

PRODUCTION SPECIFICATION

SCOPE: This specification covers the requirements for API INT. Stock Plate Flanges & Rings.
Part Numbers: PF, PFB, PF-D, PFE, PF-E, PFH, PFBH, PFHR, SPF, SPFBH, SPFH, & SPF-D.

Vendor's Initials Certifying Compliance	CHARACTERISTIC	REQUIREMENT
<input type="checkbox"/>	1 Physical/ Material	Plate: Carbon Steel - ASTM A36 (when required); otherwise Q235 (with high ts & ys). Stainless Steels - ASTM A240 (304/304L or 316/316L) Forged: Steel - ASTM A105 Stainless Steels - ASTM A182 (304/304L or 316/316L) MILL CERTIFICATION is required with MTRs. All materials shall conform to the latest revisions of ASTM Standards.
<input type="checkbox"/>	2 Finish - Very Important	Flanges to be Flat Face and have one face serrated with spiral or concentric serrations, 125 µin – 500 µin, 24-55 grooves per inch. Serrations shall not have protrusions above the serrations or variation that affects the gasket seal. All other surfaces, to be 250 µin or better.
<input type="checkbox"/>	3 Dimensional Tolerances Flange Nominal Dimensions	Dimensional Tolerances - See attachment 1.A: "QS1-FDT-PLATE.pdf" Flange Nominal Dimensions - See attachment 2.A: "ENG1-Plate Flange Nominal Dimensions.pdf"
<input type="checkbox"/>	4 Structural Integrity of Material	Material shall be of highest quality and shall not exhibit any internal voids, cracks, pitting, or porosity on or below the surface. Repairing defect material by welding (or any other means) is not permitted and will result in rejection of full batch/heat.
<input type="checkbox"/>	5 Flange Identification Markings	Each flange shall be impression stamped as follows: Country of Origin - within 0.10" of I.D. with 1/8" high letters on un-serrated face. Part Number, Heat Number, Size, Material Specification, Material Grade, & AWWA Mark (if applicable) along O.D. edge with 1/8" high letters. See attachment 3a-3c and 3g: "Required Flange Markings.pdf"
<input type="checkbox"/>	6 Inspection	100% Inspection of all dimensions. All dimensions must meet the requirements of attachment 1.A and 2.A.
<input type="checkbox"/>	7 Appearance	All edges should be free of burrs and should not be sharp. Flanges should not be scratched, dented or nicked. Bolt Hole chamfers should be smooth. Flanges should be clean.
<input type="checkbox"/>	8 Coating	Carbon Steel Flanges should have light mist of clean/clear oil coating. SDS sheets are mandatory and shall be provided to API Purchasing for all corrosive preventatives.

Note 1) – These Production Specifications shall be as stated above, unless otherwise specified in the Purchase Order, a Product Engineering Drawing/Engineering Specification or Quality Documentation.



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9	Packaging /Crating	<p>Packaging in Crates - Specific instructions per purchase order as specified. <i>All products</i> should be packed carefully to minimize damage. Place desiccant bags into crates (inside/outside flanges to absorb moisture).</p> <p>Palletized Stock Flanges - All API International Stock Flanges shall be packaged per the purchase order and Attachment 5 – Flange Packaging Procedure.</p> <p>All stainless-steel flanges must be individually wrapped or separated by cardboard to avoid scratching. Attach labels on outside of crates/pallets (per attachment 7).</p>
10	Documentation	<ol style="list-style-type: none"> 1. Mill Certification (from Mill) & Material Test Results (MTR) - Must show matching Tensile Strength, Yield Strength, elongation percent at break, along with Chemical composition. MTR per excel format, Mill Cert per attachment 4 example. 2. Packing Slip - Must show correct part numbers, quantities, and corresponding crates.

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DATE	REV	DESC.	INITIALS	APPROVAL
4/21/2026	A	Initial Release, Adapted and revised scope from PS-102722	EA	4/21/2026 - GTD