

CONFIRMED
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Specification for

Pressed steel gutters rainwater pipes fittings and accessories

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The Hardware and Ironmongery Industry Standards Committee, under whose supervision this British Standard was prepared, consists of representatives of the following Government departments and scientific and industrial organizations:

- Aluminium Federation
- British Ironfounders Association
- British Lock and Latch Manufacturers' Association
- British Plastics Federation
- British Waterworks Association
- Cast Butt Hinge Manufacturers' Association
- Copper Development Association
- D.S.I.R. Building Research Station*
- Guild of Architectural Ironmongers
- Institution of Municipal Engineers*
- London County Council
- Metal Window Association
- Ministry of Public Building and Works
- National Brassfoundry Association
- National Federation of Builders' and Plumbers' Merchants*
- National Federation of Building Trades Employers
- National Federation of Ironmongers
- Royal Institute of British Architects*
- The Royal Institution of Chartered Surveyors
- Zinc Development Association

The Government department and professional organizations marked with an asterisk in the above list, together with the following, were directly represented on the Committee entrusted with the preparation of this British Standard:

- Association of Galvanized Steel Gutter and Pipe Manufacturers
- British Constructional Steelwork Association
- British Iron and Steel Federation
- Federation of Registered Housebuilders
- Iron and Steel Institute
- National Association of Iron and Steel Stockholders
- Vitreous Enamel Development Council

This British Standard, having been approved by the Hardware and Ironmongery Industry Standards Committee and endorsed by the Chairman of the Building Divisional Council, was published under the authority of the General Council on 4 December 1963

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Foreword

This standard makes reference to the following British Standards:

BS 729, *Zinc coatings on iron and steel articles — Part 1. Hot-dip galvanized coatings.*

BS 1344, *Methods of testing vitreous enamel finishes — Part A2. Resistance to culinary acids.*

BS 1449, *Steel plate, sheet and strip.*

This British Standard has been revised under the authority of the Hardware and Ironmongery Industry Standards Committee.

The opportunity has been taken to specify the materials in accordance with the present day supply position, amend sundry descriptive terms, and extend the nominal size range. The standard has been expanded to include requirements for “vitreous enamelled” as an alternative finish.

NOTE Metric equivalents are given in Appendix A. The figures in British units are to be regarded as the standard. The metric conversions are approximate. More accurate conversions should be based on the tables in BS 350, “Conversion factors and tables”.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i to iv, pages 1 to 14, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

1 Scope

This British Standard relates to:

- i) Light pressed steel gutters, rainwater pipes, fittings and accessories.
- ii) Heavy pressed steel gutters.

Section 1. Light pressed steel gutters, rainwater pipes, fittings and accessories

2 General

This section of the standard covers:

- 1) Pressed steel half-round and O.G. rainwater gutters and fittings not exceeding 6 in nominal size.
- 2) Pressed steel rainwater pipes and fittings not exceeding 4 in nominal size.
- 3) Accessories.

3 Definitions

For the purposes of this standard, the following definitions apply:

3.1

left hand O.G. gutter or O.G. gutter fitting

a gutter or gutter fitting shall be deemed to be left hand if, when the observer is facing the moulded or splayed side, the socket projects to the left

3.2

right hand O.G. gutter or O.G. gutter fitting

a gutter or gutter fitting shall be deemed to be right hand if, when viewed as above, the socket projects to the right

3.3

fittings

this term refers to the following articles:

- i) For use with gutters: Outlets, angles and stop ends.
- ii) For use with pipes: Offsets, bends and shoes.

3.4

accessories

this term refers to the following articles:

- i) Gutter brackets.
- ii) Bolts, nuts and washers.
- iii) Fixing screws.

4 Materials

The material used in the manufacture of light pressed gutters, gutter fittings, gutter brackets, down pipes and fittings shall be as follows:

- a) *For galvanized finish.* Mild steel sheet, coil or strip of a quality equivalent to Type En2, according to the requirements of BS 1449¹⁾.
- b) *For vitreous enamelling finish.* Cold reduced sheet, coil or strip suitable for vitreous enamelling according to the requirements of BS 1449.

The thickness of metal before either finish shall be:

- i) 18 B.G. (0.049 in, 1.257 mm) for gutters and gutter fittings, or a heavier grade if so specified by the purchaser.
- ii) 24 B.G. (0.024 in, 0.629 mm) for rainwater pipes and pipe fittings, or a heavier grade if so specified by the purchaser.

5 Workmanship

The finished gutters, down pipes, fittings and accessories shall be true and smooth, and the ends shall be finished square to the axes. They shall be in all respects sound and free from imperfections that render them unsuitable for their purpose. All holes shall be punched before the coating finish is applied. Down pipes and fittings shall be made with a seamed or welded joint.

6 Effective length

Gutters and rainwater pipes shall be supplied in effective lengths of 6 ft, 4 ft and 3 ft, exclusive of the socket unless otherwise specified. A tolerance of $\pm \frac{1}{4}$ in shall be allowed on the length of an individual gutter or pipe, but the average length of any single batch of any one size of gutter or pipe shall not be less than the nominal length.

7 Dimensions

The dimensions of gutters, gutter fittings, down pipes and pipe fittings shall be in accordance with the requirements of the appropriate tables and drawings, see Table 1 to Table 5 and Figure 1 to Figure 20.

The nominal size of a down pipe or down pipe fitting shall be measured in terms of its internal diameter. The nominal size of a gutter or gutter fitting shall be the measurement between the internal edges at the top of the gutter or gutter fitting.

¹⁾ BS 1449, "Steel plate, sheet and strip".