



*** For thicknesses beyond $7/8$ ", refer to ASME B16.9.**

Pipe Size	End Preparation
2" or less (wall thickness $3/16$ " and less)	Cut square or a slight chamfer at manufacture's option.
2 1/2" to 24"*** (wall thickness greater than $3/16$ ")	Plain bevel as in sketch above.

Note: For OD and ID transition contours (if necessary), refer to ASME B16.9 alternative bevel details (compound).

*** For sizes greater than 24", refer to ASME B16.9.