

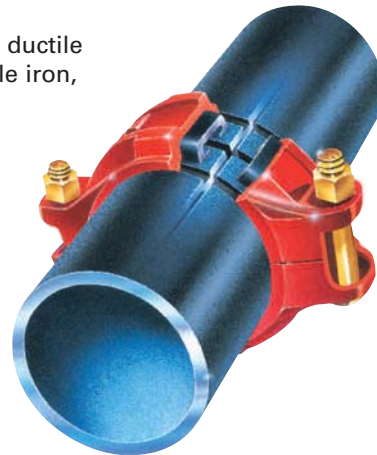
ΑΥΛΑΚΩΤΑ ΕΞΑΡΤΗΜΑΤΑ – ΠΑΡΕΜΒΥΣΜΑΤΑ

Metallurgical specifications:

Grinnell Grooved Products are manufactured in modern, state of the art ductile iron foundries. The following applicable material specifications for ductile iron, galvanizing and rubber-injection apply:

Housing & Fitting specifications

- Cast:
- ASTM A-536 – Standard specifications for Ductile Iron Castings Grade 65-45-12
 - Tensile Strength, minimum 65,000 psi
 - Yield Strength, minimum 45,000 psi
 - Elongation in 2" or 50 mm, minimum 12%
 - ASTM A-153 Standard Specification for Hot Dip Galvanizing

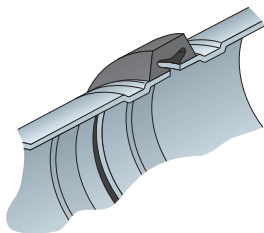


Fabricated:

Carbon steel according DIN/BS/ASTM Standard.
ASTM A-153 or DIN EN10240 [Previous DIN2444]
Standard Specification for Hot Dip Galvanizing

Gasket Specifications

Grade 'E' EPDM gaskets have a green color code identification and conform to ASTM D-2000 for service temperatures from -34°C [-30°F] to +110°C [+230°F]. They are recommended for hot water not to exceeding the +110°C [+230°F], plus a variety of dilute acids, oil free air and many chemical services. They are not recommended for petroleum services.



Grade 'T' Nitrile gaskets have an orange color code identification and conform to ASTM D-2000 for service temperatures from -29°C [-20°F] to +82°C [+180°F]. They are recommended for petroleum products, vegetable oils, mineral oils and air with oil vapors.

Bolt specifications

ANSI/Metric: Heat treated Carbon Steel Track Head Bolts conform to the physical properties of ASTM A-183 minimum Tensile Strength of 758,340 kPa (110,000 psi). Bolts and Nuts are zinc electroplated.

Paint Specifications:

Standard: Red RAL3000 - Non Lead
Optional: Hot Dip Zinc Galvanized

Nut size Wrench sizes

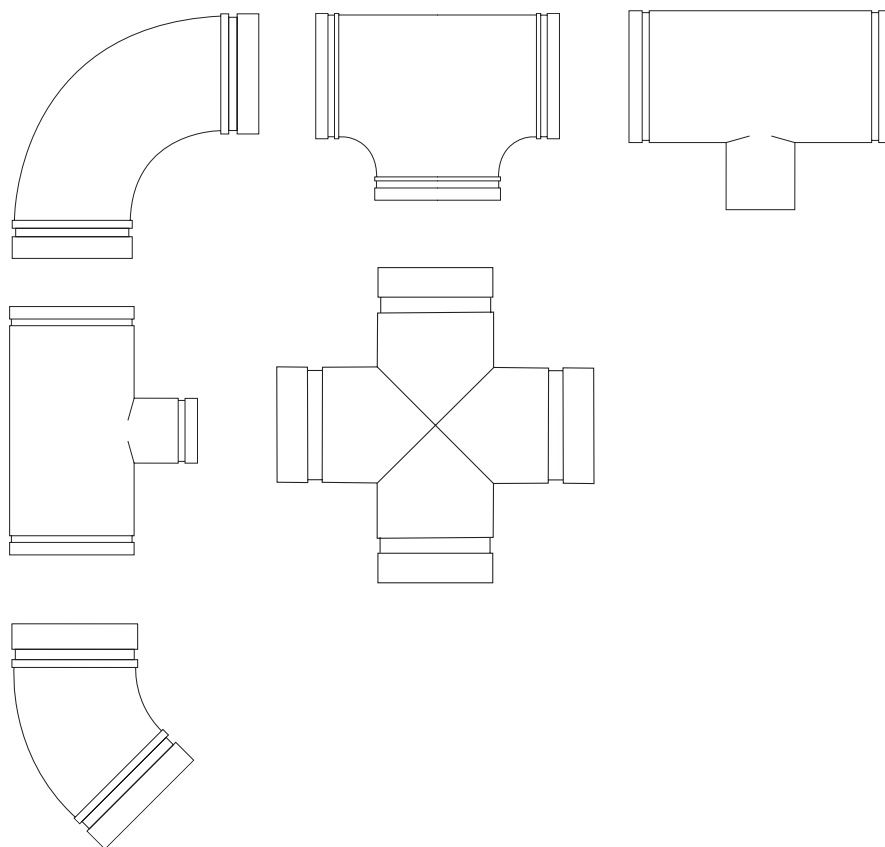
M10	17mm
M12	22mm
M16	27mm
M20	32mm
M22	36mm
M24	41mm

Note: All dimensions in this catalogue are nominal sizes.



ΧΡΥΣΑΦΙΔΗΣ Α.Ε.

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Grinnell Grooved Fittings provide an economical and efficient method of changing direction, adding and outlet, reducing, or capping grooved piping systems. Grinnell Grooved Fittings are rated at the same pressure rating of the coupling being used.

Pressure ratings of Grinnell standard casted fittings conform to those of fig. 707 Grinnell couplings.

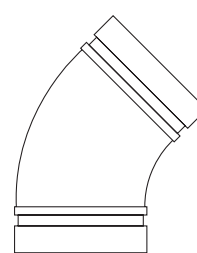
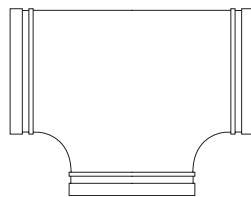
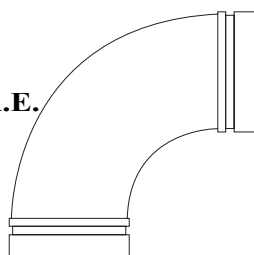


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ΧΡΥΣΑΦΙΔΗΣ Α.Ε.



