

STANDARD ENGINEERING INSTRUCTION

Cosmetic Criteria for Uncoated Stainless Steel Components – Sheet and Plate

DSF 3.2.16

1. Scope

This DSEI applies to any component or fabrication manufactured from sheet or plate stainless steel which does not receive any other surface coating. This DSEI should be read in conjunction with the acceptable cosmetic criteria DSF 3.2.3 & DSF 3.2.4.

2. Applicability

Any new design initiated after the first issue date of this document.

Any major rework of an existing design initiated after the first issue date of this document.

This does not apply to stencils, squeegee blades or components where DSF 3.2.13 has been specified.

This does not apply if the mill finish of the material matches that of this standard.

3. Purpose

The primary purpose of this finish is to remove any mill applied markings and disrupt the surface such that when two components are placed next to each other they are visually consistent and complimentary, regardless of manufacturer.

The secondary purpose of this finish is to remove burrs and positive edges created during the cutting process.

4. Method

The surface disruption (abrasion) should be generated using a random orbit orbital sander fitted with a 280 grit fleece. A minimal force should be applied to the surface of the material such that the surface is disrupted as opposed to fully abraded.

This disruption should be applied to both sides of the sheet after punching and/or lasering but prior to any folding. An example of the acceptable finish is shown in Figure 1.

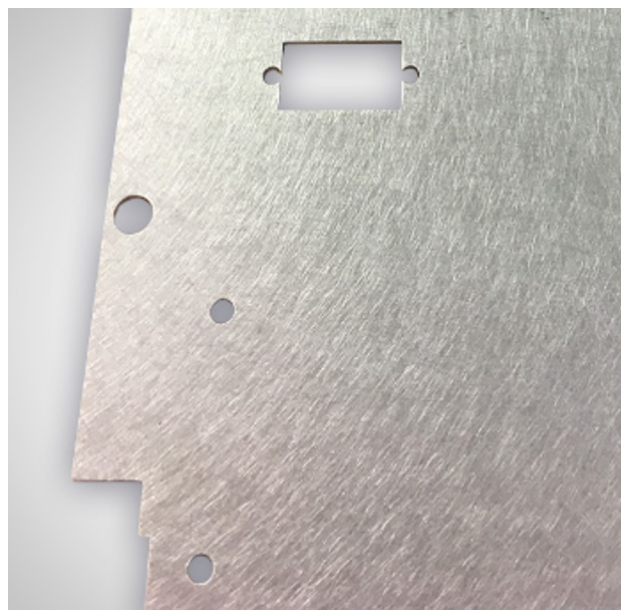


Figure 1 – Acceptable Surface Finish

Issue	01	02	03	04	05	06	07	08
Date	23/04/2024							