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Grooved Joint & Pipe Fittings

Technical information



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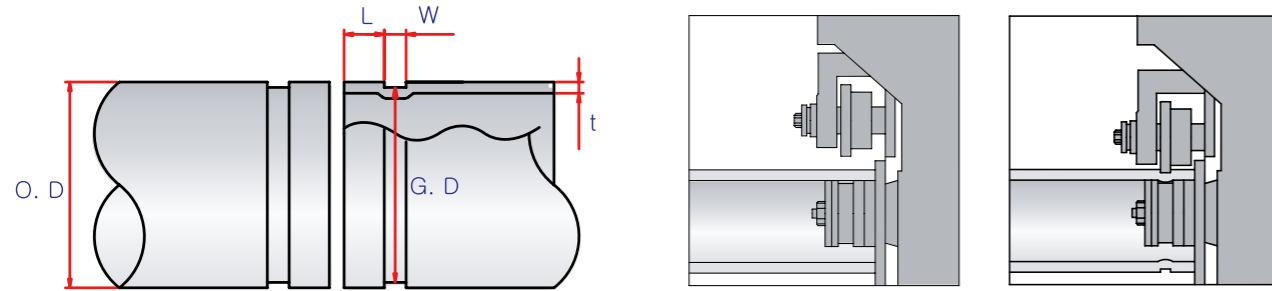
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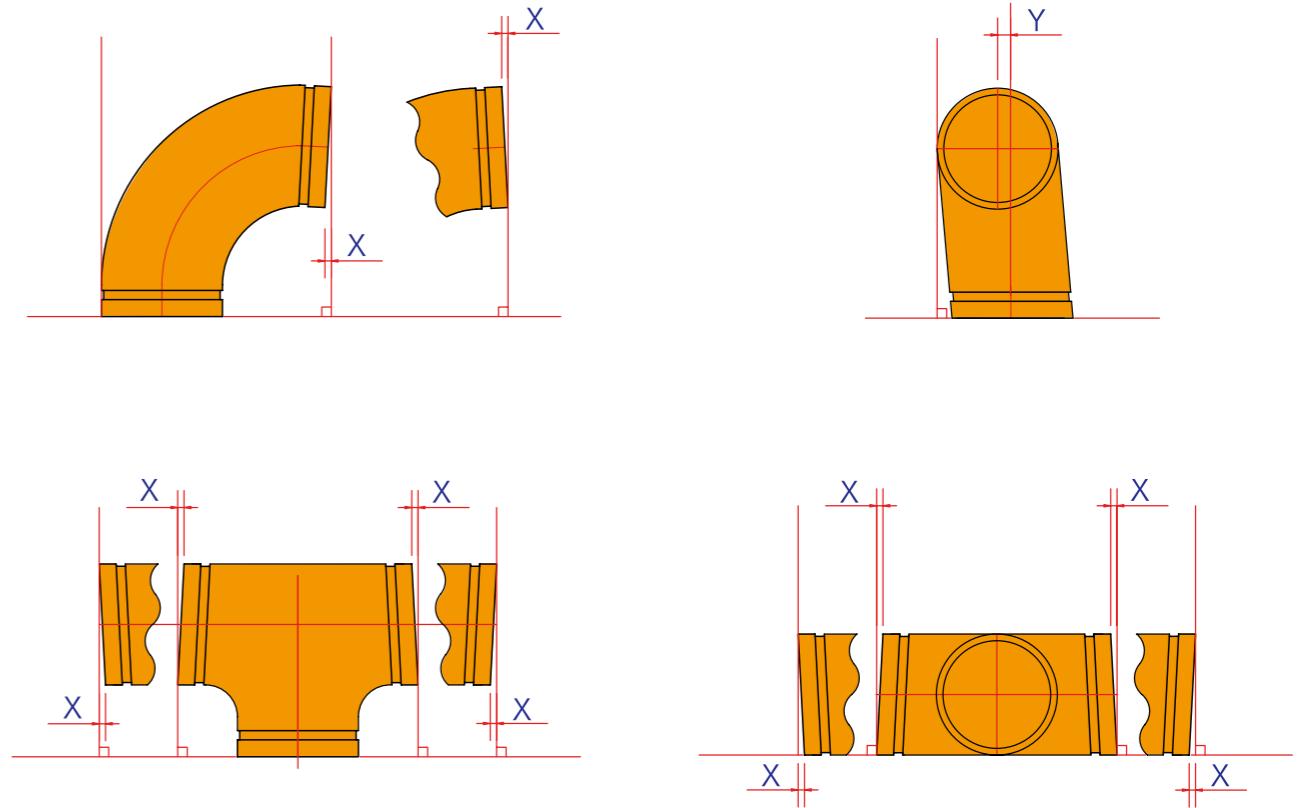
Grooved Specifications