FRICTION RESISTANCE (EXPRESSED AS EQUIVALENT STRAIGHT PIPE)

Nominal Size mm Inches	Pipe OD	Pipe Wall Thickness mm	Elbows 90° mtrs	Elbows 45° mtrs	Tee Branch mtrs	Tee Run mtrs
25 1	33.7	3.4	0.5	0.2	1.3	0.5
32 1 1/4	42.4	3.6	0.6	0.3	1.5	0.6
40 1 1/2	48.3	3.7	0.7	0.4	1.8	0.7
50 2	60.3	3.9	1.0	0.5	2.5	1.0
65 2 1/2	73.0	5.2	1.2	0.6	3.0	1.2
65 2 1/2	76.1	5.0	1.2	0.6	3.1	1.2
80 3	88.9	5.5	1.5	0.7	3.7	1.5
100 4	108.0	5.6	2.0	1.0	5.0	2.0
100 4	114.3	6.3	2.0	1.0	5.0	2.0
125 5	133.0	6.3	2.4	1.3	6.1	2.4
125 5	139.7	6.3	2.4	1.3	6.1	2.4
125 5	141.3	6.6	2.5	1.3	6.3	2.5
150 6	159.0	7.1	2.9	1.4	7.2	2.9
150 6	165.1	7.1	2.9	1.4	7.2	2.9
150 6	168.3	7.1	3.0	1.5	7.6	3.0
200 8	219.1	8.2	4.0	2.0	10.0	4.0
250 10	273.0	9.3	5.0	2.5	12.6	5.0
300 12	323.9	9.5	6.1	3.0	15.1	6.1
350 14	355.6	9.5	7.0	5.5	20.7	7.0
400 16	406.4	9.5	7.9	6.1	23.8	7.9
450 18	457.2	9.5	8.8	7.0	25.9	8.8
500 20	508.0	9.5	10.1	7.9	30.5	10.1
600 24	609.6	9.5	12.2	9.1	35.1	12.2

For the reducing tee and branches, use the value that is corresponding to the branch size. Example: For 6"x6"x3" tee, the branch value of 3" is 3.9 meters. For sizes not listed, interpolate from the values shown.

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Μ.Γ.ΧΡΥΣΑΦΙΔΗΣ Α.Ε.: ΑΘΗΝΑ: ΑΓΡΙΝΙΟΥ 3 ΤΑΥΡΟΣ, ΤΗΛ.:210-4836315-20, ΦΑΧ:210-4817000. ΘΕΣ/ΚΗ: 2οΚΜ ΘΕΣ/ΚΗΣ-ΚΑΛΟΧΩΡΙΟΥ, ΤΗΛ.:2310-754681-3, ΦΑΧ:2310-751835

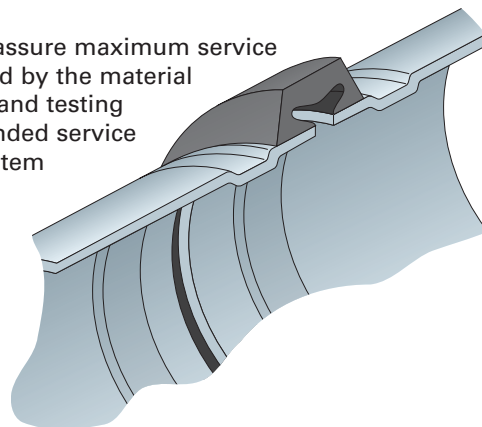
30/11/2004



Grinnell Gasket Grade Index and Recommendations

The Gasket Recommendation Tables have been developed to assure maximum service life. The tables have been developed from information supplied by the material manufacturers of the elastomer, technical reference literature and testing conducted by Grinnell. In evaluating the gasket grade for intended service applications consideration must be given to the following: system operating temperature, fluid or solution concentration, and duration of service.

All gasket recommendations are based on a temperature of 21°C (70°F) unless otherwise noted. Tyco Building Services Products should be consulted if combinations of service solutions are being considered. Contact Tyco Building Services Products for recommendations for services not listed. Gasket recommendations apply to Grinnell gaskets only. These listings do not apply for Grinnell Butterfly Valves.



Standard Gaskets

Grade	Temperature Range	Compound	Colour Code	General Service Application
E	-34°C to + 110°C (-30°F to +230°F)	EPDM	Green	Hot water, dilute acids, alkalies and many chemical services not involving petroleum products. Excellent oxidation resistance. NOT FOR USE WITH HYDROCARBONS
T	-29°C to + 82°C (-20°F to +180°F)	Nitrile (Buna-N)	Orange	Petroleum products, vegetable oils and air with oil vapors NOT FOR USE IN HOT WATER SERVICES

Tri-Seal freezer gasket

The Tri-Seal Grade E freezer gasket is used primarily for dry pipe fire protection systems, vacuum service, and freezer applications. The Tri-Seal freezer gasket differs from standard gaskets by closing off the gap of gasket cavity. This is accomplished by positioning the center "rib" of the gasket over the gap between the pipes. The Tri-Seal freezer gasket has two tapered sealing edges in addition to the center rib for additional strength and sealing.

The Tri-Seal freezer gasket is available in sizes 32mm to 300mm and is designed for use with Grinnell Figure 705, 705R, 707, 577, 772, 405 and 472 Couplings. A petroleum-free silicone based lubricant is recommended for all dry pipe systems. For low temperature services or dry systems in cold storage or freezer applications, use Tri-Seal freezer gaskets. For vacuum services greater than 10" Hg, Tri-Seal gaskets should be used.

Note: Rigid couplings are preferred for vacuum, dry pipe and freezer applications.



ΧΡΥΣΑΦΙΔΗΣ Α.Ε.

