

1.9. Pipe ends must be cut square. Deviation from the right angle (cutting oblique) should not exceed that specified in Table. [5](#).

1.9. The ends of the pipes should be cut at right angles. The deviation from the right angle (the cosine of the cut) should not exceed the one indicated in Table 5.

Table 5

mm

Outer diameter	Outer diameter of pipes	478 - 720	820 - 1020	1120 - 1420
Marginal deviations along the cut	cosine	2.5	3.5	4.5

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1.10. Pipe ends must be chamfered at an angle of 25 - 30 ° to the pipe end. In this case, an end ring (blunting) should be left with a width of 1.0 - 3.0 mm - for pipes with a diameter of up to 1020 mm inclusive and a width of 1.0 - 5.0 mm - for pipes with a diameter of more than 1020 mm.

1.10. The ends of the pipes must have a chamfer at an angle of 25-30° to the end of the pipe. At the same time, an end ring (blunting) with a width of 1.0 - 3.0 mm should be left - for pipes with a diameter up to 1020 mm inclusive and a width of 1.0 - 5.0 mm - for pipes with a diameter of more than 1020mm.

At the request of the consumer, the bevel angle of the chamfer should be 30 - 35 ° , and for pipes with a wall thickness of 17 mm or more, the cutting of the edges should be performed in accordance with drawing. [1](#).

At the request of the consumer, the bevel angle of the chamfer should be 30 - 35 ° , and for pipes with a wall thickness of 17 mm or more, the cutting of the edges should be performed in accordance with fig. one.

Edge cutting is allowed in accordance with drawing. [one](#) conduct on the pipes With thick walls 15 mm .

.It is allowed to cut the edges in accordance with the rules. 1 carry out on pipes with a wall thickness of 15 mm.

