



## ASSEMBLY OF FIELD CUT PIPE

When pipe is cut in the field, the cut end may be readily conditioned so that it can be used to make up the next joint. The outside of the cut end should be bevelled about 1/4 inch at an angle of about 30 degrees (Figure 1). This can be quite easily done with a cut-off saw or a portable grinder. This operation removes any sharp, rough edges which otherwise might damage the gasket.

The ANSI/AWWA Standard for Ductile Iron Pipe requires only factory gauging of the bell and spigot ends. Accordingly, pipe selected for field cutting should also be field gauged in the location of the cut. In the field, a mechanical joint gland or an O.D. tape can be used as a gauging device. Canada Pipe supplies, with each load, pipe that has been "gauged full length" at the plant. These lengths are marked with paint on the bell face and can be used for cutting.



Figure 1

**NOTE:** IN NO CASE SHOULD PIPE BE CUT WITHIN 2 1/2 FEET (.75 m) OF THE BELL FACE WITHOUT FIRST GAUGING THE PIPE.

### SUITABLE PIPE DIAMETERS FOR FIELD CUTS

Nominal Pipe Size	Min. Pipe Diameter	Max. Pipe Diameter	Min. Pipe Circum.	Max. Pipe Circum.
in	in	in	in	in
4	4.74	4.86	14 29/32	15 9/32
6	6.84	6.96	21 1/2	21 7/8
8	8.99	9.11	28 1/4	28 5/8
10	11.04	11.16	34 11/16	35 1/16
12	13.14	13.26	41 9/32	41 21/32
14	15.22	15.35	47 13/16	48 7/32
16	17.32	17.45	54 13/32	54 13/16
18	19.42	19.55	61	61 13/32
20	21.52	21.65	67 19/32	68
24	25.72	25.85	80 13/16	81 7/32
30	31.94	32.08	100 11/32	100 25/32
36	38.24	38.38	120 1/8	120 9/16

•Diameters and Circumferences to be determined using an O.D. tape.