



Designation: ~~B508-97 (Reapproved 2003)~~ Designation: B 508 – 07

Standard Specification for Copper Alloy Strip for Flexible Metal Hose¹

This standard is issued under the fixed designation B 508; 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 specification establishes the requirements for annealed copper-alloy strip for the manufacture of flexible metal hose produced from Copper Alloy UNS Nos. C41100 and C50500.

1.1.1 The nominal compositions are as follows:

Copper Alloy UNS No.	Copper	Zinc	Tin
C41100	91.0	8.5	0.5
C50500	98.7	...	1.3

1.2 The values stated in inch-pound units are to be regarded as the standard, except grain size, which is given in SI units. The values given in parentheses are for information only.

1.3 The following precautionary statement pertains only to the test method portion, Section 13, of this specification: *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. Referenced Documents

2.1 *ASTM Standards:*²

B 601 Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast

B 846 Terminology for Copper and Copper Alloys

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E 62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Method) ~~Methods~~

E 112 Test Methods for Determining the Average Grain Size

E 255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition

E 478 Test Methods for Chemical Analysis of Copper Alloys

3. Terminology

3.1 *Definitions:*

3.1.1 For definitions of terms related to copper and copper alloys, refer to Terminology B 846.

~~3.2 Definitions of Terms Specific to This Standard:~~

~~3.2.1 coil (as applied to a flat product)—a length of the product spirally wound into a series of connected turns. The unqualified term “coil” as applied to “flat product” usually refers to a coil in which the product is spirally wound, with the successive layers on top of one another (sometimes called a “roll”).~~

~~3.2.2 level or traverse wound—a coil in which the turns are positioned into layers parallel to the axis of the coil such that successive turns in a given layer are next to one another.~~

~~3.2.3 level or traverse wound on a reel or spool—a coil in which the turns are positioned into layers on a reel or spool parallel to the axis of the reel or spool such that successive turns in a given layer are next to one another.~~

~~3.2.4 reel or spool—a cylindrical device that has a rim at each end and an axial hole for a shaft or spindle, and on which the product is wound to facilitate handling and shipping.~~

~~3.2.5 strip—a rolled flat product, other than flat wire, up to and including 0.188 in. [4.78 mm] thick, in straight lengths, coils~~

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is direct responsibility of Subcommittee B05.01 on Plate, Sheet, and Strip.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard.

(rolls), or ~~traverse wound on reels or spools: with slit, sheared, or slit and rolled edges in widths up to 24 in. [610 mm] inclusive; or, with finished drawn or rolled edges in widths over 1/4 to 12 in. [31.8 to 305 mm] inclusive.~~

4. Ordering Information

4.1 Orders for product under this specification should include the following information:

- 4.1.1 ASTM designation and year of issue,
- 4.1.2 Copper Alloy UNS No. (see Section 1 and Table 1),
- 4.1.3 Temper (see 7.1 and Table 2),
- 4.1.4 Quantity, number of pieces or total weight of each alloy and size, and
- 4.1.5 *Dimensions*—Thickness and width; and length, if applicable (see 8.2 and 8.3).

4.2 The following options are available and should be specified at the time of placing the order, when required:

- 4.2.1 *How furnished*—Coils (inside and outside diameters), pounds per inch of width; stock or specific lengths, with or without ends;
- 4.2.2 *Packing*—Type of pallet, skid, or box: interleaving, banding, maximum weight, and so forth; and
- 4.2.3 Special surface condition requirements, if any (see 9.3).

5. Materials and Manufacture

5.1 *Material:*

5.1.1 The material of manufacture shall be cast bar, slab, cake, billet, or so forth of Copper Alloy UNS No. C41100 or C50500 of such soundness as to be suitable for processing in to the products prescribed herein.

5.1.2 In the event heat identification or traceability is required, the purchaser shall specify the details desired.

NOTE 1—Because of the discontinuous nature of the processing of castings into wrought products, it is not always practical to identify specific casting analysis with a specific quantity of finished material.

5.2 *Manufacture:*

5.2.1 The product shall be manufactured by such hot working, cold working, and annealing processes as to produce a uniform wrought structure in the finished product.

5.2.2 The product shall be hot or cold worked to the finished size and subsequently annealed, if required, to meet the temper properties specified.

5.2.3 *Edges*—Slit edges shall be furnished unless otherwise specified in the contract or purchase order.

6. Chemical Composition

6.1 The material shall conform to the requirements prescribed in Table 1 for the alloy specified in the ordering information.

6.2 These composition limits do not preclude the presence of other elements. Limits for unnamed elements may be established and analysis required by agreement between the manufacturer or supplier and purchaser.

6.3 Zinc, when given as the “remainder,” is the differences between the sum of the results for all elements analyzed and 100 %.

6.3.1 Copper may be taken as the difference between the sum of all elements analyzed and 100 % and, when so determined, the difference value shall conform to the requirements given in Table 1.

6.4 When analyzed, the sum of results for all elements listed in Table 1 for Copper Alloy UNS C41100 shall be 99.7 % minimum and 99.5 % minimum for Copper Alloy UNS C50500.

