

## SPECIFICATIONS FOR IMPERIAL BENDS AND TEES BS 4825: 1991

### TOLERANCES

#### Outside Diameter

The tolerance on the outside diameter, in the straight length, shall be as follows:

- (a) Upto and including 101.6 mm diameter  $\pm 0.5\%$  with a minimum of  $\pm 0.1$  mm.
- (b) Over 101.6 mm diameter  $\pm 0.75$

#### Thickness

The tolerance on wall thickness, in the straight length, shall be  $\pm 10\%$  of the specified value.

#### Face to centre-line length

The tolerance on face to centre-line length/centre to end, shall be as follows:

- (a) Upto and including 101.6 mm diameter + 0.5, -0mm
- (b) Over 101.6 mm diameter +1.0, -0.mm

### SURFACE FINISH

The internal and external surfaces of Bends and Tees shall be as given in the following table.

#### Surface finish of Bends and Tees

Finish	Ra maximum	Typical types of finish
Internal	1.0	Polishing, abrasive
External	2.5	Cleaning, acid descaling

NOTE 1. Ra is defined in BS1134

NOTE 2. The purchaser should specify on his enquiry and/or Order the type(s) of finish required for the internal and external surfaces of Bends and Tees.

NOTE 3. Care should be taken that no deposit of any material Which might prove harmful during subsequent use and/or Fabrication shall remain on the Bends and Tees.

NOTE 4. Bends and Tees should be clean and free from surface defects or inclusions.

#### Manufacture's certificate

The manufacturer shall supply, when requested by the purchaser in the enquiry and/or order, a certificate stating that the Bends and Tees comply with the requirements of this standard for the appropriate type of Bends and Tees.