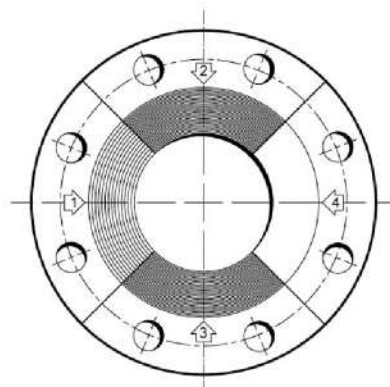
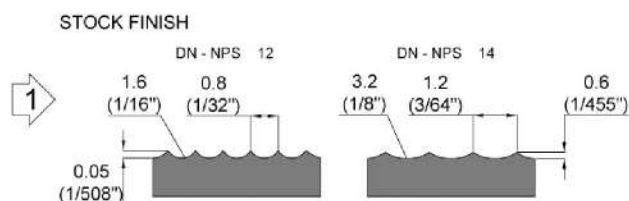




## STANDARD FINISHES FOR FACE OF FLANGE (ANSI B16.5)

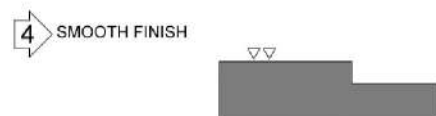


### Stock Finish :



The most widely used in any gasket finish. It is practically suitable for all ordinary service conditions. This is a continuous spiral groove. Flanges sizes 12" and smaller are produced with 1/16" round-nosed tool at a feed of 1/2" per revolution. For sizes 14" and larger, the finish is made with 1/8" round-nosed tool at a feed of 3/64" per revolution.

### Smooth Finish :



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

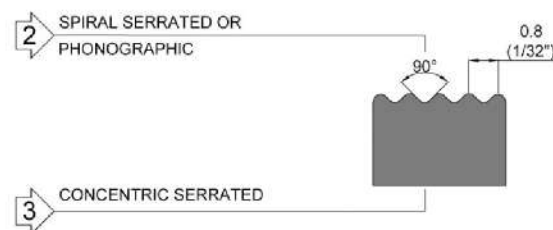
### RAISE FACE, LARGE MALE AND FEMALE

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

### TONGUE AND GROOVE, SMALL MALE AND FEMALE

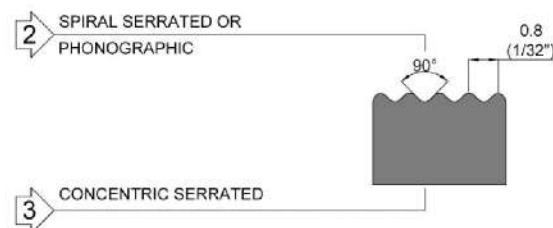
The gasket contact surface does not exceed 125µ inch (3.2µm) roughness.

### Spiral Serrated or Phonographic :



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

### Concentric Serrated :



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

### RING JOINT

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

### BLIND

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