

COSMETIC FINISH STANDARD**ALUMINIUM CASTINGS****DSF 3.1.3****Definition:**

The cost of painting a casting can be significant, particularly if masking and plugging of feature holes is extensive.

Where aluminium alloy castings are to be used without paint or plating, the surface is to have a uniform visual appearance. The removal of fettling, sand and joint evidence can be achieved by using a blasting process.

Grit Blasting (Sand blasting) is a dry high pressure process using an abrasive media which is then accelerated through a blasting nozzle by means of compressed air. The impact of the grit on the metal surface puts the surface layer into compression, and this effect can be beneficial, in reducing stress corrosion cracking in aluminium alloys. This technique removes burrs, paint, rust and /or 'keys' the substrate for subsequent high performance coatings.

Properties:

- Low cost, effective cleaning process.
- Machine end of life disposal is assisted by not having paint or other surface media to be removed before recycling of the casting.

Preferred media grit is Aluminium Oxide; grit size 80 μm - 120 μm .

Acceptable Finish:**Unacceptable Finish:**

Issue	01	02	03	04	05	06	07	08	09
DCR		44734							

COSMETIC FINISH STANDARD**ALUMINIUM CASTINGS****DSF 3.1.3****ASM (DEK) Application:**

This standard applies to any ASM (DEK) designed component used on a machine, or supplied as a spare by the vendor.

All components must meet the criteria set out in this standard, unless a concession has been granted by ASM (DEK).

Where conflict is found between this standard and any other specification, the priority should be as follows:-

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| 1 st Customer Specified Requirement. | 3 rd Purchasing contract |
| 2 nd ASM (DEK) Engineering specification. | 4 th This standard |

This standard is not an exhaustive list, any component displaying a non-specified symptom which may cause a customer issue should be reviewed only by authorised ASM(DEK) personnel.

Only upon this approval can the component be released from ASM (DEK) or its vendor.

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