Roll Grooved



Nominal Size (A, inch)	Pipe O.D (mm)		Gasket Seating Surface L±0.79 (mm)			Groove Width W±0.79 (mm)			Groove Diameter G.D(mm)		Groove Depth (mm)	Flare Diameter (mm)
	Basic	Tolerance	Basic	MAX	MIN	Basic	MAX	MIN	MAX	MIN		
25	34,0	+0,40 -0,40	15,88	16,67	15,09	7,14	7,93	6,35	30,23	29,80	1,65	36,0
32	42,7	+0,40 -0,40	15,88	16,67	15,09	7,14	7,93	6,35	38,99	38,61	1,65	45,0
40	48,6	+0,40 -0,40	15,88	16,67	15,09	7,14	7,93	6,35	45,09	44,70	1,65	51,1
50	60,5	+0,60 -0,40	15,88	16,67	15,09	8,74	9,53	7,95	57,15	56,77	1,65	63,0
65	76,3	+0,44 -0,40	15,88	16,67	15,09	8,74	9,53	7,95	72,26	71,80	2,11	78,7
* 2-1/2"	73,0	+0,74 -0,74	15,88	16,67	15,09	8,74	9,53	7,95	69,09	68,63	2,11	75,7
80	89,1	+0,80 -0,50	15,88	16,67	15,09	8,74	9,53	7,95	84,94	84,48	2,11	91,4
100	114,3	+0,90 -0,50	15,88	16,67	15,09	8,74	9,53	7,95	110,08	109,57	2,11	116,8
125	139,8	+1,30 -0,60	15,88	16,67	15,09	8,74	9,53	7,95	135,48	134,97	2,77	142,2
* 5"	141,3	+1,42 -0,79	15,88	16,67	15,09	8,74	9,53	7,95	137,03	136,47	2,77	143,8
150	165,2	+1,30 -0,60	15,88	16,67	15,09	8,74	9,53	7,95	160,78	160,22	2,77	167,6
* 6"	168,3	+1,57 -0,79	15,88	16,67	15,09	8,74	9,53	7,95	163,96	163,40	2,77	170,9
200	216,3	+1,50 -0,60	19,05	19,84	18,26	11,91	12,70	11,12	211,61	210,96	2,77	220,7
* 8"	219,1	+1,57 -0,79	19,05	19,84	18,26	11,91	12,70	11,12	214,40	213,76	2,77	223,5
250	267,4	+1,50 -0,80	19,05	19,84	18,26	11,91	12,70	11,12	262,60	261,61	3,40	271,8
* 10"	273,1	+1,57 -0,79	19,05	19,84	18,26	11,91	12,70	11,12	268,28	267,59	3,40	277,4
300	318,5	+1,50 -0,80	19,05	19,84	18,26	11,91	12,70	11,12	312,90	312,14	3,96	322,8
* 12"	323,9	+1,57 -0,79	19,05	19,84	18,26	11,91	12,70	11,12	318,29	317,53	3,96	328,2
350	355,6	+1,50 -0,80	23,83	24,62	23,04	11,91	12,70	11,12	350,04	349,28	3,96	359,0
400	406,4	+1,50 -0,80	23,83	24,62	23,04	11,91	12,70	11,12	400,84	400,08	4,19	410,0
450	457,2	+1,50 -1,00	25,40	26,19	24,61	11,91	12,70	11,12	451,64	450,88	4,19	461,0
500	508,0	+1,50 -1,00	25,40	26,19	24,61	11,91	12,70	11,12	502,44	501,68	4,78	512,0
550	558,8	+1,50 -1,00	25,40	26,19	24,61	12,70	13,49	11,91	550,06	549,30	4,78	563,9
600	609,6	+1,50 -1,00	25,40	26,19	24,61	12,70	13,49	11,91	600,86	600,10	5,54	614,0

