

IPS PIPE AND BEADTRIMMER™ HEAD SIZE CHART



Manufacturer of the

BEAD TRIMMER™ **HDPE FUSION BEAD REMOVAL TOOLING**

BEAD TRIMMER™ CUTTER RANGE ID

BT2-03	2.48" (63mm) - 3.28" (83mm) ID	BT3-08	6" (156mm) - 8.06" (205mm) ID	ML-24	18" (457mm) - 24" (610mm) ID
BT2-04	3.19" (81mm) - 4.22" (107mm) ID	BT3-10	7.62" (194mm) - 10.04" (255mm) ID	ML-30	24" (610mm) - 28" (711mm) ID
BT2-05	3.94" (100mm) - 5.22" (132mm) ID	BT3-12	9.04" (229mm) - 11.92" (302mm) ID	ML-36	28" (711mm) - 36" (914mm) ID
BT2-06	4.7" (119mm) - 6.2" (157mm) ID	BT3-14	9.93" (252mm) - 13.08" (332mm) ID	ML-54	36" (914mm) ID - 52" (1320mm) ID
		BT3-16	11.35" (288mm) - 14.95" (380mm) ID		
		BT3-18	12.77" (324mm) - 16.82" (427mm) ID		
		BT3-20	14.19" (360mm) - 18.69" (474mm) ID		
		BT3-22	15.61" (396mm) - 20.56" (522mm) ID		
		BT3-24	17.03" (432mm) - 22.43" (570mm) ID		

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PE4710		160 PSI SDR 13.5			150 PSI SDR 14.3			140 PSI SDR 15.5			125 PSI SDR 17		
IPS Pipe Size	Nominal OD (in)	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit
3"	3.500	0.259	2.950	BT2-03	0.245	2.981	BT2-03	0.226	3.021	BT2-03	0.206	3.021	BT2-03
4"	4.500	0.333	3.793	BT2-04	0.315	3.833	BT2-04	0.290	3.885	BT2-03	0.265	3.939	BT2-03
5"	5.563	0.412	4.689	BT2-05	0.389	4.738	BT2-05	0.359	4.802	BT2-05	0.327	4.869	BT2-05
6"	6.625	0.491	5.585	BT2-06	0.463	5.643	BT2-06	0.427	5.719	BT2-06	0.390	5.799	BT2-06
8"	8.625	0.639	7.271	BT3-08	0.603	7.346	BT3-08	0.556	7.445	BT3-08	0.507	7.549	BT3-08
10"	10.750	0.796	9.062	BT3-10	0.752	9.156	BT3-10	0.694	9.280	BT3-10 BT3-12	0.632	9.409	BT3-10 BT3-12
12"	12.750	0.944	10.748	BT3-12 BT3-14	0.892	10.860	BT3-12 BT3-14	0.823	11.006	BT3-12 BT3-14	0.750	11.160	BT3-12 BT3-14
14"	14.000	1.037	11.801	BT3-14 BT3-16	0.979	11.925	BT3-14 BT3-16	0.903	12.085	BT3-14 BT3-16	0.824	12.254	BT3-14 BT3-16
16"	16.000	1.185	13.487	BT3-16 BT3-18	1.119	13.628	BT3-16 BT3-18	1.032	13.812	BT3-16 BT3-18	0.941	14.005	BT3-16 BT3-18
18"	18.000	1.333	15.173	BT3-18 BT3-20	1.259	15.332	BT3-18 BT3-20	1.161	15.538	BT3-18 BT3-20	1.059	15.755	BT3-18 BT3-20
20"	20.000	1.481	16.859	BT3-20 BT3-22	1.399	17.035	BT3-20 BT3-22	1.290	17.265	BT3-20 BT3-22	1.176	17.506	BT3-20 BT3-22
22"	22.000	1.630	18.545	BT3-22 BT3-24	1.538	18.739	BT3-22 BT3-24	1.419	18.991	BT3-22 BT3-24	1.294	19.256	BT3-22 BT3-24
24"	24.000	1.778	20.231	BT3-22 BT3-24	1.678	20.442	BT3-22 BT3-24	1.548	20.717	BT3-24 ML-24	1.412	21.007	BT3-24 ML-24
26"	26.000	1.926	21.917	BT3-24 ML-24	1.818	22.146	BT3-24 ML-24	1.677	22.444	ML-24	1.529	22.758	ML-24
28"	28.000	2.074	23.603	ML-24	1.958	23.849	ML-24	1.806	24.170	ML-30	1.647	24.508	ML-30
30"	30.000	2.222	25.289	ML-30	2.098	25.552	ML-30	1.935	25.897	ML-30	1.765	26.259	ML-30
32"	32.000	2.370	26.975	ML-30	2.238	27.256	ML-30	2.065	27.623	ML-30	1.882	28.009	ML-30 ML-36
34"	34.000	2.519	28.661	ML-36	2.378	28.959	ML-36	2.194	29.350	ML-36	2.000	29.760	ML-36
36"	36.000	2.667	30.347	ML-36	2.517	30.663	ML-36	2.323	31.076	ML-36	2.118	31.511	ML-36
42"	42.000	3.111	35.404	ML-36	2.937	35.773	ML-36	2.710	36.255	ML-54	2.471	36.762	ML-54
48"	48.000	3.556	40.461	ML-54	3.357	40.883	ML-54	3.097	41.435	ML-54	2.824	42.014	ML-54
54"	54.000	NA	NA	NA	NA	NA	NA	3.484	46.614	ML-54	3.176	47.266	ML-54

