



Designation: B 428 – 93 (Reapproved 2004)

Standard Test Method for Angle of Twist in Rectangular and Square Copper and Copper Alloy Tube¹

This standard is issued under the fixed designation B 428; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This test method establishes the requirements for the determination of the angle of twist in rectangular and square copper and copper alloy tube.

1.2 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Significance and Use

2.1 The rectangular or square copper alloy tube covered by this test method may be used in applications in which control of twist is important to proper fit in final assembly and to minimize rework to bring the tube into compliance. It is recognized that the amount of twist, in degrees, per increment of length can change as a result of the weight of the product and its length during measurement.

2.2 This test method provides a procedure for measuring the twist in square and rectangular copper and copper alloy tubes as a measure of the deviation from straightness.

2.3 This test method allows the purchaser and supplier or manufacturer to inspect square and rectangular copper and copper alloy tube with a standard technique that provides acceptable twist in delivered tubes.

3. Apparatus

3.1 *Horizontal Reference Plane* (see Fig. 1 and Fig. 2) of sufficient length to support the tube specimen and a clamping device to hold one end of the specimen against the reference plane.

3.2 *Transparent Plastic Protractor Segment* engraved with angle lines as shown in Fig. 3.

3.3 *Parallel Face Blocks.*

¹ This test method is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.06 on Methods of Test.

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4. Procedure

4.1 Place the tube specimen lengthwise on the reference plane. Whenever the specimen has noticeable edgewise curvature, place the specimen so that a side having convex curvature is in contact with the reference plane. Further placement requirements are as follows:

4.1.1 For rectangular tube, place a major outer dimension side (width side) against the reference plane, as shown in Fig. 1.

4.1.2 For square tube, having curvature along all edges, place the specimen so that the side with the least convex curvature is against the reference plane.

4.2 Clamp one end of the specimen so that the tube surface, adjacent to that end and facing the reference plane, will be in firm contact with this plane. Keep the other end of the specimen free.

4.3 Position the protractor segment flush against the free end of the specimen, as shown in Fig. 2, and measure the total angle of twist by reading the degrees for that angle line which most nearly coincide with the lower outside edge of the tube end. In making this reading, keep the lower edge of the protractor segment in contact with the reference plane or hold it parallel to this plane by use of the parallel face blocks.

4.4 The angle of twist per unit length is the total angle of twist for the specimen divided by its length and shall be calculated according to the units specified in the material specification.

5. Precision and Bias

5.1 This test method is unaffected by edgewise curvature of the specimen, and the precision for measurement of total angle of twist is $\pm 0.5^\circ$.

5.2 This test method has no bias because the values of twist are a direct measurement based on the accuracy of the protractor and the observation of the operator.

6. Keywords

6.1 angle; copper; copper alloy; rectangular; square; tube; twist