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- Contact Tyco BSP for an Engineering evaluation and recommendation where the gasket grade is shown in parenthesis.
- Specify gasket grade when ordering.
- For dry pipe systems or freezer systems, use Tri-Seal freezer gasket and petroleum free silicone lubricant.
- Check gasket colour code to be certain it is suitable for the service intended.
- Unless otherwise noted, all gasket listings are based upon a temperature of 21°C (70°F).
- For services not listed contact Tyco BSP for recommendation.
- Where more than one gasket is shown, the preferred gasket grade is listed first.

WATER & AIR

Service	Gasket Grade
Air, (no oil vapors), Temp. -34°C to + 110°C (-30°F to + 230°F)	E
Air, with oil vapors, Temp. -29°C to + 66°C (-20°F to + 150°F)	T
Water, Temperature to 66°C (150°F)	E/T
Water, Temperature to 110°C (230°F) [not recommended for steam services]	E
Water, Acid Mine	E/T
Water, Chlorine	E
Water, Deionized	E
Water, Seawater	E
Water, Waste (no petroleum products)	E

PETROLEUM PRODUCTS

Service	Gasket Grade
Crude Oil - Sour	T
Diesel Oil	T
Fuel Oil	T
Gasoline, Leaded	T
Hydraulic Oil	T
Kerosene	T
Lube Oil, to 66°C (150°F)	T
Motor Oil	T
Tar and Tar Oil	T

**ΧΡΥΣΑΦΙΔΗΣ Α.Ε.**

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Chemical Composition	Gasket Grade	Chemical Composition	Gasket Grade
Acetic Acid up to 10%	E	Heptane	T
Acetone	E	Hexaldehyde	E
Acetylene	E/T	Hexane	T
Alkalis	E	Hexylene Glycol	T
Aluminium Chloride	E/T	Hydrochloric Acid to 36%, 24°C (75°F) Max	E
Aluminium Fluoride	E/T	Hydrofluosilicic Acid	E
Aluminium Hydroxide	E	Isobutyl Alcohol	E
Aluminium Nitrate	E/T	Isopropyl Alcohol	E
Aluminium Salts	T	Lead Acetate	T
Ammonia Gas, Cold	E	Lithium Bromide	T
Ammonia Liquid	E	Magnesium Chloride	E/T
Ammonium Chloride	E/T	Magnesium Hydroxide	E/T
Amyl Acetate	E	Magnesium Sulphate	E/T
Amyl Alcohol	E	Methyl Alcohol, Methanol	E/T
Aniline	E	Methyl Ethyl Ketone	(E)
Arsenic Acid to 75%	T	Methyl Isobutyl Carbinol	E
Barium Carbonate	E	Mineral Oils	T
Barium Chloride	E/T	Nickel Chloride	E/T
Barium Hydroxide	E/T	Nickel Plating Solution 52°C (125°F) Max	E/T
Benzoic Acid	E	Nitric Acid, to 10%, 24°C (75°F) Max	E
Benzyl Alcohol	E	Nitrous Oxide	E
Borax Solutions	E	Ozone	E
Boric Acid	E/T	Phosphate Ester	E
Butyl Alcohol	E/T	Phosphoric Acid to 75% & 21°C (70°F) Max	E/T
Butylene	T	Potassium Bromide	E/T
Calcium Bisulphate	T	Potassium Carbonate	E/T
Calcium Chloride	E/T	Potassium Chloride	E
Calcium Hydroxide (Lime)	E/T	Potassium Chromate	T
Calcium Sulfate	E/T	Potassium Hydroxide	T
Calcium Sulfide	E	Propylene Glycol	E
Carbitol	E/T	Salicylic Acid	E
Carbon Dioxide, Dry	E/T	Silver Nitrate	E
Carbon Dioxide, Wet	E/T	Soda Ash, Sodium Carbonate	E/T
Carbon Monoxide	E	Sodium Bicarbonate	E/T
Caustic Potash	T	Sodium Bisulphate	E/T
Chrome Alum	T	Sodium Bisulphite (black liquor)	E/T
Citric Acid	E/T	Sodium Bromide	E/T
Copper Chloride	T	Sodium Chlorate	E
Copper Cyanide	E/T	Sodium Chloride	E/T
Copper Sulphate	E/T	Sodium Cyanide	E/T
Cupric Fluoride	E	Sodium Hydroxide, up to 50%	E
Cupric Sulphate	E/T	Sodium Hypochlorite, to 20%	E
Diocetyl Phthalate	E	Sodium Metaphosphate	T
Ethane	E	Sodium Nitrate	E
Ethanolamine	E	Sodium Peroxide	E
Ethyl Alcohol	E	Sodium Phosphate	T
Ethyl Chloride	E	Sodium Silicate	T
Ethylene Chlorohydrin	E	Sodium Sulfide	T
Ethylene Diamine	T	Sodium Sulfite Solution, to 20%	T
Ethylene Glycol	E/T	Sodium Thiosulphate, "Hypo"	T
Ferric Sulphate	T	Stannous Chloride, to 15%	T
Fluoboric Acid	E/T	Stearic Acid	T
Fly Ash	E	Sulphur	E
Fomaldehyde	E/T	Sulphuric Acid, to 25%, 66°C(150°F) Max	E
Formamide	E/T	Toluene 30%	T
Formic Acid	E	Triethanolamine	E/T
Fructose	E/T	Trisdodium Phosphate (5 kg/189 ltr)	E
Furfuryl Alcohol	E	Turpentine 70°C (158°F) Max	(T)
Glycerin	E/T	Urea	T
Glycerol	E/T	Vegetable Oil	T
Glycol	E/T	Vinyl Acetate	E

Note: Contact Tyco BSP for an Engineering evaluation and recommendation where the gasket grade is shown in parenthesis.

For dry pipe systems or freezer systems, use Tri-Seal freezer gasket and petroleum free silicone lubricant.

Check gasket colour code to be certain it is recommended for the service intended.

Unless otherwise noted, all gasket listings are based upon a temperature of 70° F (21° C).

For services not listed contact Tyco BSP for recommendation.

Where more than one gasket is shown, the preferred gasket grade is listed first.

