



## ROSE BRAND

### Internal Expanding Batten Splice

Rose Brand Item Number HWSPLIBATEXPAND

1. Batten material shall be new schedule 40 steel pipe, 1 1/2" ID. The pipe shall be painted flat black. All ends shall be cut square. Unspliced ends shall be chamfered smooth so there will be no sharp edges. At each end where splices shall be used, a 7/16" hole shall be drilled, 3" from the end.
2. Internal expanding splices made with 1/2" x 1 1/4" CF flat iron, 12" long shall be used to mechanically splice the pipe battens together. No other type of splice is acceptable. The two pieces of CF flat shall be pinned together with 5/16" x 1" roll pins, 4" OC. The holes for the 5/16" roll pins shall be 5/16" dia. for a tight and secure fit. The 3/8"-16 tapped holes in one of the two CF flat irons shall be 6" OC. 3/8"-16 x 1" lock point Allan set screws shall be placed in each tapped hole. All four long edges shall be broken to facilitate splice installation.
3. The splice shall be inserted into the ends of the two pieces of pipe. The set screws shall be inserted through the 7/16" holes in the batten and tightened with the pipes being pushed together for a tight fit. The screws shall be tightened twice.

In case you need this for the future.

1. Splices shall be 1 9/16" OD steel tubing, 5/32" wall cut 18" long. The ends of the splices shall be chamfered to remove any sharp edges. The splices shall be secured with 1/4" nail (hammer) in steel rivets. There shall be 2 rivets on each side of each splice. The first rivet shall be at 2" from the joint, the 2nd rivet shall be 4" OC and 90° from the 1st rivet.
2. The splice may be secured with a single plug weld in each pipe or a plug weld in one pipe and rivets as above in the other side. If plug welding is employed, the hole in the pipe shall be 3/4" dia. before welding. The plug welds shall be ground smooth and painted to match the battens.