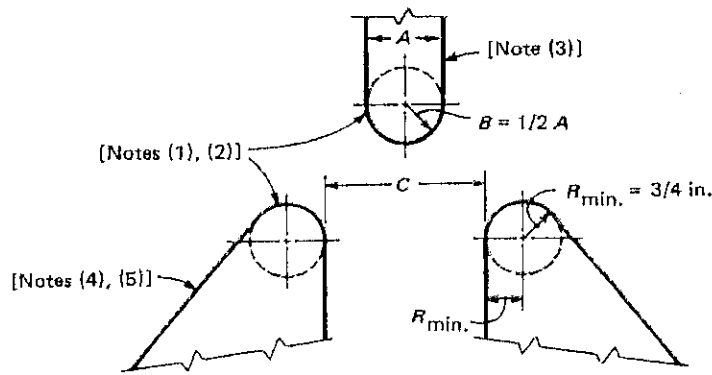


QW-466 Test Jigs (Cont'd)



Material	Thickness of Specimen, in.	A, in.	B, in.	C, in.
P-No. 23 to P-No. 2X; P-No. 2X with F-No. 23; P-No. 35	1/8 $t = 1/8$ or less	2-1/16 $16-1/2t$	1-1/32 $8-1/4t$	2-3/8 $18-1/2t + 1/16$
P-No. 11; P-No. 25 to P-No. 21 or P-No. 22 or P-No. 25	3/8 $t = 3/8$ or less	2-1/2 $6-2/3t$	1-1/4 $3-1/3t$	3-3/8 $8-2/3t + 1/8$
P-No. 51	3/8 $t = 3/8$ or less	3 $8t$	1-1/2 $4t$	3-7/8 $10t + 1/8$
P-No. 52, P-No. 61, P-No. 62	3/8 $t = 3/8$ or less	3-3/4 $10t$	1-7/8 $5t$	4-5/8 $12t + 1/8$
All others	3/8 $t = 3/8$ or less	1-1/2 $4t$	3/4 $2t$	2-3/8 $6t + 1/8$

GENERAL NOTES:

- (a) For P-Numbers, see QW-422; for F-Numbers, see QW-432.
- (b) The weld and heat affected zone in the case of a transverse-weld bend specimen shall be completely within the bend portion of the specimen after testing.
- (c) See General Note (b) of QW-466.1.

NOTES:

- (1) Either hardened and greased shoulders or hardened rollers free to rotate shall be used.
- (2) The shoulders or rollers shall have a minimum bearing surface of 2 in. for placement of the specimen. The rollers shall be high enough above the bottom of the jig so that the specimens will clear the rollers when the ram is in the low position.
- (3) The ram shall be fitted with an appropriate base and provision made for attachment to the testing machine, and shall be of a sufficiently rigid design to prevent deflection and misalignment while making the bend test. The body of the ram may be less than the dimensions shown in column A.
- (4) If desired, either the rollers or the roller supports may be made adjustable in the horizontal direction so that specimens of  $t$  thickness may be tested on the same jig.
- (5) The roller supports shall be fitted with an appropriate base designed to safeguard against deflection or misalignment and equipped with means for maintaining the rollers centered midpoint and aligned with respect to the ram.

QW-466.2 GUIDED-BEND ROLLER JIG

ASME Section IX