Dimensional Tolerances

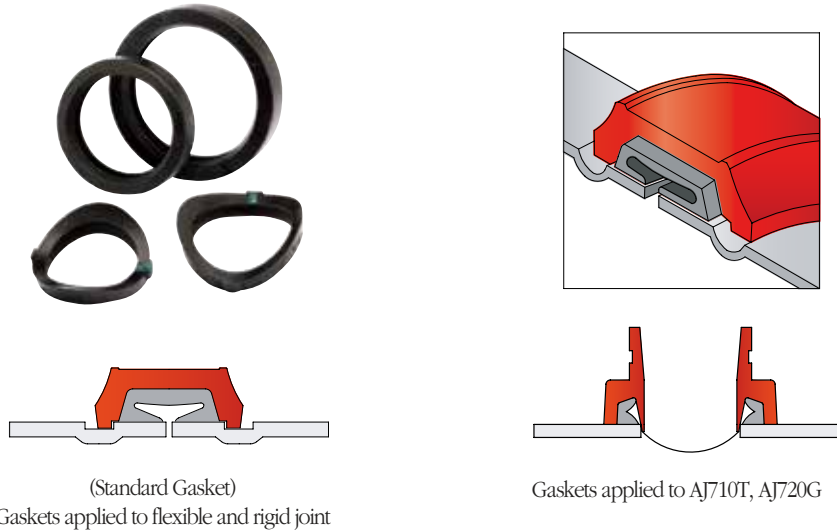


Item	Type of Pipe Fittings	Nominal Diameter							
		15-100	125-200	250-300	350-400	450-600	650-750	800-1050	1100-1200
Off Angle (X)	All pipe Fittings	0,8	1,6	2,4	3,2	4,8			
Off Angle (Y)		1,6	3,2	4,8	6,4	9,5	12,7	19,1	

Type of Pipe Fitting	All pipe Fittings	Nominal Diameter															
		25	32	40	50	65	80	100	125	150	200	250	300	350	400	450	500
Pip Fittings	Thickness	+Not Specified -15%															
Elbow (90°, 45°, 22,5°, 11,25°)	A	±1,6								±2,4							
Tee	C/M	±1,6								±2,4							
Reducer	H	±1,6								±2,4							
Cap	E	±3,2				±6,4											
Flange Adapter	L	±1,6								±2,4							

◉ Gasket Styles

The specially designed C-shaped rubber ring maintains excellent airtightness as the pressure in the pipe increases, making it more tightly attached to the rubber ring seating area.



(Standard Gasket)
Gaskets applied to flexible and rigid joint

Gaskets applied to AJ710T, AJ720G

◉ Gasket Guide

The gasket material shall be selected according to the fluid in the pipe.

Grade	Compound	Temp. Range	Color Code	General Service Recommendations
E	EPDM	-34℃~+110℃	Green	cold water, air, weak acid and alkali * Do not use in hydrocarbon and petroleum fluids
T	NBR	-29℃~+82℃	Orange	Oil-based fluids, oils, wastewater Do not use in hot water above 65℃
L	Silicone	-34℃~+177℃	Red	Dry heat, dry gas, Hot air not including hydrocarbon
O	Fluoro-elastomer	-29℃~+149℃	Blue	Acid, petroleum oil, halogenated hydrocarbon, lubricating oil, hydraulic oil, organic liquid, hydrocarbon gas

* Contact NEWASIA for special gaskets

◉ Bolt Torque

The bolt torque values for the groove joints are as below table.

In particular, if the torque value on one side is excessive when fastening a rigid joint, the risk of leakage is high.

Torque values must be checked before tightening to prevent leakage



Bolt Size (mm)	Bolt Torque			Remark
	Kgf-cm	N-m	ft/lb	
M10	350~400	34~40	25~30	
M12	550~600	54~59	38,9~43,5	
M16	750~800	74~79	54,5~58,3	
M20	1630~1840	160~180	118,0~132,8	
M22	1940~2140	190~210	140,1~154,9	
M24	2550~2750	250~270	184,4~199,2	