168 (6.62)
8 x 8 x 5	219.1 (8.62)	141.3 (5.56)	178 (7.00)	162 (6.38)
8 x 8 x 4	219.1 (8.62)	114.3 (4.50)	178 (7.00)	156 (6.12)
8 x 8 x 3-1/2	219.1 (8.62)	101.6 (4.00)	178 (7.00)	152 (6.00)
10 x 10 x 8	273.0 (10.75)	219.1 (8.62)	216 (8.50)	203 (8.00)
10 x 10 x 6	273.0 (10.75)	168.3 (6.62)	216 (8.50)	194 (7.62)
10 x 10 x 5	273.0 (10.75)	141.3 (5.56)	216 (8.50)	191 (7.50)
10 x 10 x 4	273.0 (10.75)	114.3 (4.50)	216 (8.50)	184 (7.25)

Reducing Outlet Tees 2/2

ASTM A403 / ASME B16.9

Unit: mm (in.)



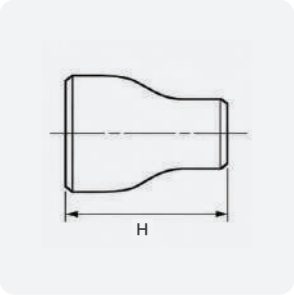
Reducing Outlet Tees

Nominal Pipe Size [NPS]	OD at Bevel		Run, C	Outlet, M
	Run	Outlet		
12 x 12 x 10	323.8 (12.75)	273.0 (10.75)	254 (10.00)	241 (9.50)
12 x 12 x 8	323.8 (12.75)	219.1 (8.62)	254 (10.00)	229 (9.00)
12 x 12 x 6	323.8 (12.75)	168.3 (6.62)	254 (10.00)	219 (8.62)
12 x 12 x 5	323.8 (12.75)	141.3 (5.56)	254 (10.00)	216 (8.50)
14 x 14 x 12	355.6 (14.00)	323.8 (12.75)	279 (11.00)	270 (10.62)
14 x 14 x 10	355.6 (14.00)	273.0 (10.75)	279 (11.00)	257 (10.12)
14 x 14 x 8	355.6 (14.00)	219.1 (8.62)	279 (11.00)	248 (9.75)
14 x 14 x 6	355.6 (14.00)	168.3 (6.62)	279 (11.00)	238 (9.38)
16 x 16 x 14	406.4 (16.00)	355.6 (14.00)	305 (12.00)	305 (12.00)
16 x 16 x 12	406.4 (16.00)	323.8 (12.75)	305 (12.00)	295 (11.62)
16 x 16 x 10	406.4 (16.00)	273.0 (10.75)	305 (12.00)	283 (11.12)
16 x 16 x 8	406.4 (16.00)	219.1 (8.62)	305 (12.00)	273 (10.75)
18 x 18 x 16	457.0 (18.00)	406.4 (16.00)	343 (13.50)	330 (13.00)
18 x 18 x 14	457.0 (18.00)	355.6 (14.00)	343 (13.50)	330 (13.00)
18 x 18 x 12	457.0 (18.00)	323.8 (12.75)	343 (13.50)	321 (12.62)
18 x 18 x 10	457.0 (18.00)	273.0 (10.75)	343 (13.50)	308 (12.12)
20 x 20 x 18	508.0 (20.00)	457.0 (18.00)	381 (15.00)	368 (14.50)
20 x 20 x 16	508.0 (20.00)	406.4 (16.00)	381 (15.00)	356 (14.00)
20 x 20 x 14	508.0 (20.00)	355.6 (14.00)	381 (15.00)	356 (14.00)
20 x 20 x 12	508.0 (20.00)	323.8 (12.75)	381 (15.00)	346 (13.62)
22 x 22 x 20	559.0 (22.00)	508.0 (20.00)	419 (16.50)	406 (16.00)
22 x 22 x 18	559.0 (22.00)	457.0 (18.00)	419 (16.50)	394 (15.50)
22 x 22 x 16	559.0 (22.00)	406.4 (16.00)	419 (16.50)	381 (15.00)
22 x 22 x 14	559.0 (22.00)	355.6 (14.00)	419 (16.50)	381 (15.00)
24 x 24 x 22	610.0 (24.00)	559.0 (22.00)	432 (17.00)	432 (17.00)
24 x 24 x 20	610.0 (24.00)	508.0 (20.00)	432 (17.00)	432 (17.00)
24 x 24 x 18	610.0 (24.00)	457.0 (18.00)	432 (17.00)	419 (16.50)
24 x 24 x 16	610.0 (24.00)	406.4 (16.00)	432 (17.00)	406 (16.00)

Concentric Reducer

ASTM A403 / ASME B16.9

Unit: mm (in.)