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30/11/2004

Grinnell Coupling Working Pressure Ratings (Bar) on Roll Grooved ISO Size Steel Pipe. Maximum Working Pressure Bar**								
Nom. Pipe Size Inches DN/mm	Pipe Outside Diameter mm	Nominal Wall Thickness mm	Fig. 705 Flexible Max. Work Pressure Bar	Fig. 577 Rigid Max. Work Pressure Bar	Fig. 707 Flexible Max. Work Pressure Bar	Fig. 772 Rigid Max. Work Pressure Bar	Fig. 716 Reducing Max. Work Pressure Bar	Fig. 71 Flange Max. Work Pressure Bar
1	33.7	1.8	-	20.7	-	-	-	-
25		2.9	-	20.7	-	-	-	-
		3.2	-	20.7	-	-	-	-
1 1/4	42.4	1.8	20.7	20.7	-	51.7	-	-
32		2.9	34.5	20.7	-	51.7	-	-
		3.6	34.5	20.7	-	51.7	-	-
1 1/2	48.3	1.8	34.5	20.7	34.5	34.5	24.1	-
40		2.9	34.5	20.7	51.7	51.7	24.1	-
		3.6	34.5	20.7	69.0	51.7	24.1	-
2	60.3	1.8	34.5	20.7	34.5	34.5	24.1	13.8
50		2.9	34.5	20.7	51.7	51.7	24.1	17.2
		3.6	34.5	20.7	69.0	51.7	24.1	20.7
2 1/2	73.0	2.0	34.5	20.7	34.5	34.5	24.1	13.8
65		3.2	34.5	20.7	41.3	41.3	24.1	17.2
		5.0	34.5	20.7	69.0	51.7	24.1	20.7
2 1/2	76.1	2.0	34.5	20.7	34.5	34.5	24.1	13.8
65		3.2	34.5	20.7	41.3	41.3	24.1	17.2
		5.0	34.5	20.7	69.0	51.7	24.1	20.7
3	88.9	2.0	34.5	20.7	34.5	34.5	24.1	13.8
80		3.2	34.5	20.7	41.3	41.3	24.1	17.2
		5.6	34.5	20.7	69.0	51.7	24.1	20.7
4	114.3	2.0	27.6	20.7	27.6	27.6	24.1	13.8
100		3.2	34.5	20.7	41.3	41.3	24.1	17.2
		5.6	34.5	20.7	69.0	51.7	24.1	20.7
4	108.0	2.0	27.6	-	-	-	-	-
100		3.2	34.5	-	-	-	-	-
		5.6	34.5	-	-	-	-	-
5	141.3	2.9	24.1	20.7	24.1	24.1	24.1	13.8
125		3.6	31.0	20.7	34.5	31.0	24.1	17.2
		6.3	31.0	20.7	69.0	51.7	24.1	20.7
5	133.0	2.9	24.1	-	-	-	-	-
125		3.6	31.0	-	-	-	-	-
		6.3	31.0	-	-	-	-	-
5	139.7	2.9	24.1	20.7	-	24.1	-	13.8
125		3.6	31.0	20.7	-	31.0	-	17.2
		6.3	31.0	20.7	-	51.7	-	20.7
6	168.3	2.9	24.1	20.7	24.1	24.1	17.2	13.8
150		3.6	31.0	20.7	31.0	34.5	24.1	17.2
		7.1	31.0	20.7	69.0	48.2	24.1	20.7
6	159.0	2.9	24.1	-	-	-	-	-
150		3.6	31.0	-	-	-	-	-
		7.1	31.0	-	-	-	-	-
6	165.1	2.9	24.1	20.7	24.1	24.1	17.2	13.8
150		3.6	31.0	20.7	31.0	34.5	24.1	17.2
		7.1	31.0	20.7	69.0	48.2	24.1	20.7
8	219.1	2.9	17.2	17.2	17.2	17.2	-	13.8
200		5.0	20.7	20.7	20.7	20.7	-	13.8
		8.0	31.0	20.7	55.1	41.3	-	20.7
10	273.0	3.6	20.7	-	17.2	17.2	-	13.8
250		5.0	24.1	-	20.7	20.7	-	13.8
		8.0	24.1	-	34.5	27.6	-	17.2
12	323.9	4.0	20.7	-	13.8	13.8	-	13.8
300		5.0	24.1	-	20.7	13.8	-	13.8
		8.0	24.1	-	34.5	27.6	-	17.2
14	355.6	4.0	-	-	8.6	-	-	-
350		6.3	-	-	17.2	-	-	-
		8.8	-	-	20.7	-	-	-
16	406.4	4.0	-	-	6.9	-	-	-
400		6.3	-	-	12.1	-	-	-
		8.8	-	-	20.7	-	-	-
18	457.2	5.0	-	-	5.2	-	-	-
450		6.3	-	-	6.9	-	-	-
		8.8	-	-	20.7	-	-	-
20	508.0	5.0	-	-	3.4	-	-	-
500		6.3	-	-	6.9	-	-	-
		8.8	-	-	20.7	-	-	-
24	609.6	5.0	-	-	1.7	-	-	-
600		6.3	-	-	5.2	-	-	-
		8.8	-	-	17.2	-	-	-

**Maximum line pressure, including surge, to which a joint should be subjected on pipe roll grooved to standard roll grooving specification with coupling properly assembled

