



Thermocouple Technology, Inc.

Series PFD

Post-Fabricated Flange Dimensions – Manufacturing Standard

SEC. I – Tolerances

1. Flange Thickness
 - RF, FF, RTJ $+.12"/-.063"$
 - All Others $+/- .063"$
2. Gasket Surface
 - Std Flanges 125-200 Microinch. Serrated-Spiral grooves (phonographic)
 - RTJ (Ring Type) 125-200 AARH. Smooth machined surface- no grooves.
 - Vanstone Series 125-200 AARH. Smooth machined surface-no grooves.
 - Flanged w/ Sheath 32-64 RMS (surface finish of the thermowell flange face)
3. Stamping
 - a) ANSI B16.5 Mill Standard stamping, and
 - b) Manufacturer's traceability code and/or requested stamping using 3/32" min. height characters.
4. Threaded Flanges
Reference TTEC Series information for Threaded-On & Seal Welded Series thermowells. Unless specified otherwise, flange threads are in compliance with ANSI B1.20.1 to mate with a thermowell stem. (ASME B16.5 threads will not properly mate with a thermowell stem.)
5. Drilled Diameters
 - a) Varies to accommodate the interdependent factors of the thermowell's specifications. Request the applicable TTEC Welding Specification.
 - b) $+.005"/.000"$ drilled diameters provided for "flange only" orders.
6. Welding
 - Qualifications Certified under ASME Sec. IX, B&PVC.
 - Documentation WPS (Welding Procedure Qualification) & PQR (Procedural Qualification Record) are available upon request, PRIOR to fabrication.
 - Specifications Request TTEC welding specifications for the applicable procedure:
 - a) Standard welding – TTEC Series SW
 - b) Full penetration welding – TTEC Series FPW
 - c) Custom – request information from the Sales Department

Sec. II – Flanged Thermowell Disclosure

1. Flanged thermowells are proprietary products and are not governed by the ASME B16.5. Post-Fabricated flanges do NOT qualify as compliant with the ASME B16.5 Standard. Ref: ANSI B16.5-1988 (1992) Interpretation Section "1-1: Modification to Flanges, reply to number (1) and (2)" and Section "1-4: Proprietary Products, reply to (1) and (3)" for additional information regarding compliance rulings for flanged thermowells.
*NOTE: TTEC will be pleased to quote price & availability for post-fabricated flanges that meet the ASME B16.5 minimum flange thickness. Pricing will increase and availability may be extended.