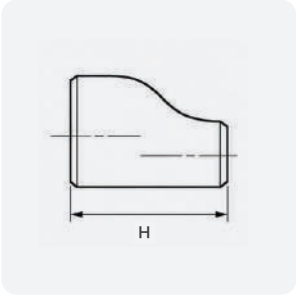
Concentric

Nominal Pipe Size [NPS]	OD at Bevel		End-to-End, H
	Large End	Small End	
3/4 x 1/2	26.7 (1.05)	21.3 (0.84)	38 (1.50)
1 x 3/4	33.4 (1.32)	26.7 (1.05)	51 (2.00)
1 x 1/2	33.4 (1.32)	21.3 (0.84)	51 (2.00)
1-1/4 x 1	42.2 (1.66)	33.4 (1.32)	51 (2.00)
1-1/4 x 3/4	42.2 (1.66)	26.7 (1.05)	51 (2.00)
1-1/4 x 1/2	42.2 (1.66)	21.3 (0.84)	51 (2.00)
1-1/2 x 1-1/4	48.3 (1.90)	42.2 (1.66)	64 (2.50)
1-1/2 x 1	48.3 (1.90)	33.4 (1.32)	64 (2.50)
1-1/2 x 3/4	48.3 (1.90)	26.7 (1.05)	64 (2.50)
1-1/2 x 1/2	48.3 (1.90)	21.3 (0.84)	64 (2.50)
2 x 1-1/2	60.3 (2.38)	48.3 (1.90)	76 (3.00)
2 x 1-1/4	60.3 (2.38)	42.2 (1.66)	76 (3.00)
2 x 1	60.3 (2.38)	33.4 (1.32)	76 (3.00)
2 x 3/4	60.3 (2.38)	26.7 (1.05)	76 (3.00)
2-1/2 x 2	73.0 (2.88)	60.3 (2.38)	89 (3.50)
2-1/2 x 1-1/2	73.0 (2.88)	48.3 (1.90)	89 (3.50)
2-1/2 x 1-1/4	73.0 (2.88)	42.2 (1.66)	89 (3.50)
2-1/2 x 1	73.0 (2.88)	33.4 (1.32)	89 (3.50)
3 x 2-1/2	88.9 (3.50)	73.0 (2.88)	89 (3.50)
3 x 2	88.9 (3.50)	60.3 (2.38)	89 (3.50)
3 x 1-1/2	88.9 (3.50)	48.3 (1.90)	89 (3.50)
3 x 1-1/4	88.9 (3.50)	42.2 (1.66)	89 (3.50)
3-1/2 x 3	101.6 (4.00)	88.9 (3.50)	102 (4.00)
3-1/2 x 2-1/2	101.6 (4.00)	73.0 (2.88)	102 (4.00)
3-1/2 x 2	101.6 (4.00)	60.3 (2.38)	102 (4.00)
3-1/2 x 1-1/2	101.6 (4.00)	48.3 (1.90)	102 (4.00)
4 x 3-1/2	114.3 (4.50)	101.6 (4.00)	102 (4.00)
4 x 3	114.3 (4.50)	88.9 (3.50)	102 (4.00)
4 x 2-1/2	114.3 (4.50)	73.0 (2.88)	102 (4.00)
4 x 2	114.3 (4.50)	60.3 (2.38)	102 (4.00)
4 x 1-1/2	114.3 (4.50)	48.3 (1.90)	102 (4.00)
5 x 4	141.3 (5.56)	114.3 (4.50)	127 (5.00)
5 x 3-1/2	141.3 (5.56)	101.6 (4.00)	127 (5.00)
5 x 3	141.3 (5.56)	88.9 (3.50)	127 (5.00)
5 x 2-1/2	141.3 (5.56)	73.0 (2.88)	127 (5.00)
5 x 2	141.3 (5.56)	60.3 (2.38)	127 (5.00)
6 x 5	168.3 (6.62)	141.3 (5.56)	140 (5.50)
6 x 4	168.3 (6.62)	114.3 (4.50)	140 (5.50)
6 x 3-1/2	168.3 (6.62)	101.6 (4.00)	140 (5.50)
6 x 3	168.3 (6.62)	88.9 (3.50)	140 (5.50)
6 x 2-1/2	168.3 (6.62)	73.0 (2.88)	140 (5.50)

Eccentric Reducer

ASTM A403 / ASME B16.9

Unit: mm (in.)



Eccentric

Nominal Pipe Size [NPS]	OD at Bevel		End-to-End, H
	Large End	Small End	
8 x 6	219.1 (8.62)	168.3 (6.62)	152 (6.00)
8 x 5	219.1 (8.62)	141.3 (5.56)	152 (6.00)
8 x 4	219.1 (8.62)	114.3 (4.50)	152 (6.00)
8 x 3-1/2	219.1 (8.62)	101.6 (4.00)	152 (6.00)
10 x 8	273.0 (10.75)	219.1 (8.62)	178 (7.00)
10 x 6	273.0 (10.75)	168.3 (6.62)	178 (7.00)
10 x 5	273.0 (10.75)	141.3 (5.56)	178 (7.00)
10 x 4	273.0 (10.75)	114.3 (4.50)	178 (7.00)
12 x 10	323.8 (12.75)	273.0 (10.75)	203 (8.00)
12 x 8	323.8 (12.75)	219.1 (8.62)	203 (8.00)
12 x 6	323.8 (12.75)	168.3 (6.62)	203 (8.00)
12 x 5	323.8 (12.75)	141.3 (5.56)	203 (8.00)
14 x 12	355.6 (14.00)	323.8 (12.75)	330 (13.00)
14 x 10	355.6 (14.00)	273.0 (10.75)	330 (13.00)
14 x 8	355.6 (14.00)	219.1 (8.62)	330 (13.00)
14 x 6	355.6 (14.00)	168.3 (6.62)	330 (13.00)
16 x 14	406.4 (16.00)	355.6 (14.00)	356 (14.00)
16 x 12	406.4 (16.00)	323.8 (12.75)	356 (14.00)
16 x 10	406.4 (16.00)	273.0 (10.75)	356 (14.00)
16 x 8	406.4 (16.00)	219.1 (8.62)	356 (14.00)
18 x 16	457.0 (18.00)	406.4 (16.00)	381 (15.00)
18 x 14	457.0 (18.00)	355.6 (14.00)	381 (15.00)
18 x 12	457.0 (18.00)	323.8 (12.75)	381 (15.00)
18 x 10	457.0 (18.00)	273.0 (10.75)	381 (15.00)
20 x 18	508.0 (20.00)	457.0 (18.00)	508 (20.00)
20 x 16	508.0 (20.00)	406.4 (16.00)	508 (20.00)
20 x 14	508.0 (20.00)	355.6 (14.00)	508 (20.00)
20 x 12	508.0 (20.00)	323.8 (12.75)	508 (20.00)
22 x 20	559.0 (22.00)	508.0 (20.00)	508 (20.00)
22 x 18	559.0 (22.00)	457.0 (18.00)	508 (20.00)
22 x 16	559.0 (22.00)	406.4 (16.00)	508 (20.00)
22 x 14	559.0 (22.00)	355.6 (14.00)	508 (20.00)
24 x 22	610.0 (24.00)	559.0 (22.00)	508 (20.00)
24 x 20	610.0 (24.00)	508.0 (20.00)	508 (20.00)
24 x 18	610.0 (24.00)	457.0 (18.00)	508 (20.00)
24 x 16	610.0 (24.00)	406.4 (16.00)	508 (20.00)