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TYCENNECH-7/04

Grinnell Coupling Working Pressure Ratings (Bar) on Roll Grooved ISO Size 304/316 Stainless Steel Pipe. Maximum Working Pressure Bar**								
Nom. Pipe Size Inches DN/mm	Pipe Outside Diameter mm	Nominal Wall Thickness mm	Fig. 705 Flexible Max. Work Pressure Bar	Fig. 577 Rigid Max. Work Pressure Bar	Fig. 707 Flexible Max. Work Pressure Bar	Fig. 772 Rigid Max. Work Pressure Bar	Fig. 405 Flexible Max. Work Pressure Bar	Fig. 472 Rigid Max. Work Pressure Bar
1 25	33.7	1.7	-	21	-	-	-	16
		2.0	-	21	-	-	-	16
		2.8	-	21	-	-	-	21
		3.4	-	21	-	-	-	16
1 1/4 32	42.4	1.7	-	21	-	28	21	16
		2.0	-	21	-	28	21	16
		2.8	-	21	-	34	21	21
		3.6	-	21	-	52	21	21
1 1/2 40	48.3	1.7	28	21	28	28	21	16
		2.0	28	21	28	28	21	16
		2.8	34	21	34	34	21	21
		3.7	34	21	52	52	21	21
2 50	60.3	1.7	17	21	22	22	21	16
		2.0	17	21	22	22	21	16
		2.8	28	21	34	34	21	21
		3.9	34	21	52	52	21	21
2 1/2 65	73.0	2.1	17	21	22	22	21	16
		2.0	17	21	22	22	21	16
		3.0	28	21	34	34	21	21
		5.2	34	21	52	52	21	21
3 65.0	76.1	2.8	17	21	22	22	21	16
		3.8	17	21	22	22	21	21
		5.1	28	21	34	34	21	21
		6.4	34	21	52	52	21	21
3 80	88.9	2.1	17	21	22	22	21	16
		2.0	17	21	22	22	21	16
		3.0	28	21	34	34	21	21
		5.5	34	21	52	52	21	21
4 100	114.3	2.1	16	21	17	17	21	16
		3.0	21	21	28	28	21	21
		6.0	34	21	52	52	21	21
		2.8	9	21	16	16	17	16
5 125	139.7	3.0	9	21	16	16	17	16
		5.1	16	21	21	21	21	21
		6.4	21	21	34	34	21	21
		2.8	9	21	16	16	17	16
5 125	141.3	3.0	9	21	16	16	17	16
		3.4	16	21	21	21	21	21
		6.6	21	21	34	34	21	21
		2.8	6	21	9	9	17	16
6 150	165.1	3.0	6	21	9	9	17	16
		5.1	9	21	16	16	21	21
		6.4	21	21	34	31	21	21
		2.8	6	21	9	9	17	16
6 150	168.3	3.0	6	21	9	9	17	16
		3.4	9	21	16	16	21	21
		7.1	21	21	34	31	21	21
		2.8	-	17	6	6	7	16
8 200	219.1	3.0	-	17	6	6	7	16
		3.8	6	21	9	9	14	21
		8.2	21	21	28	28	21	21
		3.4	-	-	-	-	-	-
10 250	273.1	4.0	-	-	6	6	-	16
		4.2	-	-	6	6	-	21
		9.3	-	-	28	22	-	21
		4.0	-	-	6	6	-	16
12 300	323.9	4.6	-	-	9	9	-	21
		9.5	-	-	28	17	-	21

**Maximum line pressure, including surge, to which a joint should be subjected on 304/316 stainless steel pipe roll grooved to standard roll grooving specification with coupling properly assembled. For sizes above 12" consult Tyco BSP.

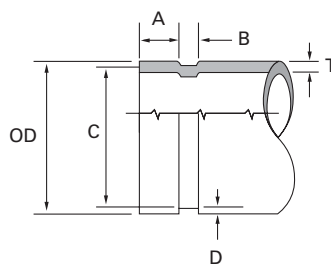


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Nominal Pipe Size	Pipe Outside diameter mm	Gasket Seat	Groove Width	Groove Diameter C mm	Groove Depth D (Ref. only)	Min. Allow. Wall Thick T mm	Max. Flare Dia.
mm Inches	Nom:	Tolerance + -	A ±0.76 mm	B ±0.76 mm	Actual Tolerance +0.00	mm	mm
25 1	33.7	0.33 0.33	15.88	7.14	30.23 -0.38	1.60	36.32
32 1 1/4	42.4	0.41 0.41	15.88	7.14	38.99 -0.38	1.60	44.96
40 1 1/2	48.3	0.48 0.48	15.88	7.14	45.09 -0.38	1.60	51.05
50 2	60.3	0.61 0.61	15.88	8.74	57.15 -0.38	1.60	62.99
65 2 1/2	73.0	0.74 0.74	15.88	8.74	69.09 -0.46	1.98	75.69
65 2 1/2	76.1	0.76 0.76	15.88	8.74	72.26 -0.46	1.93	78.74
80 3	88.9	0.89 0.79	15.88	8.74	84.94 -0.46	1.98	91.44
100 4	108.0	1.09 0.79	15.88	8.74	103.73 -0.51	2.11	110.50
100 4	114.3	1.14 0.79	15.88	8.74	110.08 -0.51	2.11	116.84
125 5	133.0	1.35 0.79	15.88	8.74	129.13 -0.56	2.11	135.90
125 5	139.7	1.42 0.79	15.88	8.74	135.48 -0.56	2.11	142.24
125 5	141.3	1.42 0.79	15.88	8.74	137.03 -0.56	2.13	143.76
150 6	159.0	1.60 0.79	15.88	8.74	154.54 -0.76	2.16	161.30
150 6	165.1	1.60 0.79	15.88	8.74	160.78 -0.56	2.16	167.64
150 6	168.3	1.60 0.79	15.88	8.74	163.96 -0.56	2.16	170.94
200 8	219.1	1.60 0.79	19.05	11.91	214.40 -0.64	2.39	223.52
250 10	273.0	1.60 0.79	19.05	11.91	268.27 -0.69	2.39	277.37
300 12	323.9	1.60 0.79	19.05	11.91	318.29 -0.76	2.77	328.17
350 14	355.6	1.60 0.79	23.83	11.91	350.04 -0.76	2.77	358.14
400 16	406.4	1.60 0.79	23.83	11.91	400.84 -0.76	2.77	408.94
450 18	457.2	1.60 0.79	25.40	11.91	451.64 -0.76	2.77	461.26
500 20	508.0	1.60 0.79	25.40	11.91	502.44 -0.76	2.77	512.06
600 24	609.6	1.60 0.79	25.40	12.70	600.86 -0.76	4.37	614.68

- The maximum allowable tolerances for IPS pipe from square cut ends is 0.76 mm (0.030") for sizes 1"-3"; 1.14 mm (0.045") for sizes 4"-6"; and above 1.52 mm (0.060") for sizes 8" and above.
- Gasket Seating Surface 'A' must be free from score marks, ridges, indentations, projections, loose paint, scale, dirt, chips, grease, rust, etc. that would prevent a positive seal.
- Groove diameter 'C' must be of uniform depth around the circumference of the pipe.

