

FORM QF-482(c) SUGGESTED FORMAT FOR SIDEWALL-FUSING PROCEDURE SPECIFICATION (FPS or SFPS)
(See QF-201.3, Section IX, ASME Boiler and Pressure Vessel Code)

Company Name _____ By _____

Fusing Procedure Specification No. _____ Date _____

Revision No. _____ Date _____

FPS qualification By testing SFPS If qualified by testing, supporting PQR No.(s) _____

<p>Joints (QF-402)</p> <p>Joint Design _____</p> <p>Header size range _____</p> <p>Fitting Manufacturer _____</p> <p style="padding-left: 40px;">Branch connection (diameter) range _____</p> <p>Sketches, production drawings, joint symbols, or written description should show the general arrangement of the parts to be fused. Where applicable, the details of the joint groove may be specified.</p>	<p align="center">Details</p>
<p>Materials (QF-403)</p> <p>Fitting Specification _____ Classification _____ to Header Specification _____ Classification _____</p>	
<p>Thermal Conditions (QF-405)</p> <p>Heater temperature _____ °F (°C) Heating initial interfacial pressure _____</p> <p>Heating soak interfacial pressure _____ Melt bead size or time at heat soak _____</p> <p>Heater plate removal time _____ Fusing interfacial pressure _____</p> <p>Cool-down time at fusing pressure _____ Cool-down time post-fusion _____</p> <p>Other _____</p>	
<p>Equipment (QF-406)</p> <p>Fusing Machine Manufacturer _____ Model _____</p> <p>Other _____</p>	
<p>Technique (QF-407)</p> <p>Abrasion device _____ Post-abrasion cleaning method _____</p> <p>Other _____</p>	