Caps

ASTM A403 / ASME B16.9

Unit: mm (in.)

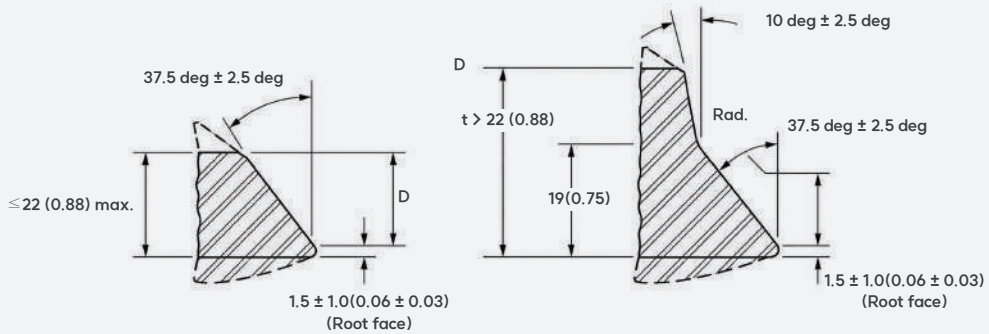


Caps

Nominal Pipe Size [NPS]	OD at Bevel	Wall Thickness Limit for Length E	E when t ≤ Limit	E when t ≤ Limit
1/2	21.3 (0.84)	4.57 (0.18)	25 (1.00)	25 (1.00)
3/4	26.7 (1.05)	3.81 (0.15)	25 (1.00)	25 (1.00)
1	33.4 (1.32)	4.57 (0.18)	38 (1.50)	38 (1.50)
1-1/4	42.2 (1.66)	4.83 (0.19)	38 (1.50)	38 (1.50)
1-1/2	48.3 (1.90)	5.08 (0.20)	38 (1.50)	38 (1.50)
2	60.3 (2.38)	5.59 (0.22)	38 (1.50)	44 (1.75)
2-1/2	73.0 (2.88)	7.11 (0.28)	38 (1.50)	51 (2.00)
3	88.9 (3.50)	7.62 (0.30)	51 (2.00)	64 (2.50)
3-1/2	101.6 (4.00)	8.13 (0.32)	64 (2.50)	76 (3.00)
4	114.3 (4.50)	8.64 (0.34)	64 (2.50)	76 (3.00)
5	141.3 (5.56)	9.65 (0.38)	76 (3.00)	89 (3.50)
6	168.3 (6.62)	10.92 (0.43)	89 (3.50)	102 (4.00)
8	219.1 (8.62)	12.70 (0.50)	102 (4.00)	127 (5.00)
10	273.0 (10.75)	12.70 (0.50)	127 (5.00)	152 (6.00)
12	323.8 (12.75)	12.70 (0.50)	152 (6.00)	178 (7.00)
14	355.6 (14.00)	12.70 (0.50)	165 (6.50)	191 (7.50)
16	406.4 (16.00)	12.70 (0.50)	178 (7.00)	203 (8.00)
18	457.0 (18.00)	12.70 (0.50)	203 (8.00)	229 (9.00)
20	508.0 (20.00)	12.70 (0.50)	229 (9.00)	254 (10.00)
22	559.0 (22.00)	12.70 (0.50)	254 (10.00)	254 (10.00)
24	610.0 (24.00)	12.70 (0.50)	267 (10.50)	305 (12.00)

General Note: Caps are ellipsoidal in shape and conform to ASME B16.9 dimensional requirements.