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PE4710		110 PSI SDR 19			100 PSI SDR 21			80 PSI SDR 26			65 PSI SDR 32.5		
IPS Pipe Size	Nominal OD (in)	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit	Minimum Wall (in)	Average ID (in)	BT Head Size/Unit
3"	3.500	0.184	3.109	BT2-03	0.167	3.147	BT2-03	NA	NA	NA	NA	NA	NA
4"	4.500	0.237	3.998	BT2-03	0.214	4.046	BT2-03 BT2-05	0.173	4.133	BT2-03 BT2-05	0.138	4.206	BT2-05
5"	5.563	0.293	4.942	BT2-05 BT2-06	0.265	5.001	BT2-05 BT2-06	0.214	5.109	BT2-05 BT2-06	0.171	5.200	BT2-06
6"	6.625	0.349	5.886	BT2-06	0.315	5.956	BT2-06	0.255	6.085	BT2-06 BT3-08	0.204	6.193	BT3-08
8"	8.625	0.454	7.663	BT3-08	0.411	7.754	BT3-08 BT3-10	0.332	7.922	BT3-08 BT3-10	0.265	8.062	BT3-10
10"	10.750	0.566	9.551	BT3-10 BT3-12	0.512	9.665	BT3-10 BT3-12	0.413	9.873	BT3-10 BT3-12	0.331	10.049	BT3-12
12"	12.750	0.671	11.327	BT3-12 BT3-14	0.607	11.463	BT3-12 BT3-14	0.490	11.710	BT3-12 BT3-14	0.392	11.918	BT3-14
14"	14.000	0.737	12.438	BT3-14 BT3-16	0.667	12.587	BT3-14 BT3-16	0.538	12.858	BT3-14 BT3-16	0.431	13.087	BT3-16
16"	16.000	0.842	14.215	BT3-16 BT3-18	0.762	14.385	BT3-16 BT3-18	0.615	14.695	BT3-16 BT3-18	0.492	14.956	BT3-18
18"	18.000	0.947	15.992	BT3-18 BT3-20	0.857	16.183	BT3-18 BT3-20	0.692	16.532	BT3-18 BT3-20	0.554	16.826	BT3-20
20"	20.000	1.053	17.768	BT3-20 BT3-22	0.952	17.981	BT3-20 BT3-22	0.769	18.369	BT3-20 BT3-22	0.615	18.695	BT3-22
22"	22.000	1.158	19.545	BT3-22 BT3-24	1.048	19.779	BT3-22 BT3-24	0.846	20.206	BT3-22 BT3-24	0.677	20.565	BT3-24
24"	24.000	1.263	21.322	BT3-24 ML-24	1.143	21.577	BT3-24 ML-24	0.923	22.043	BT3-24 ML-24	0.738	22.434	ML-24
26"	26.000	1.368	23.099	ML-24	1.238	23.375	ML-24	1.000	23.880	ML-24	0.800	24.304	ML-30
28"	28.000	1.474	24.876	ML-30	1.333	25.173	ML-30	1.077	25.717	ML-30	0.862	26.174	ML-30
30"	30.000	1.579	26.653	ML-30	1.429	26.971	ML-30	1.154	27.554	ML-30	0.923	28.043	ML-30 ML-36
32"	32.000	1.684	28.429	ML-36	1.524	28.770	ML-36	1.231	29.391	ML-36	0.985	29.913	ML-36
34"	34.000	1.789	30.206	ML-36	1.619	30.568	ML-36	1.308	31.228	ML-36	1.046	31.782	ML-36
36"	36.000	1.895	31.983	ML-36	1.714	32.366	ML-36	1.385	33.065	ML-36	1.108	33.652	ML-36
42"	42.000	2.211	37.314	ML-54	2.000	37.760	ML-54	1.615	38.575	ML-54	1.292	39.260	ML-54
48"	48.000	2.526	42.644	ML-54	2.286	43.154	ML-54	1.846	44.086	ML-54	1.477	44.869	ML-54
54"	54.000	2.842	47.975	ML-54	2.571	48.549	ML-54	2.077	49.597	ML-54	1.662	50.478	ML-54