- Groove depth 'D' is a reference dimension only. The Groove Diameter 'C' must be maintained.
- Minimum Wall Thickness 'T' is the minimum pipe wall thickness that should be roll grooved.
- Maximum allowable pipe end flare diameter is measured at the pipe end diameter.

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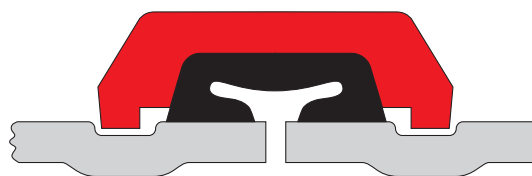
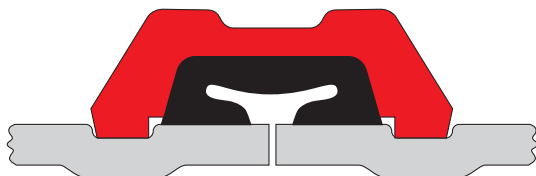
Rigid Joints

Από το 1882



ΧΡΥΣΑΦΙΔΗΣ Α.Ε.

Flexible Joints

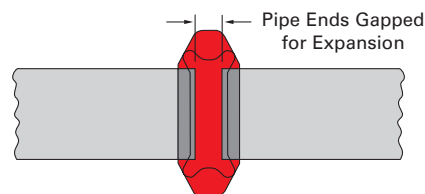


Grinnell Rigid Couplings provide rigid gripping of the pipe. They are designed to bring the pipe ends closely together and the coupling clamps firmly onto the pipe OD and also onto the bottom of the grooves. Because Rigid Couplings clamp around the entire pipe surface, they provide resistance to flexural and torsional loads and therefore permit longer spacing to ASME/ANSI B31.1 (Power Piping) and ASME/ANSI B39.1 (Building Services) requirements as well as NFPA 13 (Sprinkler Systems).

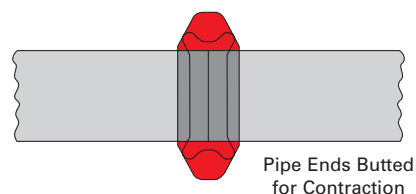
Grinnell Flexible Couplings act as an "expansion joint", allowing linear and angular movement of the pipe. They are designed with the coupling keys engaging the pipe without gripping on the bottom of the grooves, while still providing for a restrained mechanical joint. This is particularly useful to allow for pipe expansion / contraction and piping misalignment.

Linear Movement (Flexible Joints)

For thermal expansion the pipe ends at each joint should be fully gapped to the maximum end gap. This can be accomplished by pressurizing the system and then anchoring the system.



For thermal contraction with flexible couplings, the pipe ends at each joint should be fully butted. The system can then be anchored in place to prevent the pipe ends from opening up to the maximum end gap when pressurized.



For design purposes, the maximum pipe end gap should be reduced to account for field practices as follows:

Pipe Size Inches mm	End Cap Reduction Maximum Pipe End Cap Reduction
1 1/4 - 3 42.4 - 88.9	50%
4 - 24 114.3 - 609.6	25%

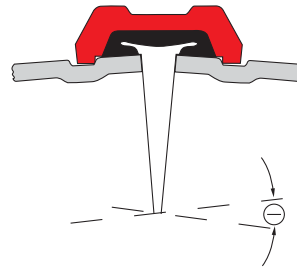
Therefore the following values should be used as available pipe end movements for Grinnell Figure 705, 705R, 707, 716 and 405 Flexible Couplings:

Pipe Size Inches mm	Pipe End Movements Cut Grooved Inches mm	Roll Grooved* Inches mm
1 1/4 - 3 42.4 - 88.9	0 - 0.063 0 - 1.6	0 - 0.031 0 - 0.8
4 - 24 114.3 - 609.6	0 - 0.188 0 - 4.8	0 - 0.094 0 - 2.4

* Roll grooved joints provide 1/2 the available movement of cut grooved joints.

Angular Deflection

Grinnell Flexible Couplings are capable of accommodating angular deflection.

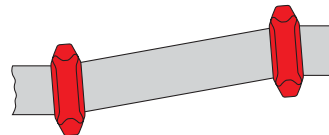


The deflection published in our literature is a maximum value. For design purposes the maximum deflection should be reduced to account for field practices as shown:

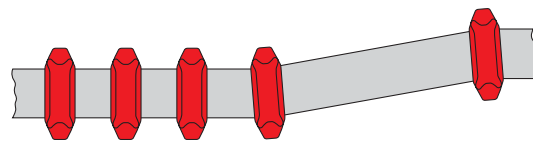
Pipe Size Inches mm	Deflection Maximum Pipe Deflection Reduction
1 1/4 - 3 42.4 - 88.9	50%
4 - 24 114.3 - 609.6	25%

Expansion / Contraction

Grinnell Flexible Couplings are capable of accommodating pipe thermal movements provided they are properly gapped and a sufficient quantity of flexible couplings are used. Note that flexible couplings will not accommodate both full maximum linear movement and the maximum available angular deflection concurrently at the same joint.



If it is desired to have both deflection and linear movement available, then the system should have sufficient flexible joints to accommodate the requirement.



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Thermal Movement

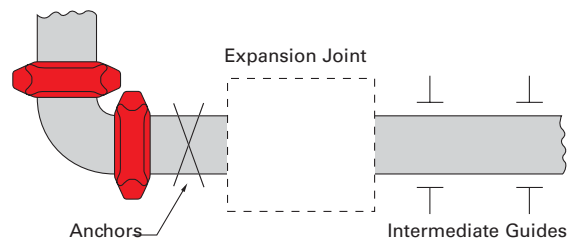
The following guidelines are similar to any expansion joint: Its is recommended that anchors be installed at changes of direction on the pipe lines to control the pipe movement. The thermal expansion/contraction in the piping system can be accommodated utilizing Grinnell Flexible Couplings. In designing anchoring systems. It is suggested that the following be taken into consideration as a minimum:

- Pressure thrusts
- Frictional resistance of any guides or supports
- Centrifugal thrust due to velocity at changes of direction
- Activation force required to compress or expand a flexible coupling

Pipe Size Inches mm	Activation Force	
		Activation Force Lbs. N
1 1/4		35
42.4		156
1 1/2		45
48.3		200
2		70
60.3		311
2 1/2		100
73.0		645
76.1		110
		489
3		145
88.9		645
4		240
114.3		1068
5		375
139.7/141.3		1668
165.1		500
		2224
6		520
168.3		2313
8		880
219.1		3914
10		1365
273.0		6072
12		1915
323.9		8518

Three methods are available as examples to accommodate thermal expansion/contraction:

- 1) Design the system with rigid couplings and place expansion joints at the relevant locations. Expansion joints may be a series of flexible grooved couplings of a sufficient quantity to accommodate the movement.



