



VNE MaxPure Fittings Specifications and Submittal Documentation

MaxPure – Fittings Specifications and Submittal Documentation

Product:

Stainless Steel fittings comply with current BPE standards.

Gaskets are made from compounds which are FDA approved and USP 87, 88 Pharmaceutical Class VI certified.

Sizes:

Stainless Steel fittings are available in sizes 1/4" - 6" O.D. tube size.

Material:

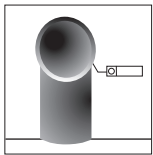
Fittings are fabricated in AISI 316L Stainless Steel. Weld end fittings utilize controlled sulfur content of 0.005-0.017% achieving superior repeatability for automatic orbital welding process. Reference: BPE 2016 Part MM-5.2.1.1

Dimensions & Tolerances:

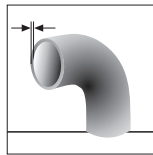
Dimensions as specified in 2016 BPE Part DT-3-1

Nominal Size	O.D.		Wall Thickness Mechanical Polish (MP)		Wall Thickness Electropolish (EP)		Squareness Face to Tangent, B		Off Angle, O		Equivalent Angle (for O)	Off Plane, P		Centerline Radius (CLR), R	
	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	deg	in.	mm	in.	mm
1/4	±0.005	±0.13	+0.003/-0.004	+0.08/-0.10	+0.003/-0.006	+0.08/-0.15	0.005	0.13	0.009	0.23	2.1	0.030	0.76	0.563	14.30
3/8	±0.005	±0.13	+0.003/-0.004	+0.08/-0.10	+0.003/-0.006	+0.08/-0.15	0.005	0.13	0.012	0.3	1.8	0.030	0.76	1.125	28.58
1/2	±0.005	±0.13	+0.005/-0.008	+0.13/-0.20	+0.005/-0.010	+0.13/-0.25	0.005	0.13	0.014	0.36	1.6	0.030	0.76	1.125	28.58
3/4	±0.005	±0.13	+0.005/-0.008	+0.13/-0.20	+0.005/-0.010	+0.13/-0.25	0.005	0.13	0.018	0.46	1.4	0.030	0.76	1.125	28.58
1	±0.005	±0.13	+0.005/-0.008	+0.13/-0.20	+0.005/-0.010	+0.13/-0.25	0.008	0.20	0.025	0.64	1.4	0.030	0.76	1.500	38.10
1 1/2	±0.008	±0.20	+0.005/-0.008	+0.13/-0.20	+0.005/-0.010	+0.13/-0.25	0.008	0.20	0.034	0.86	1.3	0.050	1.27	2.250	57.15
2	±0.008	±0.20	+0.005/-0.008	+0.13/-0.20	+0.005/-0.010	+0.13/-0.25	0.008	0.20	0.043	1.09	1.2	0.050	1.27	3.000	76.20
2 1/2	±0.010	±0.25	+0.005/-0.008	+0.13/-0.20	+0.005/-0.010	+0.13/-0.25	0.010	0.25	0.054	1.37	1.2	0.050	1.27	3.750	95.25
3	±0.010	±0.25	+0.005/-0.008	+0.13/-0.20	+0.005/-0.010	+0.13/-0.25	0.016	0.41	0.068	1.73	1.3	0.050	1.27	4.500	114.30
4	±0.015	±0.38	+0.008/-0.010	+0.20/-0.25	+0.008/-0.012	+0.20/-0.30	0.016	0.41	0.086	2.18	1.2	0.060	1.52	6.000	152.40
6	±0.030	±0.76	+0.015/-0.015	+0.38/-0.38	+0.015/-0.017	+0.38/-0.43	0.030	0.76	0.135	3.43	1.3	0.060	1.52	9.000	228.60

