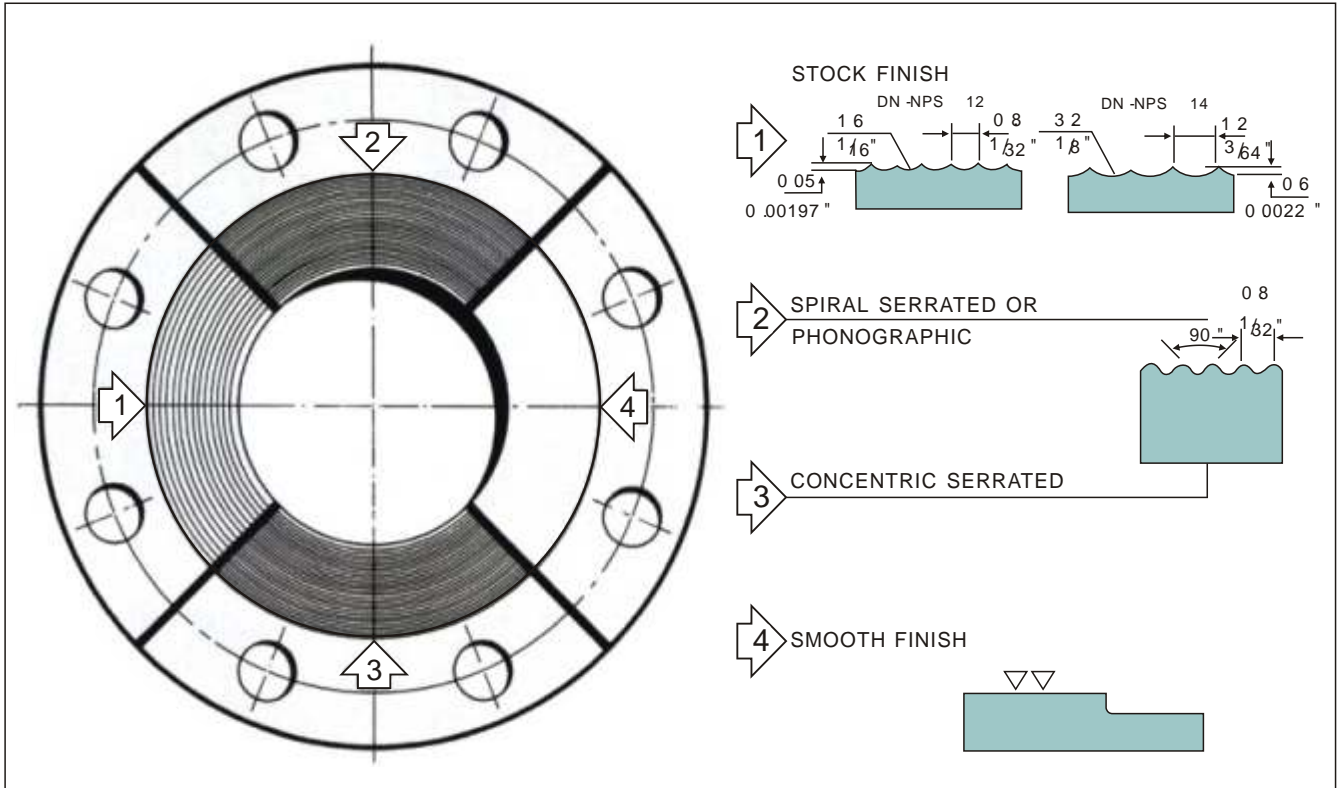


STANDARD FINISH

STANDARD FINISHES for Face of Flange (ANSI B16.5) 1



STOCK FINISH:

The most widely used of any gasket finish, because practically is suitable for all ordinary service conditions. This is a continuous spiral groove. Flanges sizes 12" (304.8mm) and smaller are produced with a 1/16" round-nosed tool at a feed of 1/32" per revolution. For sizes 14" (355.6mm) and larger, the finish is made with 3/16" round-nosed tool at a feed of 3/64" per revolution.

SPIRAL SERRATED OR PHONOGRAPHIC:

This finish is producing by using a 90° round-nosed tool.

CONCENTRIC SERRATED:

This finish is producing by using a 90° round-nosed tool.

SMOOTH FINISH:

The cutting tool employed shall have an approximate 0.06" radius. The resultant surface finish shall have a 125 μ in. (3.2 μ in.) to 250 μ in. (6.3 μ in.) approximate roughness (ANSI B16.5 para 6.4;4.1)

1. RAISED FACE, AND LARGE MALE AND FEMALE

Either a serrated-concentric or serrated-spiral finish having from 34 to 64 grooves per inch is used. The cutting tool employed has an approximate 0.06 in. radius. The resultant surface finish shall have a 125 μ in. (3.2 μ in.) to 500 μ in. (12.5 μ in.) approximate roughness.

2. TONGUE AND GROOVE, AND SMALL MALE AND FEMALE

The gasket contact surface does not exceed 125 μ in. (3.2 μ in.) roughness

3. RING JOINT

The inside wall surface of gasket groove does not exceed 63 μ in. (1.6 μ in.) roughness.

4. BLIND

Blind flanges need not be faces in the center if, when this center part is raised, its diameter is at least 1 in. smaller than the inside diameter of fittings of the corresponding pressure class. When the center part is depressed, its diameter is not greater than the inside diameter of the corresponding pressure class fittings. Machining of the depressed center is not required.