



## Tolerances and Skid Quantities

### Outside Diameters and Tolerances

Nom. Pipe Size (in.)	Outside Diam.	Average.	Tolerances For Max. and Min. Diameter O of R					
			Sch. 40	Sch. 80	Sch. 120	SDRs 21, 26 & 41	SDR 13.5	
1/8	0.405	±0.004	±0.008	±0.008				
1/4	0.540	±0.004	±0.008	±0.008				
3/8	0.675	±0.004	±0.008	±0.008				
1/2	0.840	±0.004	±0.008	±0.008	±0.008	±0.015	±0.008	
3/4	1.050	±0.004	±0.010	±0.010	±0.010	±0.015	±0.010	
1	1.315	±0.005	±0.010	±0.010	±0.010	±0.015	±0.010	
1-1/4	1.660	±0.005	±0.012	±0.012	±0.012	±0.015	±0.012	
1-1/2	1.900	±0.006	±0.012	±0.012	±0.012	±0.030	±0.012	
2	2.375	±0.006	±0.012	±0.012	±0.012	±0.030	±0.012	
2-1/2	2.875	±0.007	±0.015	±0.015	±0.015	±0.030	±0.015	
3	3.500	±0.008	±0.015	±0.015	±0.015	±0.030	±0.015	
3-1/2	4.000	±0.008	±0.050	±0.015	±0.015	±0.050		
4	4.500	±0.009	±0.050	±0.015	±0.015	±0.050		
5	5.563	±0.010	±0.050	±0.030	±0.030	±0.050		
6	6.625	±0.011	±0.050	±0.035	±0.035	±0.050		
8	8.625	±0.015	±0.075	±0.075	±0.045	±0.075		
10	10.750	±0.015	±0.075	±0.075	±0.050	±0.075		
12	12.750	±0.015	±0.075	±0.075	±0.060	±0.075		
14	14.000	±0.015	±0.100	±0.100		±0.100		
16	16.000	±0.019	±0.160	±0.160		±0.160		
18	18.000	±0.019	±0.180	±0.180		±0.180		
20	20.000	±0.023	±0.200	±0.200		±0.200		
24	24.000	±0.031	±0.240	±0.240		±0.240		

Specifications applicable to Schedule 40, 80 and 120 piping are described in ASTM D1785  
 Specifications applicable to SDR 41, 26, 21 and 13.5 piping are described in ASTM D2241  
 O of R = Out of Roundness

### Pallet & Truck Load Quantities

Size (in.)	Pcs./ Skid	Ft./ Skid	Skid Dim.	Schd. 40 & SDR's		Schd. 80	
				Plain End Skids/ Truck	Belled End Skids/ Truck	Plain End Skids/ Truck	Belled End Skids/ Truck
1/2	285	5700	44 x 08	32	N/A	32	N/A
3/4	263	5260	43 x 10	28	N/A	24	N/A
1	214	4280	44 x 12	24	N/A	20	N/A
1-1/4	118	2360	43 x 11	28	28	28	28
1-1/2	103	2060	43 x 12	28	28	28	28
2	83	1660	44 x 14	28	28	24	24
2-1/2	54	1080	44 x 14	28	28	24	24
3	42	840	42 x 16	24	24	24	24
4	26	520	44 x 16	24	24	24	24
5	20	400	42 x 19	20	20	20	20
6	17	340	43 x 21	16	16	16	16
8	11	220	36 x 27	12	12	12	12
10	7	140	43 x 23	12	12	12	12
12	5	100	36 x 27	12	12	12	12
14	5	100	42 x 31	12	12	12	12
16	3	60	48 x 19	10	10	10	10
*18	3	60	54 x 21	8	8	8	8
*18	2	40	36 x 21	8	8	8	8
20	2	40	40 x 23	16	16	16	16
24	2	40	48 x 28	12	12	12	12

\*NOTE: Skid quantities for 18" pipe vary; i.e. One row on truck = One skid of 3 pcs and one skid of 2 pcs= 8 skids of 3pcs and 8 skids of 2pcs per truck

### Wall Thickness and Tolerances

Nominal Pipe Size (in.)	Wall Thickness													
	Schedule 40		Schedule 80		Schedule 120		SDR 41		SDR 26		SDR 21		SDR 13.5	
	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance	Minimum	Tolerance
1/8	0.068	+0.020	0.095	+0.020										
1/4	0.088	+0.020	0.119	+0.020										
3/8	0.091	+0.020	0.126	+0.020										
1/2	0.109	+0.020	0.147	+0.020	0.170	+0.020							0.062	+0.020
3/4	0.113	+0.020	0.154	+0.020	0.170	+0.020					0.060	+0.020		
1	0.133	+0.020	0.179	+0.021	0.200	+0.024			0.060	+0.020	0.063	+0.020		
1-1/4	0.140	+0.020	0.191	+0.023	0.215	+0.026			0.064	+0.020	0.079	+0.020		
1-1/2	0.145	+0.020	0.200	+0.024	0.225	+0.027			0.073	+0.020	0.090	+0.020		
2	0.154	+0.020	0.218	+0.026	0.250	+0.030			0.091	+0.020	0.113	+0.020		
2-1/2	0.203	+0.024	0.276	+0.033	0.300	+0.036			0.110	+0.020	0.137	+0.020		
3	0.216	+0.026	0.300	+0.036	0.350	+0.042			0.135	+0.020	0.167	+0.020		
3-1/2	0.226	+0.027	0.318	+0.038	0.350	+0.042			0.154	+0.020	0.190	+0.023		
4	0.237	+0.028	0.337	+0.040	0.437	+0.052			0.173	+0.020	0.214	+0.026		
5	0.258	+0.031	0.375	+0.045	0.500	+0.060			0.214	+0.027	0.265	+0.032		
6	0.280	+0.034	0.432	+0.052	0.562	+0.067			0.255	+0.031	0.316	+0.038		
8	0.322	+0.039	0.500	+0.060	0.718	+0.086			0.332	+0.040	0.410	+0.049		
10	0.365	+0.044	0.593	+0.071	0.843	+0.101			0.413	+0.050				
12	0.406	+0.049	0.687	+0.082	1.000	+0.120			0.490	+0.059				
14	0.437	+0.053	0.750	+0.090					0.538	+0.064				
16	0.500	+0.060	0.843	+0.101					0.615	+0.074				
18	0.562	+0.067	0.937	+0.112			0.439	+0.061	0.692	+0.083				
20	0.593	+0.071	1.031	+0.124			0.488	+0.068	0.769	+0.092				
24	0.687	+0.082	1.218	+0.146			0.585	+0.082	0.923	+0.111				