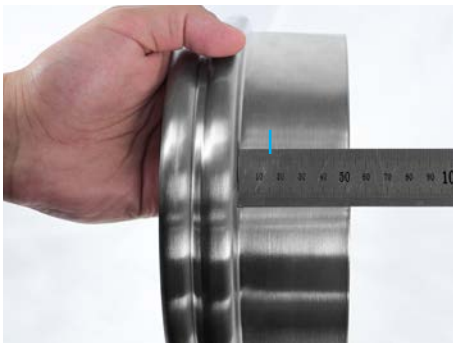
Spigot Welding Instructions

01. **DO NOT** cut the BFM® spigot diameter and re-size before installation.

02. Size fitting to pipe. Pipe circumference may need to be expanded or reduced to suit the BFM® spigot.

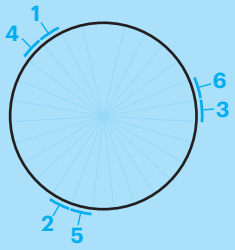


03. Avoid cutting the tail down if possible. If it is necessary to shorten it, we recommend leaving at least 15mm (19⁄32") on the tail.

TAKE CARE TO AVOID HEAT SHRINKAGE!

The tail of the spigot can be cut right to the base of the head, but **extreme care should be taken to avoid welding shrinkage on any spigot** as this will effect the fit of the flexible connector cuff.

We recommend that welding is undertaken in small sections eg. 10mm at a time, and that this is done on alternating thirds of the connector circumference to avoid over-heating large portions of the spigot.



04. Tack BFM® spigot to correct sized pipe.

05. Peen the tacked joint to ensure correct fit.

06. Weld fitting on. Dress and polish to required standards.

All care must be taken to ensure that the circumference of the head after fitting and welding remains the same size as supplied, to ensure fitting tolerance of the connector.

Spigot Welding Instructions...(continued)

01.

The stainless steel spigots (flanges) have a tail 52mm (2") long. These can be easily cut down or cut on an angle to suit your existing pipework. See installation instructions on previous page for more information.

02.

It is important to weld the spigots onto your pipework with the length of the flexible connector in mind and the correct installation gap (IG) for the position/application involved. There is a BFM® Installation Gap Calculator App available to calculate this IG (go to www.bfmfitting.com/calculator).

All BFM® fittings are available with a length in increments of 50mm (2").

03.

Ensure your spigots are installed parallel to each other and not on an angle as this will impact the performance of the connector.

You may also need to re-align your pipework to enable the spigots to be installed in-line with each other (offset installations are not recommended).

04.

For applications where there is a possibility for static build up eg. wood, dust, flour, milk powder etc, we recommend using a static dissipative wire (strip) connecting the two BFM® spigots together (see examples).