Welding Bevels and Root Face



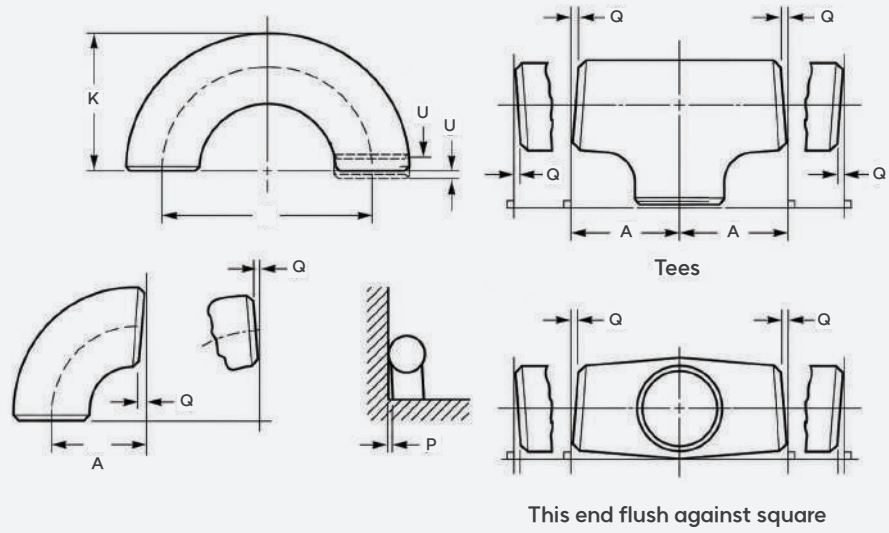
End Preparation Criteria

Nominal Wall Thickness (t)	End Preparation
t < x	Square cut or slight chamfer
x ≤ t ≤ 22 mm (0.88 in.)	x ≤ t ≤ 22 mm (0.88 in.) Plain bevel
t > 22 mm (0.88 in.)	t > 22 mm (0.88 in.) Compound bevel

Note: x = 3 mm (0.12 in.) for austenitic stainless steel (e.g., 304, 304L, 316, 316L)

- Applicable for NPS 1/2" through 24".
- All welding ends are prepared in accordance with ASME B16.9 requirements.
- Engineered to ensure superior weldability, structural integrity, and long-term service reliability

Tolerances



Unit: mm (in.)

Nominal Pipe Size [NPS]	Outside Diameter at Bevel	Inside Diameter at End	Center-to-End	Overall Length		Center-to-Center	Back-to-Face	Alignment of Ends
			A,B,C,M	F,H	E	O	K	U
1/2 to 2-1/2	+1.6, -0.8 (+0.06, -0.03)	0.8 (0.03)	2 (0.06)	2 (0.06)	3 (0.12)	6 (0.25)	6 (0.25)	1 (0.03)
3 to 3-1/2	1.6 (0.06)	1.6 (0.06)	2 (0.06)	2 (0.06)	3 (0.12)	6 (0.25)	6 (0.25)	1 (0.03)
4	1.6 (0.06)	1.6 (0.06)	2 (0.06)	2 (0.06)	3 (0.12)	6 (0.25)	6 (0.25)	1 (0.03)
5 to 8	+2.4, -1.6 (+0.09, -0.06)	1.6 (0.06)	2 (0.06)	2 (0.06)	6 (0.25)	6 (0.25)	6 (0.25)	1 (0.03)
10 to 18	+4.0, -3.2 (+0.16, -0.12)	3.2 (0.12)	2 (0.09)	2 (0.09)	6 (0.25)	10 (0.38)	6 (0.25)	2 (0.06)
20 to 24	+6.4, -4.8 (+0.25, -0.19)	4.8 (0.19)	2 (0.09)	2 (0.09)	6 (0.25)	10 (0.38)	6 (0.25)	2 (0.06)

Lap Joint Stub Ends				Angularity Tolerances		
Nominal Pipe Size [NPS]	Outside Diameter	Fillet Radius R	Lap Thickness, mm (in.)	Nominal Pipe Size [NPS]	Off Angle, Q	Off Plane, P
1/2 to 2-1/2	+0, -1 (+0, -0.03)	+0, -1 (+0, -0.03)	+1.6, -0 (+0.06, -0)	1/2 to 4	1 (0.03)	2 (0.06)
3 to 3-1/2	+0, -1 (+0, -0.03)	+0, -1 (+0, -0.03)	+1.6, -0 (+0.06, -0)	5 to 8	2 (0.06)	4 (0.12)
4	+0, -1 (+0, -0.03)	+0, -2 (+0, -0.06)	+1.6, -0 (+0.06, -0)	10 to 12	3 (0.09)	5 (0.19)
5 to 8	+0, -1 (+0, -0.03)	+0, -2 (+0, -0.06)	+1.6, -0 (+0.06, -0)	14 to 16	3 (0.09)	6 (0.25)
10 to 18	+0, -2 (+0, -0.06)	+0, -2 (+0, -0.06)	+3.2, -0 (+0.12, -0)	18 to 24	4 (0.12)	10 (0.38)
20 to 24	+0, -2 (+0, -0.06)	+0, -2 (+0, -0.06)	+3.2, -0 (+0.12, -0)			

ADDITIONAL NOTE: Basic wall thickness undertolerance: -12.5%. Unless otherwise specified by the purchaser, the minimum wall thickness shall be 87.5% of the marked nominal thickness, in accordance with ASME B16.9, para. 11.1.

02 STAINLESS STEEL GROOVED FITTINGS



Daeyoung Bend's stainless steel grooved fittings are designed for fast, reliable, and efficient mechanical piping connections. Compared with conventional welding methods, grooved piping systems help reduce installation time,minimize hot work at the job site, and provide excellent flexibility for maintenance and system modification.
Manufactured with accumulated forming technology and strict quality control, our stainless grooved fittings are suitable for a wide range of industrial, commercial, and sanitary piping applications.

