

B&D PRODUCTS (HALIFAX) LTD

DATA SHEET #102 for:

Bi-Metallic Flanges to BS4504 Part 2 (1974) Table 6/23

General:

Bi-metal (carbon steel and gunmetal) flanges, also known as composite flanges, spinning flanges or QA (Quick Action) flanges. To be used with copper and copper-alloy tubes for water (including potable), and sanitary applications.

Pressure-Temperature Ratings:

Nominal Pressure (bar)	Temperature (Degrees C)						
	-10/120	150	180	200	220	250	260
6	Maximum Permissible Working Pressure (bar)						
	6	6	6	5	4	2.5	2

Note: Intermediate values may be inferred by linear interpolation.

Materials:

Outer flange: Carbon steel conforming to BS4360 Grade 40A.

Inners: Cast Gunmetal conforming to BS1400 LG2.

Finishes:

Outer flange: Machined all over, with green (RAL6011) epoxy coating for corrosion resistance.

Inner: Machined all over, supplied with tube stop, for location of tube.

Bolting:

The dimensions and finishes of bolting materials should comply with the following:-

-Studs: BS4439 Grade 4.8

-Hexagon Headed Bolts: BS3692 or BS4190 Grade 4.6

-Stud-bolts: BS4882 Carbon steel.

-Nuts: BS3692, BS4190 Grade 4, or BS4882 Grade 2H/M as appropriate.

Where washers are used, they should conform to BS4320 (1968) Table 3.

Gaskets:

Inside bolts gaskets should be used, with the material selection made with consideration of the suitability for the fluid, at the intended working temperature and pressure conditions.

Attachment of flanges:

Gunmetal inners to be silver brazed to copper or copper-alloy tubes, to the requirements of appropriate application standard.