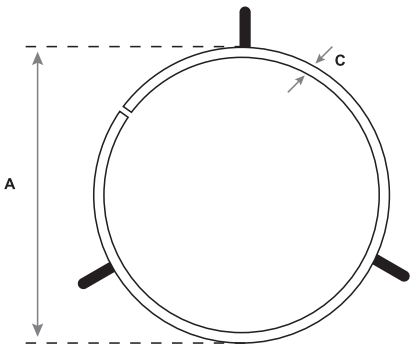
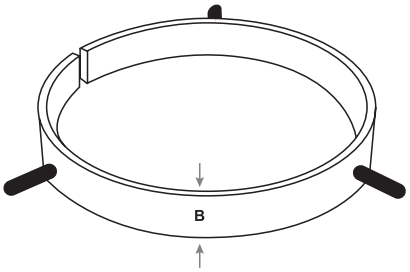
Republic Brass Sales, Inc.
619.229.8304
6566 Federal Blvd
Lemon Grove, CA 91945
www.republicbrasssales.com

BACKING (CHILL) RING

Specification: MIL-STD-22D
FIGURE 63





NOMINAL PIPE SIZE	RBS P/N	A	B	C
1/4"	CH**XY**-040	0.205	3/4" (+/- 1/32")	1/8" (+/-1/32")
3/8"	CH**XY**-060	0.330	3/4" (+/- 1/32")	1/8" (+/-1/32")
1/2"	CH**XY**-100	0.455	3/4" (+/- 1/32")	1/8" (+/-1/32")
3/4"	CH**XY**-150	0.705	3/4" (+/- 1/32")	1/8" (+/-1/32")
1"	CH**XY**-200	0.955	3/4" (+/- 1/32")	1/8" (+/-1/32")
1 1/4"	CH**XY**-250	1.205	3/4" (+/- 1/32")	1/8" (+/-1/32")
1 1/2"	CH**XY**-300	1.455	3/4" (+/- 1/32")	1/8" (+/-1/32")
2"	CH**XY**-400	1.955	3/4" (+/- 1/32")	1/8" (+/-1/32")
2 1/2"	CH**XY**-450	2.435	1" (+/- 1/32")	3/16" MAX
3"	CH**XY**-500	2.935	1" (+/- 1/32")	3/16" MAX
3 1/2"	CH**XY**-550	3.435	1" (+/- 1/32")	3/16" MAX
4"	CH**XY**-600	3.935	1" (+/- 1/32")	3/16" MAX
5"	CH**XY**-700	4.935	1" (+/- 1/32")	3/16" MAX
6"	CH**XY**-800	5.935	1" (+/- 1/32")	3/16" MAX
8"	CH**XY**-900	7.935	1" (+/- 1/32")	3/16" MAX
10"	CH**XY**-1000	9.935	1" (+/- 1/32")	3/16" MAX
12"	CH**XY**-1100	11.935	1" (+/- 1/32")	3/16" MAX

AVAILABLE ALLOYS:
(FERROUS) CARBON STEEL (A105) &
STAINLESS STEEL (GRADES 304 / 316 / 321 / 347)

(NON-FERROUS)
CUNI (90/10 & 70/30), NICU (MONEL), ALUMINUM

NOTES: For P/N's:

*Replace **X** with the following codes for Material:*

*Stainless Steel 304 - **304***
*Stainless Steel 316 - **316***
*Stainless Steel 321 - **321***
*Stainless Steel 347 - **347***
*Carbon Steel - **CS***
*Nicu (Monel) - **M***
*Aluminum - **A***
*Cuni 70/30 - **7***
*Cuni 90/10 - **9***

*Replace **Y** with the following codes for Pressure:*

*Class 200 - **200***
*Class 700 - **700***
*Schedule 40 - **40***
*Schedule 80 - **80***
*Schedule 160 - **160***

Backing Rings are designed for quick, easy alignment of pipe, tube, fittings, valves and assure precise, close tolerance fit-up. They allow complete penetration and fusion of the weld and radiograph perfect certified welds. The 3/4" long spacer nubs automatically set the weld gap for the root-pass. The internal bevel and flat inner lands assure non-restricted fluid flow. Backing Rings are manufactured with the 3/32" ring gap on sizes 4" and smaller and 1/8" on sizes 5" and larger.