- Quick and convenient installation without field welding
- Suitable for mechanical pipe joining systems
- Excellent corrosion resistance of stainless steel
- Reduced installation time and labor cost
- Easy maintenance, replacement, and system expansion
- Stable sealing performance when used with compatible grooved couplings and gaskets
- Applicable to plant facilities, mechanical rooms, utility piping, water supply systems, and industrial piping lines

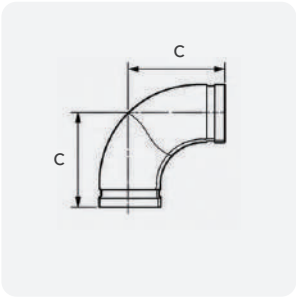


Dimensions and specifications shown in this catalog are standard reference values. Customized dimensions, materials, or specifications may be available upon request depending on project requirements.

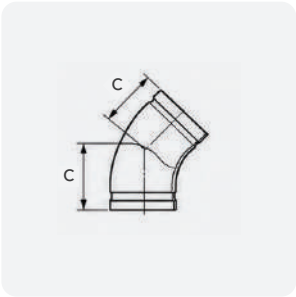
90° / 45°Elbows

ASTM A403 / ASME B16.9

Unit: mm (in.)



90° Elbows



45° Elbows

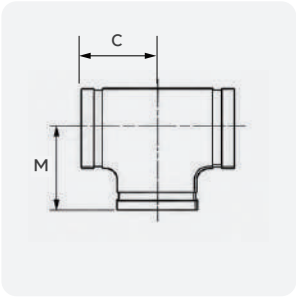
Nominal Pipe Size [NPS]	Outside Diameter	90° ELBOW			45° ELBOW		
		C	S10(kg)	S20(kg)	C to E	S10(kg)	S20(kg)
2	60.3	92.3	0.58	0.71	57.8	0.21	0.27
2-1/2	73.0	110.9	0.94	1.09	65.8	0.37	0.43
3	88.9	128.5	1.28	1.69	70.0	0.51	0.67
3-1/2	101.6	152.4	2.60	2.80	83.1	0.96	1.30
4	114.3	169.5	3.42	4.97	78.9	1.71	2.49
5	141.3	228.6	4.87	7.09	94.7	2.49	3.54
6	168.3	304.8	10.0	16.1	126.3	5.01	8.05
8	219.1	381.0	16.6	25.0	157.8	7.77	12.5
10	273.0	457.2	25.9	35.9	189.4	12.5	17.9
12	323.8	355.6	23.1	37.8	220.9	17.3	28.5
14	355.6	406.4	30.2	49.5	252.5	22.7	37.3
16	406.4	457.2	38.2	62.8	284.1	28.7	47.3
18	457.0	508.0	54.7	77.7	315.8	41.1	58.5
20	508.0	558.8	66.3	114.0	347.2	49.8	85.5
22	559.0	609.6	90.4	135.0	378.7	68.0	101.0

※ For 90° Elbows, sizes 350A and larger, use short radius elbow dimensions.

Straight Tees

ASTM A403 / ASME B16.9

Unit: mm (in.)

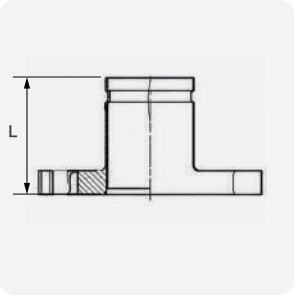


Straight Tees

Nominal Pipe Size [NPS]	Outside Diameter	STRAIGHT TEE			
		C	M	S10(kg)	S20(kg)
2	60.3	78.5	78.5	0.79	0.98
2-1/2	73.0	85.0	85.0	1.13	1.31
3	88.9	86.0	86.0	1.30	1.71
3-1/2	101.6	105.0	105.0	2.03	2.48
4	114.3	124.0	124.0	3.35	4.88
5	141.3	143.0	143.0	4.65	6.77
6	168.3	178.0	178.0	8.91	14.3
8	219.1	216.0	216.0	13.4	21.5
10	273.0	254.0	254.0	27.0	30.1
12	323.8	279.5	279.5	27.3	44.8
14	355.6	305.0	305.0	31.5	53.5
16	406.4	343.0	343.0	42.7	70.0
18	457.0	381.0	381.0	61.0	86.8
20	508.0	419.0	419.0	74.1	126.2
22	559.0	432.0	432.0	93.9	139.4

Flange Adapters

Unit: mm (in.)

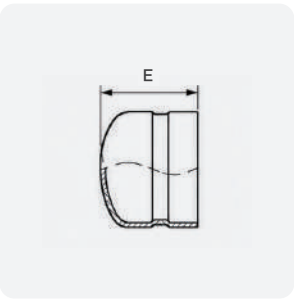


Flange Adapters

Nominal Pipe Size [NPS]	Outside Diameter	L	S10(kg)	S20(kg)
2	60.3	86.0	2.2	2.3
2-1/2	73.0	85.0	3.1	3.1
3	88.9	85.0	3.2	4.5
3-1/2	101.6	90.0	3.9	5.9
4	114.3	95.0	5.9	9.4
5	141.3	100.0	7.7	12.1
6	168.3	115.0	10.0	16.5
8	219.1	120.0	14.9	27.0
10	273.0	120.0	16.9	31.9
12	323.8	190.0	24.4	49.2
14	355.6	220.0	33.6	69.0
16	406.4	225.0	41.7	86.0
18	457.0	260.0	51.4	103.0
20	508.0	280.0	64.3	128.8
22	559.0	285.0	73.1	141.6

Caps

Unit: mm (in.)

