



CUTTING CLOW DUCTILE IRON PIPE

The ANSI/AWWA C111 standard requires all pipe to be factory gauged on the spigot end only. The manufacturing process of ductile iron pipe results in a tapered effect from end to end. The pipe O.D. will generally be larger near the bell. This taper will occasionally cause a pipe outside diameter to exceed the dimensions shown in Table 1. The spigot end of these pipe are still suitable for Tyton Bell and Mechanical Joint Bell assemblies however a field cut pipe that exceeds these dimensions cannot be used.

Clow carefully controls the manufacturing process to ensure as many pipe as possible are suitable for field cutting. Clow has pre-measured these pipe and marked those that are suitable with a GREEN STRIPE ON THE BELL FACE. This stripe indicates that the pipe can be cut anywhere along the barrel to within 24” of the bell face. Generally speaking, all 6-12” pipe fall into this category and the majority of 14”-36” fall into this category as well. All pipe that are not designated with the green stripe should only be cut after verifying the roundness with a MJ gland or verifying the dimensions with a conventional tape or a Pi O.D. tape. **Clow is not responsible for any pipe cut within 24” from the face of the bell or any pipe that is cut without the green stripe on the bell.**

Please see the diagram below for a summary of acceptable conditions to field cut our pipe.



Table 1

**DO NOT CUT
24 inches from
face of bell**

Outside Diameter.

**Pipe outside circumference*

<u>Size</u>	<u>Tolerance</u>		
6”	6.84-6.96	6”	21.49-21.87
8”	8.99-9.11	8”	28.24-28.62
10”	11.04-11.16	10”	34.68-35.06
12”	13.14-13.26	12”	41.28-41.66
14”	15.22-15.35	14”	47.81-48.22
16”	17.32-17.45	16”	54.41- 54.81
18”	19.42-19.55	18”	61.00-61.41
20”	21.52-21.65	20”	67.59-68.03
24”	25.72-25.85	24”	80.78-81.22
30”	31.94-32.08	30”	100.34- 100.78
36”	38.24-38.38	36”	120.125-120.563

***A flat steel tape should be used when measuring the circumference**