

STANDARD THERMOWELL MANUFACTURING TOLERANCES

JMS Thermowells meet or exceed the following standards:

(Copies are available from JMS Southeast, Inc., ANSI, or the issuing body.)

ASME B40.9 - Thermowells for Thermometer and Electrical Temperature Sensors

SAMA RC17-10-1963 - Bushings and Wells for Temperature Sensing Elements

ISA 1.02.01 - Thermowells

IEC 61520 - Functional Dimensions of Metal Thermowells for Thermometer Sensors

The following specifications are for .260 and .385 bore thermowells:

Lengths: $\pm 1/16$ " on lengths 12" or less

$\pm 1/8$ " on lengths 12" or over

Wells up to 38" bore depths are drilled from solid bar stock to specified tip thickness (1/4" standard). A built-up design is necessary after 38 1/4" overall length.

Bore I.D. Tolerance:

$\pm .001$

O.D. Tolerances:

Fractional: $\pm .015$

Decimal: $\pm .005$ on .000 place

$\pm .010$ on .00 place

Concentricity of Bore to O.D.:

$\pm 10\%$ of minimum wall thickness

End Thickness:

Gun drill bottom, $1/4" \pm 1/16"$.

Male Threads (NPT):

± 1 turn of thread gauge

Female Threads:

1/2" NPS standard, 1/2" NPT available upon request

Radius Under Threads and Flanges:

1/8" is standard, $\pm 1/16"$

1/16" on Van Stone

Lagging Extension:

Lagging on wells is left as hex and is not turned. For material not available in hex, round bars with wrench flats will be furnished.

End of Wells:

Break corners. No burrs.

Wetted Surfaces Finish for "U" Dimension

63 ST is our standard surface finish. A mirror polish is available upon request. 8 RMS is our standard for a mirror polish, and must be specified on the order. Electropolish or electroplating is also available. There is an additional charge for mirror, electropolish or electroplating.

Stamping:

Material code and type of material is stamped on hex or round.

Flanged Wells:

Made in accordance with ANSI B16.5 with serrated raised face. We also furnish 125 RMS smooth face which must be specified when needed. Other surface finishes are available upon request.

Weld Configuration:

Front groove welds are 1/4" wide by 5/16" deep. Rear groove welds are 1/8" wide by 1/8" deep "V". Welds are machined, leaving 1/4" radius. Full penetration welds are available upon request.