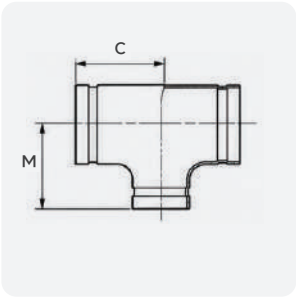


Caps

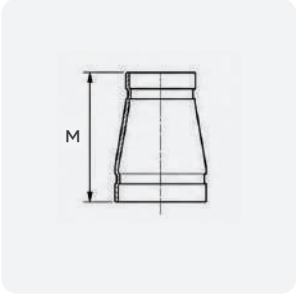
Nominal Pipe Size [NPS]	Outside Diameter	E	S10(kg)	S20(kg)
2	60.3	51.0	0.20	0.24
2-1/2	73.0	53.0	0.29	0.33
3	88.9	66.0	0.41	0.54
3-1/2	101.6	63.5	0.59	0.78
4	114.3	76.2	0.99	1.44
5	141.3	88.9	1.39	1.99
6	168.3	101.8	2.38	4.05
8	219.1	127.0	4.13	6.23
10	273.0	152.4	6.39	8.99
12	323.8	165.1	7.99	13.2
14	355.6	177.8	10.1	16.7
16	406.4	203.2	12.9	21.3
18	457.0	228.6	18.5	31.8
20	508.0	254.0	22.8	36.8
22	559.0	266.7	30.1	45.1

Reducing Tees, Reducers

Unit: mm (in.)



Reducing Tees

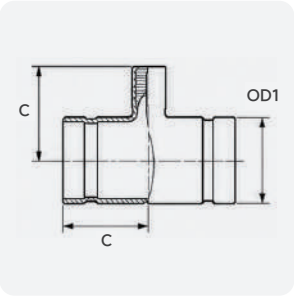


Reducers

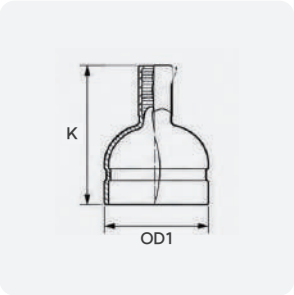
Nominal Pipe Size [NPS]	Reducing Tees				Reducers		
	C	M	S10(kg)	S20(kg)	H	S10(kg)	S20(kg)
2-1/2" x 2"	85.0	85.0	1.07	1.26	110.0	0.55	0.62
3" x 2-1/2"	86.0	89.0	1.28	1.64	110.0	0.67	0.86
3" x 2"	86.0	89.0	1.25	1.61	110.0	0.60	0.78
4" x 3"	105.0	105.0	1.95	2.58	125.0	0.94	1.22
4" x 2-1/2"	105.0	105.0	1.92	2.49	125.0	0.88	1.14
4" x 2"	105.0	105.0	1.87	2.46	125.0	0.80	1.04
5" x 4"	124.0	124.0	3.12	4.47	150.0	1.57	2.28
5" x 3"	124.0	124.0	3.07	4.41	150.0	1.41	2.05
5" x 2-1/2"	124.0	124.0	3.04	4.33	150.0	1.33	1.93
6" x 5"	143.0	136.5	4.30	6.28	170.0	2.15	3.12
6" x 4"	143.0	136.5	4.14	5.96	170.0	1.96	2.85
6" x 3"	143.0	136.5	4.10	5.93	170.0	1.78	2.59
8" x 6"	178.0	170.0	8.01	12.72	190.0	3.33	5.67
8" x 5"	178.0	170.0	7.87	12.54	190.0	3.10	5.28
8" x 4"	178.0	165.0	7.67	12.17	190.0	2.88	4.89
10" x 8"	216.0	216.0	12.25	19.77	220.0	5.46	8.38
10" x 6"	216.0	216.0	11.84	18.89	220.0	4.87	7.47
10" x 5"	216.0	216.0	11.79	18.84	220.0	4.58	7.02
12" x 10"	254.0	254.0	18.9	27.7	260.0	8.54	12.1
12" x 8"	254.0	235.0	18.4	26.8	260.0	7.78	11.0
12" x 6"	254.0	235.0	18.1	26.1	260.0	7.02	9.91
14" x 12"	279.5	270.0	25.8	43.2	330.0	13.1	21.7
14" x 10"	279.5	257.5	24.7	41.0	330.0	12.1	20.0
16" X 14"	305.0	305.0	31.5	53.5	356.0	15.9	26.4
16" x 12"	305.0	295.5	30.2	51.2	356.0	15.2	25.1
18" x 16"	343.0	330.0	40.1	67.5	381.0	18.1	32.2
18" x 14"	343.0	330.0	38.4	64.7	381.0	17.0	30.3
20" x 18"	381.0	368.5	57.5	84.0	508.0	33.5	56.9
20" x 16"	381.0	355.5	55.0	80.5	508.0	31.7	53.8
22" x 20"	419.0	406.5	71.8	124.0	508.0	37.0	63.0
22" x 18"	419.0	394.0	68.8	118.8	508.0	35.2	59.9
24" x 22"	432.0	432.0	90.7	136.4	508.0	46.4	69.1
24" x 20"	432.0	432.0	86.9	130.6	508.0	44.4	66.0

Socket Tees, Socket Reducers

Unit: mm (in.)



