



*** 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.