



Procedure for cutting pipes on site

Chamfer dimensions		
Dia pipe mm	A	
	min	max
80	10	14
100	10	14
150	10	14
200	10	14
250	10	14
300	10	14
350	10	14
400	12	16
450	12	16
500	14	18
600	14	18
700	16	20
800	16	20
900	18	22
1000	20	24

Pipes cut on site must be chamfered/bevelled and rounded after cutting. See table.

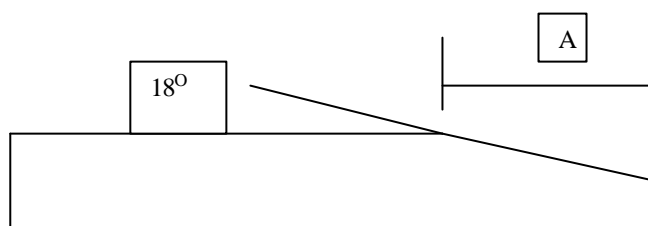
Re-coat the spigot end after cutting.

All pipes up to 300mm dia are suitable for cutting along the length of the pipe barrel to within 1metre of the socket joint.

Pipes over 300mm need to be checked prior to cutting to ensure they are within the tolerances specified and therefore suitable for cutting. Pipes can be supplied suitable for cutting; they need to be ordered separately.

Pipes ordered suitable for cutting will be marked, usually with a longitudinal line plus a marking on the socket. (Please ensure suitable safety wear is used when cutting pipes on site).

Where pipes of a nominal size DN350 to 1000mm are to be cut on site and subsequently jointed into a push fit joint, the following procedures should be carried out (see over).



Check the average external diameter of the pipe at the proposed point of the cut. This dimension must comply with the limits specified in **table 1** below.

After cutting the pipe, check the cut end, if this is found to be oval, locate and mark the major axis. Only where this exceeds the dimension specified in **table 2**, will ovality correction be required prior to jointing. (Details on ovality correction are available upon request).

Please note that cut spigots jointed into a push fit joint need to be chamfered.

Table 1

Average external diameter of Ductile iron pipe					
Dia	Measured circumferentially with a standard tape		Measured circumferentially with a diameter tape		
	min		max	min	max
mm	mm		mm	mm	mm
350	1177		1191	374.5	379
400	1337		1351	425.5	430
450	1497		1511	476.5	481
500	1660		1674	528.5	533
600	1983		1998	631	636
700	2306		2321	734	739
800	2632		2648	837.5	843
900	2955		2971	940.5	946
1000	3277		3295	1043	1049

Table 2

Maximum major axis of spigot end for jointing into a push fit joint			
Dia			
mm		mm	
350		379	
400		430	
450		481	
500		533	
600		636	
700		748	
800		850	
900		960	
1000		1064	

Pipes marked suitable for cutting can be supplied by arrangement.