Socket Tees



Socket Reducers

Nominal Pipe Size [NPS]	Socket Tees				Socket Reducers		
	OD1	Thread	C	M	OD1	Thread	K
2" x 1/2"	60.3	1/2"	63.5	68.0	60.3	1/2"	82.0
2" x 3/4"	60.3	3/4"	63.5	81.0	60.3	3/4"	85.0
2" x 1"	60.3	1"	63.5	94.0	60.3	1"	92.0
2" x 1-1/4"	60.3	1-1/4"	63.5	105.0	60.3	1-1/4"	97.0
2" x 1-1/2"	60.3	1-1/2"	63.5	108.0	60.3	1-1/2"	124.0
2-1/2" x 1/2"	73.0	1/2"	76.2	76.0	73.0	1/2"	86.8
2-1/2" x 3/4"	73.0	3/4"	76.2	79.0	73.0	3/4"	89.0
2-1/2" x 1"	73.0	1"	76.2	100.0	73.0	1"	96.0
2-1/2" x 1-1/4"	73.0	1-1/4"	76.2	112.0	73.0	1-1/4"	101.0
2-1/2" x 1-1/2"	73.0	1-1/2"	76.2	115.0	73.0	1-1/2"	137.0
2-1/2" x 2"	73.0	2"	76.2	126.0	73.0	2"	145.0
3" x 1/2"	88.9	1/2"	85.7	82.0	88.9	1/2"	97.0
3" x 3/4"	88.9	3/4"	85.7	85.0	88.9	3/4"	100.0
3" x 1"	88.9	1"	85.7	93.0	88.9	1"	107.0
3" x 1-1/4"	88.9	1-1/4"	85.7	118.0	88.9	1-1/4"	112.0
3" x 1-1/2"	88.9	1-1/2"	85.7	112.0	88.9	1-1/2"	112.0
3" x 2"	88.9	2"	85.7	132.0	88.9	2"	145.0
4" x 1/2"	114.3	1/2"	104.8	95.0	114.3	1/2"	95.0
4" x 3/4"	114.3	3/4"	104.8	98.0	114.3	3/4"	98.0
4" x 1"	114.3	1"	104.8	106.0	114.3	1"	105.0
4" x 1-1/4"	114.3	1-1/4"	104.8	112.0	114.3	1-1/4"	110.0
4" x 1-1/2"	114.3	1-1/2"	104.8	134.0	114.3	1-1/2"	110.0
4" x 2"	114.3	2"	104.8	145.0	114.3	2"	158.0
5" x 1/2"	141.3	1/2"	123.8	107.0	141.3	1/2"	107.0
5" x 3/4"	141.3	3/4"	123.8	110.0	141.3	3/4"	110.0
5" X 1"	141.3	1"	123.8	118.0	141.3	1"	117.0
5" x 1-1/4"	141.3	1-1/4"	123.8	124.0	141.3	1-1/4"	122.0
5" x 1-1/2"	141.3	1-1/2"	123.8	126.0	141.3	1-1/2"	122.0
5" x 2"	141.3	2"	123.8	161.0	141.3	2"	130.0
6" x 1/2"	168.3	1/2"	142.9	120.0	168.3	1/2"	120.0
6" x 3/4"	168.3	3/4"	142.9	123.0	168.3	3/4"	123.0
6" x 1"	168.3	1"	142.9	131.0	168.3	1"	130.0
6" x 1-1/4"	168.3	1-1/4"	142.9	137.0	168.3	1-1/4"	135.0
6" x 1-1/2"	168.3	1-1/2"	142.9	139.0	168.3	1-1/2"	135.0
6" x 2"	168.3	2"	142.9	149.0	168.3	2"	143.0
8" x 1/2"	219.1	1/2"	177.8	146.0	219.1	1/2"	133.0
8" x 3/4"	219.1	3/4"	177.8	149.0	219.1	3/4"	136.0
8" x 1"	219.1	1"	177.8	157.0	219.1	1"	143.0
8" x 1-1/4"	219.1	1-1/4"	177.8	163.0	219.1	1-1/4"	148.0
8" x 1-1/2"	219.1	1-1/2"	177.8	164.0	219.1	1-1/2"	148.0
8" x 2"	219.1	2"	177.8	174.0	219.1	2"	156.0

03 PIPE GROOVING MACHINES

DSC-002 / DSC-004 / DSC-005 / DSC-006

Product Overview

Daeyoung Bend's mobile pipe grooving machines are designed for easy movement and installation, allowing convenient use at job sites. Equipped with a low-noise, durable geared reduction motor, the machines can be operated with simple controls and are easy to use even for first-time operators

Manual



Automatic



Specification

Category	DSC-002	DSC-004	DSC-005	DSC-006
Type	Manual	Manual	Automatic	Automatic
Model No.	DSC-002	DSC-004	DSC-005	DSC-006
Capacity	2″ ~ 12″ (Option: 1″~1 ½″)	2″ ~ 6″ (Option: 1″~1 ½″, 8″~12″)	2″ ~ 6″ (Option: 1″~1 ½″, 8″~12″)	2″ ~ 12″ (Option: 1″~1 ½″)
Tool Motor	2 HP	1 HP	1 HP	2 HP
Power Supply	220V, 60Hz, Single Phase	220V, 60Hz, Single Phase	220V, 60Hz, Single Phase	220V, 60Hz, Single Phase
Weight	139 kg	112 kg	130 kg	146 kg
Remark	Standard: 50A ~ 300A Others: Optional	Standard: : 2″ ~ 12″ Others: Optional	Standard: 2″ ~ 6″ Others: Optional	Standard: 2″ ~ 12″ Others: Optional

Key Features

- Mobile structure for easy job-site movement and setup.
- Suitable for roll grooving work on pipes used with grooved couplings.
- Manual and automatic models are available depending on work conditions.
- Simple operation helps improve field productivity and operator convenience.
- Durable construction designed for repeated industrial use.