7. Grain Size of Annealed Tempers

7.1 The average grain size of each of two samples of annealed material, as determined on a longitudinal cross section, shall be within the limit prescribed of the four nominal grain sizes listed in Table 2 when tested in accordance with Test Method E 112.

7.2 In the case of thin-gage material 0.010 in. [0.25 mm] and under, there shall exist no less than six grains per stock thickness, averaged for five locations one thickness apart.

TABLE 1 Chemical Requirements

Element		Composition, %	
		Copper Alloy UNS Nos.	
		C41100	C50500
—	Copper	89.0–92.0	...
—	Copper	89.0–92.0	Remainder
—	Tin	0.30–0.7	1.0–1.7
—	Phosphorus	...	0.03–0.35
—	Iron, max	0.05	0.10
—	Lead, max	0.10	0.05
—	Zinc	remainder	0.30 max
—	Copper + tin +	...	99.5
—	phosphorus, min		

TABLE 2 Grain Size Requirements

Temps Standard Designation ^A	Grain Size, mm		
	Nominal	Minimum	Maximum
OS050	0.050	0.035	0.090
OS035	0.035	0.025	0.050
OS025	0.025	0.015	0.035
OS015	0.015	^B	0.025

^A Standard designations defined in Classification B 601.

^B Although no minimum grain size is required, this material must be fully recrystallized.

8. Dimensions, Mass, and Permissible Variations

8.1 *General*—For the purpose of determining conformance with the dimensional requirements prescribed in this specification, any measured value outside the specified limiting values for any dimension may be cause for rejection.

8.2 *Thickness*—The standard method of specifying thickness shall be in decimal fractions of an inch. For material 0.021 in. [0.533 mm] and under in thickness, it is recommended that the nominal thickness be stated not closer than the nearest 0.0005 in. [0.013 mm]. For example, specify 0.006 or 0.0065 in. [0.152 or 0.165 mm], but not 0.0063 in. [0.160 mm]. For material over 0.021 [0.533 mm] in thickness, it is recommended that the nominal thickness² be stated not closer than the nearest 0.001 in. [0.025 mm]. For example, specify 0.128 or 0.129 in. [3.25 or 3.28 mm] but not 0.1285 in. [3.26 mm]. A list of preferred thickness is shown in Appendix X1. The thickness tolerances shall be those shown in Table 3.

8.3 *Width*—The width tolerances shall be those shown in Table 4.

8.4 *Straightness*—The straightness tolerances shall be those shown in Table 5.

9. Workmanship, Finish, and Appearance

9.1 The product shall be uniform in quality and soundness and free of internal and external defects. However, surface blemishes that do not interfere with the intended application are acceptable.

9.2 The product shall be well cleaned and free of dirt.

9.3 A superficial film or residual light lubricant shall be permissible, unless otherwise specified in the contract or purchase order.

10. Sampling

10.1 The lot size, portion size, and selection of pieces shall be as follows:

10.1.1 *Lot Size*—15 000 lb, [6825 kg], or less material of the same mill form, alloy, temper, and thickness, subject to inspection at one time.

10.1.2 *Portion Size*—A portion shall be four or more pieces selected as to be representative of each lot. If the lot consists of less than four pieces, representative samples shall be taken from each piece.

10.2 *Chemical Analysis*—A sample for chemical analysis shall be taken and prepared in accordance with Practice E 255.

10.2.1 Instead of sampling in accordance with Practice E 255, the manufacturer shall have the option of determining conformance to chemical composition as follows: Conformance shall be determined by the manufacturer by analyzing samples taken at the time the castings are poured or samples taken from the semifinished product. If the manufacturer determined the chemical composition of the material during the course of manufacture, he shall not be required to sample and analyze the finished product. The number of samples taken for determination of chemical composition shall be as follows:

10.2.1.1 When samples are taken at the time the castings are poured, at least one sample shall be taken for each group of castings poured simultaneously from the same source of molten metal.

10.2.1.2 When samples are taken from the semifinished product, a sample shall be taken to represent each 10 000 lb [4550 kg] or fraction thereof, except that not more than one sample shall be required per piece.

10.3 *Grain Size*—Samples for grain size shall be taken from material in the finished condition. A sample shall be taken to represent each 10 000 lb [4550 kg] or fraction thereof, except that not more than one sample shall be required per piece.

11. Number of Tests and Retests

11.1 *Tests*:

11.1.1 Chemical composition shall be determined as the average of results from at least two replicate determinations of each specified element.

11.1.2 *Other Tests*—For other tests, test specimens shall be taken from two of the sample pieces selected in accordance with 10.1.2. The required tests shall be made on each of the specimens so selected.

11.2 *Retests*:

11.2.1 When requested by the manufacturer or supplier, a retest shall be permitted should test results obtained by the purchaser fail to conform with the specification requirements.

11.2.2 Retesting shall be as directed in the product specification for the initial test(s), except that the number of test specimens shall be twice that normally required for the test.