- 2) Design the system with flexible and/or rigid couplings and allow the pipe to move in directions desired, with the use of anchors and guides if so required. With this method, it is important to ensure that movement at branch connections, changes of direction, equipment hookup, etc., will not cause damage or excessive stresses.



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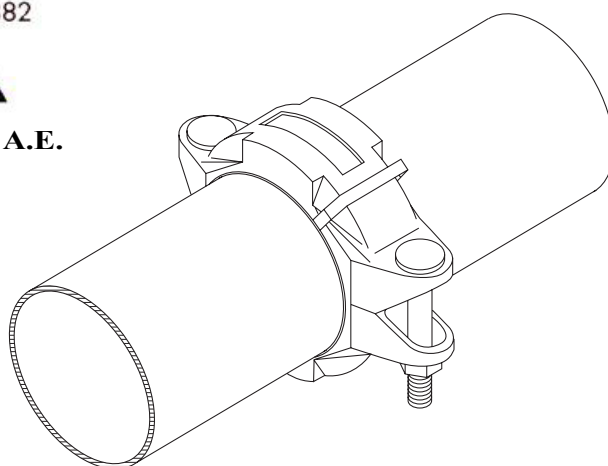
When a continuity clip is used electrical continuity across a Grinnell flexible coupling (Fig. 705 or 707) is maintained in a variety of situations including high current loads and extremely corrosive environments. In other words, the use of one clip per coupling offers the contractor a fast and simple means of providing earth continuity of steel pipework. Rigid type couplings have a build in feature which insure electrical continuity. Therefore when using rigid couplings, there is no need for continuity clips.

The Grinnell continuity clip is a light weight, stainless steel 301 clip, whereby tiny burrs provide proper grounding. It is designed for earthing requirements according British Standard (BS) 6087. The Grinnell continuity clip complies to the I.E.E regulations, 15th edition, which requires "equipotential bonding of conductive parts".

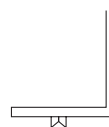
Three clips cover the coupling range from 1" up to 12" and fit both the Fig. 705 and Fig. 707 coupling.



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DETAIL A



DETAIL A

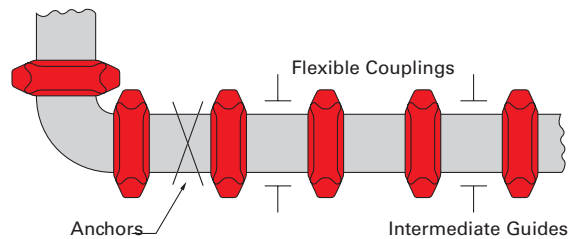
Tyco BSP Article Number	Suitable for Size Coupling	Approx Weight
	Inches	Kg
CLIP0103	1 - 3	0.005
CLIP0406	4 - 6	0.005
CLIP0812	8 - 12	0.005

General notes: Additional information is included in our data sheets and is available upon request. It is the Designer's responsibility to select products suitable for the intended service and to ensure that pressure ratings and performance data is not exceeded. Always read and understand the installation constructions. Never remove any piping components nor correct or modify any piping deficiencies without first depressurizing and draining the system. Material and gasket selection should be verified with the gasket recommendation listing for the specific application.

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3) Design the system with flexible couplings utilizing the expansion/contraction capabilities of these products. The following example illustrates this method:

- 150mm Schedule 40 Steel Pipe, Roll Grooved, 45.7m long, anchored at each end.
- Maximum Temperature = 93°C
- Minimum Temperature = 4°C
- Install Temperature = 27°C



3a) Thermal Expansion

Utilizing the Thermal Expansion Table, the following calculations are performed:

3b) Allowance for installation temperature to the minimum temperature, in this case 26.7°C to 4.4°C is calculated as:

Expansion/contraction factor steel = 1.2 mm per mtr/100° C

$$26.7-4.4 (\Delta T) \times 1.2/100 = 0.264 \text{ mm/mtr}$$

3c) Allowance for installation temperature to the maximum temperature, in this case 26.7°C to 93.3°C is calculated as:

$$93.3-26.7 (\Delta T) \times 1.2/100 = 0.8$$

Total expansion = 0.8 x 45.7 = 36.56 mm per 45.73 mtr

Δ Temperature °C	mm/mtr	Δ Temperature °C	mm/mtr
-40	-0.48	50	0.60
-30	-0.36	60	0.72
-20	-0.24	70	0.84
-10	-0.12	80	0.96
0	0	90	1.08
10	0.12	100	1.20
20	0.24	110	1.32
30	0.36	120	1.44
40	0.48	130	1.56

3d) Couplings Required

Available linear movement for a 150 mm Figure 707 on roll grooved pipe = 2.4 mm per coupling, therefore the number of flexible Figure 707 Couplings required is:

Fully Butted Together for Contraction Only
Installation temperature to minimum temperature:

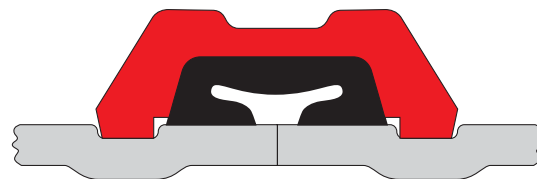
$$\frac{12.1 \text{ mm}}{2.4 \text{ mm per coupling}} = 5.1$$

Use 6 Figure 707 Couplings for pipe contraction with pipe ends fully butted together.

Fully Gapped Apart for Expansion Only
Installation temperature to minimum temperature:

$$\frac{36.6 \text{ mm}}{2.4 \text{ mm per coupling}} = 15.3$$

Use 16 Figure 707 Couplings for pipe expansion with pipe ends fully gapped apart.



