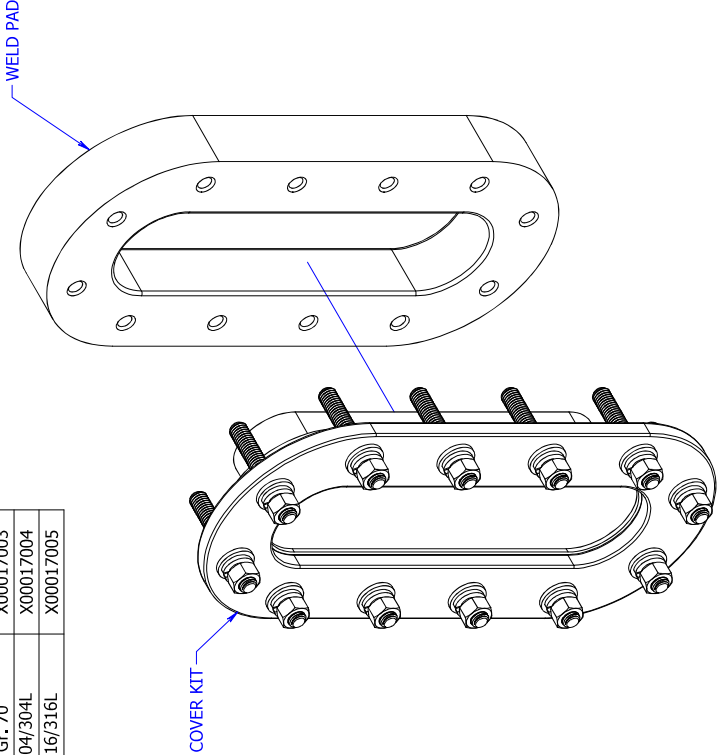


COVER KIT OPTIONS			
COVER MATERIAL	DESIGNATION	ACCEPTS RUBBER LINING?	PART #
CARBON STEEL	SA-516 Gr. 70	N	X00017677
CARBON STEEL	SA-516 Gr. 70	Y	X00017678
304 STAINLESS	SA-240 304/304L	N	X00017679
316 STAINLESS	SA-240 316/316L	N	X00017680

WELD PAD OPTIONS		
MATERIAL	DESIGNATION	PART #
CARBON STEEL	SA-516 Gr. 70	X00017003
304 STAINLESS	SA-240 304/304L	X00017004
316 STAINLESS	SA-240 316/316L	X00017005



-GENERAL NOTES-

- ALL INFORMATION SHOWN APPLIES TO "UTF STANDARD" 3"x12" SIGHT WINDOWS.
- ALL SIGHT WINDOWS ARE MADE FROM "AZCARB GP"
- ALL COVER KITS USE EPDM GASKETS
- ALL COVER KITS USE 316/316L SS BOLTS/HARDWARE

-ENGINEERING NOTES-

- UTF STANDARD SIGHT WINDOW RATED 0-150 PSI, @ -20°F TO 240°F. MATERIAL REVIEW REQUIRED FOR ASME APPLICATIONS OUTSIDE OF THESE PRESSURES OR TEMPERATURES AND WHERE ALTERNATE MATERIAL PROPERTIES ARE SPECIFIED.

-FABRICATION NOTES-

- FABRICATOR RESPONSIBLE FOR VERIFYING WELDING FRAME PROVIDES ADEQUATE REINFORCEMENT WHEN WELDED INTO HOST COMPONENT.
- VESSEL FABRICATOR TO ENSURE SEALING SURFACE OF WELDING PAD FALLS WITHIN ACCEPTABLE TOLERANCES FOLLOWING WELDING TO HOST COMPONENT.

-ASSEMBLY NOTES-

- CLEAN AND CHASE ALL THREADS PRIOR TO BEGINNING ASSEMBLY.
- INSTALL ALL STUDS IN WELDING PAD "HAND TIGHT".
- SLIP SEALING GASKET OVER SIGHT GLASS HUB, AND INSERT INTO WELDING PAD.
- CENTER AND PLACE CUSHION GASKET ON WINDOW EXTERIOR FACE. LOW TACK SPRAY ADHESIVE MAY BE USED TO HOLD GASKET.
- SLIP COVER FLANGE OVER STUDS.
- CHECK FOR INTERFERENCE AND ALIGNMENT OF SEALING SURFACES.
- INSTALL WASHER, LOCK WASHER, AND NUT "HAND TIGHT" TO EACH STUD.
- TORQUE EACH NUT WITH 9-18 FT-LBS IN A CRISS-CROSS PATTERN WITH MAXIMUM OF 1.5 FT-LBS DEVIATION BETWEEN BOLTS DURING TIGHTENING.
- INSPECT FINAL ASSEMBLY FOR SPECIFIED FIT AND FINISH. REMOVE AND ADHESIVE OR FOREIGN MATTER AND CLEAN WINDOW.

-ADDITIONAL ENGINEERING DATA-

- FLAT SEALING SURFACE: 5/8" AROUND PRIMER
- SURFACE FINISH: TO 62 RMS
- BOLT HOLE CLEARANCE: 3/32" FROM GASKET EDGE
- THREAD ENGAGEMENT (MIN.): 9/16"



TOLERANCES	
DEGREES ± 1/2°	⊥ ± 1/8" @ 18"
0.000" ± 1/16"	// ± 1/8" @ 18"
0.00" ± 1/8"	

PART DESCRIPTION
MATERIAL DESCRIPTION

A	-	4/30/2025	JDK	DESIGNER	JLS	INITIAL DESIGN	DESCRIPTION	REVISION HISTORY
REV	ECN	DATE	DESIGNER	CHECKED BY	JLS	INITIAL DESIGN	DESCRIPTION	REVISION HISTORY
							3x12 SIGHT WINDOW	
							SHEET 1 OF 1	