DSC-003 Large-Size Pipe Grooving Machine

Product Overview

The DSC-003 model consists of a hydraulic system, an electrical control unit, and upper and lower roll assemblies. It performs automatic grooving through an electrically controlled hydraulic system and is designed exclusively for large-diameter pipes.





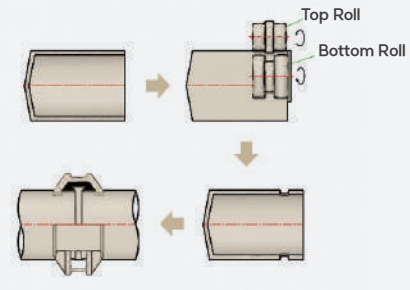
Specification

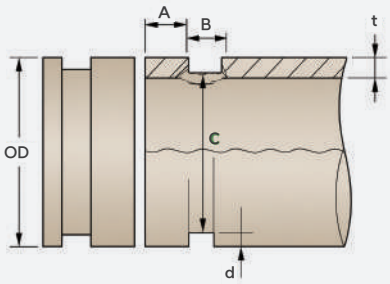
Item	Specification
Capacity	Pipe 8" - 24"
Electricity	380 V, 60 Hz
Hydraulic Pressure	150 kgf/cm²
Tool RPM	23 rpm
Main Pressing Force	10 Tons
Main Stroke	100 mm
Oil Tank Capacity	60 L
Tool Motor	5 HP, 4P, 1/60
Reduction Ratio	1/60
Output Speed	28.5 rpm
Hydraulic Motor	5 HP, 6P
Speed	Approx. 7.5 seconds per inch of pipe diameter

Catalog Note

Specifications may vary depending on pipe material, pipe thickness, tool configuration, and working conditions. Please consult Daeyoung Bend for detailed model selection and optional specifications.

GROOVING CHART





Dimension Reference

- A and B indicate the groove position and groove width reference dimensions.
- C indicates the groove diameter after roll grooving.
- d indicates groove depth.
- t indicates the minimum pipe wall thickness.
- Maximum allowable flare diameter indicates the permitted pipe-end flare after grooving.

Roll Grooving Dimensions

Unit: mm (in.)

Nominal Pipe Size [NPS]	Pipe OD (mm)	A (mm)	B (mm)	Tolerance for A, B	Groove Dia. C		Groove Depthd	Min. Wall Thickness t	Max. Allowable Flare Dia.
					Distance	Tolerance			
1″	33.4	15.9	7.1	± 0.8	30.2	-0.4	1.6	1.65	36.3
1-1/4″	42.2	15.9	7.1	± 0.8	39.0	-0.4	1.6	1.65	45.0
1-1/2″	48.3	15.9	7.1	± 0.8	45.1	-0.4	1.6	1.65	51.1
2″	60.3	15.9	8.7	± 0.8	57.2	-0.4	1.6	1.65	63.0
2-1/2″	73.0	15.9	8.7	± 0.8	69.1	-0.5	2.0	2.11	75.7
3″	88.9	15.9	8.7	± 0.8	84.9	-0.5	2.0	2.11	91.4
4″	114.3	15.9	8.7	± 0.8	110.1	-0.5	2.1	2.11	116.8
5″	141.3	15.9	8.7	± 0.8	137.0	-0.5	2.1	2.77	143.8
6″	168.3	15.9	8.7	± 0.8	164.0	-0.6	2.2	2.77	170.9
8″	219.1	19.0	11.9	± 0.8	214.4	-0.6	2.3	2.77	223.5
10″	273.0	19.0	11.9	± 0.8	268.3	-0.7	2.4	3.40	277.4
12″	323.8	19.0	11.9	± 0.8	318.2	-0.8	2.8	3.96	328.2
14″	355.6	23.8	11.9	± 0.8	350.0	-0.8	2.8	3.96	358.1
16″	406.4	23.8	11.9	± 0.8	400.8	-0.8	2.8	4.19	408.9
18″	457.0	25.4	11.9	± 0.8	451.4	-0.8	2.8	4.19	461.3
20″	508.0	25.4	11.9	± 0.8	502.4	-0.8	2.8	4.78	512.1
22″	559.0	25.4	12.7	± 0.8	550.2	-0.8	4.4	4.78	563.9
24″	610.0	25.4	12.7	± 0.8	601.2	-0.8	4.4	5.54	614.7

Extended Groove Depth Specification for large-diameter pipes

Unit: mm (in.)

Nominal Pipe Size [NPS]	Pipe OD (mm)	A (mm)	B (mm)	Tolerance for A, B	Groove Dia. C		Groove Depthd	Min. Wall Thickness t	Max. Allowable Flare Dia.
					Distance	Tolerance			
8″	219.1	19.1	11.9	± 0.8	209.0	-0.64	3.7	2.8	220.7
10″	273.0	19.1	11.9	± 0.8	260.0	-0.69	3.7	3.4	271.6
12″	323.8	19.1	11.9	± 0.8	310.0	-0.76	4.3	4.0	322.8
14″	355.6	23.8	11.9	± 0.8	347.0	-0.76	4.3	4.0	358.1
16″	406.4	23.8	11.9	± 0.8	397.0	-0.76	4.7	4.2	408.9

Note: For nominal sizes 200A and above, refer to the applicable steel pipe roll grooving dimension values and project specifications.

Catalog Note

Before installation, verify that the groove diameter, groove depth, pipe end condition, and flare diameter meet the specified requirements.

Grooving dimensions may vary depending on pipe material, wall thickness, equipment setup, and working conditions.

The values shown are reference dimensions for catalog use and should be confirmed against applicable project standards before production or installation.

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