



Designation: B153 – 11

Standard Test Method for Expansion (Pin Test) of Copper and Copper-Alloy Pipe and Tubing¹

This standard is issued under the fixed designation B153; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

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 expansion pin test for copper and copper-alloy pipe and tubing with an inside diameter of 0.125 in. (3.2 mm) and greater or an outside diameter up to and including 4 in. (102 mm).

NOTE 1—For tubes of sizes with an inside diameter less than 0.125 in. (3.2 mm), a substitute test method must be agreed upon between the manufacturer and purchaser.

NOTE 2—For tubes of sizes greater than 4 in. (102 mm) in outside diameter, refer to B968/B968M for a test method.

1.2 *Units*—The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *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

B846 Terminology for Copper and Copper Alloys

B968/B968M Test Method for Flattening of Copper and Copper-Alloy Pipe and Tube

3. Terminology

3.1 For definitions of terms related to copper and copper alloys, refer to Terminology B846.

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.

Current edition approved Jan. 1, 2011. Published February 2011. Originally approved in 1941. Last previous edition approved in 2005 as B153–05. DOI: 10.1520/B0153-11.

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.

4. Summary of Test Method

4.1 The prepared test specimen is expanded over a conical pin inserted at a uniform speed or pressure. The expansion of the test specimen shall be measured on the outside of the tube diameter and shall conform to the product specification.

5. Significance and Use

5.1 When properly performed and interpreted, the expansion pin test will provide information with regard to the capacity of a tube for expansion and to reveal surface defects. The expansion pin test may provide data for research and development, engineering design, quality control, and acceptance or rejections in specifications.

5.2 In certain product specifications which establish requirements for tubes of sizes greater than 4 in. (102 mm), the test described in B968/B968M may be allowed as a substitute.

6. Apparatus

6.1 *Pin*—The conical pin shall have an included angle of 60°, unless provided otherwise in the product specification. The pin shall be made of carbide or tool steel that has been hardened and ground to the prescribed angle and shall have a smooth, polished surface. The size of the pin at the base shall be suitable for the size of tubing being tested.

6.2 *Testing Machine*—Any type of testing machine, either hydraulically or mechanically operated, that will exert pressure to expand the pipe and tubing on the pin at a uniform rate.

7. Sampling and Test Specimen Preparation

7.1 The test specimen shall be prescribed in the specification for the product being tested. In the event that a test specimen size is not prescribed in the pipe or tube specification, the specimen shall be of suitable length so that it can be expanded to the required amount. Both ends shall either be faced square to the longitudinal axis in a lathe, or suitably prepared so as to have a smooth surface free from scratches or burrs, which might interfere with the test.

8. Procedure

8.1 The test specimen shall be wiped clean to remove any loose chips or dirt from the inside surface. The specimen shall

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