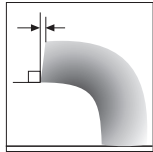
Roundness



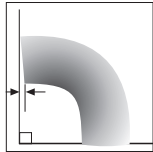
Wall Thickness



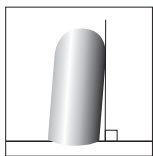
Squareness Face to Tangent



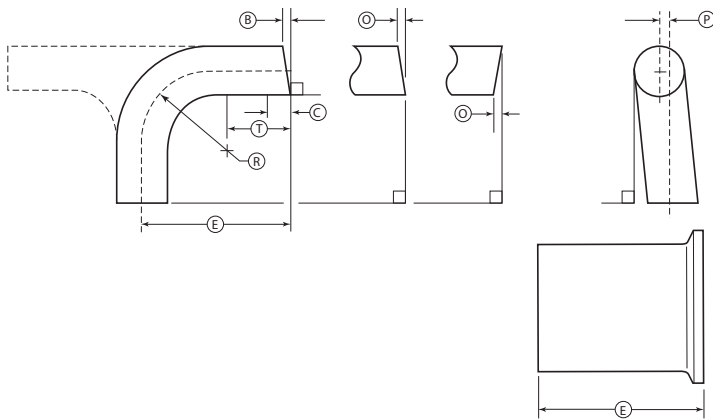
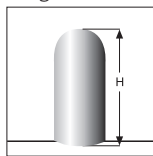
Off Angle



Off Plane



Height



General Notes:

- Tolerance on **E** end-to-end and center-to-end: 0.050 in. (1.27 mm)
- Tolerance for centerline radius (CLR) is ±10% of the nominal dimension

Fittings Specifications and Submittal Documentation

Surface Finish:

Reference: BPE-2016, Part SF, Table SF-2.4-1.

Surface Finish Code	BPE Surface Designation	Inside Surface			Outside Surface
		Ra Maximum		Surface Condition	Surface Condition
		μ-in.	μm		
PX	SF0			No finish requirement	No finish requirement
PC	SF1	20	0.51	Mechanically Polished [1]	Light Polish
PL	SF1	20	0.51	Mechanically Polished [1]	Mechanically polished to 32 Ra μ-in.
PD	SF4	15	0.38	Mechanically Polished [1] & Electropolished	Light Polish
PM	SF4	15	0.38	Mechanically Polished [1] & Electropolished	Mechanically polished to 32 Ra μ-in.
PR	-	10	0.25	Mechanically Polished [1] & Electropolished	Mechanically polished to 32 Ra μ-in.

[1] Or any other finishing method that meets the Ra max.

- MaxPure fittings guarantee the Ra in all internal surfaces, including bent areas where it is difficult to polish and difficult to measure.
- All Ra readings are taken across the lay, wherever possible.
- No single Ra reading shall exceed the Ra max. value in this table.
- Other Ra readings are available if agreed upon between owner/user and supplier, not to exceed values in this table.

Cleaning:


MaxPure fittings are cleaned using a multiple step process to assure clean surface, areas inside and out with repeatability every time.

Inspection Procedures:

All fittings produced by VNE production are visually inspected for any surface finish imperfections, as mentioned in Table SF-2.2-1, SF-2.2-2, SF-2.4-1 and SF- 2.6-1 in the BPE 2016 specification. All dimensional characteristics are inspected for tolerances listed in parts DT-3-1 to DT-9.3-1 in the BPE 2016 specification.

Fitting Marking Information:

Each fitting and process component is marked to show the following:

- Heat number/code traceable to material test report for each product contact surface component
- Material type
- Manufacturer's name, logo, & trademark
- Product contact surface designation for the appropriate BPE specification
- ASME BPE mark  or "BPE" designation

*Contact VNE for details on products covered under the MaxPure EGMO ASME BPE certification



Packaging & Labeling:

Each fitting is capped, bagged and labeled in full compliance with the current BPE standard.

Documentation:

Full Material Test Reports are supplied with the finished products and are available On-Line at <https://mtr.vnestainless.com>

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