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Misalignment and Deflection

Grinnell flexible couplings provide for restrained joints and allow for deflection to aid where the pipe or equipments is misaligned.

Note that flexible couplings will not accommodate both full maximum linear movement and the maximum available angular deflection concurrently at the same joint.

If it is desired to have both deflection and linear movement available, then the system should have sufficient flexible joints to accommodate the requirement.

Flexible couplings are also useful in designing curved piping systems.

$$R = L/(2)(\sin \varnothing/2)$$

$$L = 2R(\sin \varnothing/2)$$

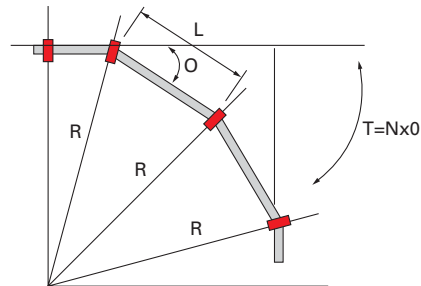
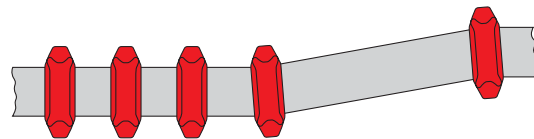
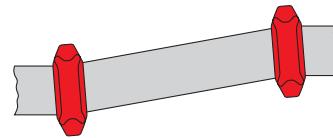
$$N = T/\varnothing$$

N = Number of flexible couplings needed
 R = Radius of curve
 L = Pipe length
 $\varnothing$ = Deflection from centerline, in degrees, for each coupling (see table)
 T = Total deflection in degrees required

This table represents the design deflection for roll grooved pipe and incorporates the recommended safety factor reduction for field practices (50% for sizes 25mm - 80mm and 25% for sizes 100mm - 600mm).



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Deflection $\varnothing$ (Roll Grooved Pipe)	
Pipe Size Inches mm	Figures 705 and 707 Degrees
1 1/4 42.4	1.08
1 1/2 48.3	0.94
2 60.3	0.75
2 1/2 73.0	0.62
76.1	0.60
3 88.9	0.51
4 114.3	1.19
5 139.7/141.3	0.97
165.1	0.83
6 168.3	0.81
8 219.1	0.63
10 273.0	0.50
12 323.9	0.42

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Pipe Support

All piping systems require that the support system accommodate the weight of the pipe, joint connections, fluid and other system components. In addition, consideration may be necessary in reducing stresses, accommodation thermal expansion or contraction, building settlement, seismic movement, etc. The following table provides guidelines for grooved steel piping products without concentrated loads between supports.

Note: The requirements of NFPA, ANSI, ASME or other code groups may require additional supports.

Flexible Joints

For pipe runs when linear movement is accommodated by the flexible coupling:

Number of hangers per pipe length								
Pipe Size	Pipe length in meters							
Inches mm	3.3	3.7	4.6	6.7	7.6	9.1	10.7	12.2
2								
50	2	2	2	3	4	4	5	6
2 1/2 - 4								
65 - 100	1	2	2	2	2	3	4	4
5 - 24								
125 - 600	1	1	2	2	2	3	3	3

For pipe runs when linear movement is not required:

Pipe Size	Distance between Supports	
	Inches mm	Maximum Distance between supports mtr
1 1/4		
42.4		3.7
2 - 8		
60.3 - 219.1		4.6
10 - 12		
273.0 - 323.9		4.9
14 - 16		
355.6 - 406.4		5.5
18 - 24		
457.2 - 609.6		6.1



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Rigid Joints

For pipe runs with rigid couplings:

Suggested Maximum Span Between Supports Meters						
Pipe Size	Water Service			Air Service		
Inches mm	I	II	III	I	II	III
1	7	9	12	9	9	
25	2.1	2.7	3.7	2.7	2.7	12
1 1/4	7	11	12	9	11	3.7
32	2.1	3.4	3.7	2.7	3.4	12
1 1/2	7	12	15	9	13	3.7
40	2.1	3.7	4.6	2.7	4.0	15
2	10	13	15	13	15	4.6
50	3.0	4.0	4.6	4.0	4.6	15
2 1/2	11	14	15	14	16	4.6
65	3.4	4.3	4.6	4.3	4.9	15
3	11	14	15	14	16	4.6
65	3.4	4.3	4.6	4.3	4.9	15
3	12	15	15	15	17	4.6
80	3.7	4.6	4.6	4.6	5.2	15
4	14	17	15	17	21	4.6
100	4.3	5.2	4.6	5.2	6.4	15
5	16	19	15	20	24	4.6
125	4.9	5.8	4.6	6.1	7.3	15
5 1/4	15	18	15	19	23	4.6
125	4.6	5.5	4.6	5.2	7	15
5 1/2	16	19	15	20	24	4.6
125	4.9	5.8	4.6	6.1	7.3	15
6	17	20	15	21	25	4.6
150	5.2	6.1	4.6	6.4	7.6	15
6 1/2	17	20	15	21	25	4.6
150	5.2	6.1	4.6	6.4	7.6	15
8	19	21	15	24	28	4.6
200	5.8	6.4	4.6	7.3	8.5	15
10	19	21	15	24	31	4.6
250	5.8	6.4	4.6	7.3	9.4	15
12	23	21	15	30	33	4.6
300	7	6.4	4.6	9.1	10.1	15
14	23	21	15	30	33	4.6
350	7	6.4	4.6	9.1	10.1	15
16	27	21	15	35	33	4.6
400	8.2	6.4	4.6	10.7	10.1	15
18	27	21	15	35	33	4.6
450	8.2	6.4	4.6	10.7	10.1	15
20	30	21	15	39	33	4.6
500	9.1	6.4	4.6	11.9	10.1	15
24	32	21	15	42	33	4.6
600	9.8	6.4	4.6	12.8	10.1	15
						4.6

- I - Spacing by ANSI B31.1 Power Piping Code
 II - Spacing by ANSI B39.1 Building Piping Code
 III - Spacing by NFPA 13 Sprinkler Systems
 (Steel Pipe except Threaded Lightwall)

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