

SURFACE FINISH
STAINLESS STEEL _BRUSHED
DSF 3.2.13

Definition:

Stainless steel is available in both standard mill finishes and mechanically treated surface finishes. The majority of these finishes can be divided into three categories.

BS EN 10088 Part 2 uses a numerical code for surface finishes as follows:-

- Hot Rolled: Ex – mill : Class: **1**
- Cold Rolled: Ex – mill : Class : **2**
- Special Finishes

and classified by a combination of number and letter, for example: **2J**

This standard focuses on **Special Finishes. (BS EN 10088-2:2014)**

Description:

The number of additional finishing processes can be minimised by selecting, as the starting point, the closest mill finish (1 or 2) to obtain the desired end result. These applied finishes will have an impact on the surface appearance and the environmental performance of the material, and should be taken into consideration during the selection process.

Mechanically polished and **brushed** finishes involve the use of abrasive materials that effectively cut the surface of the steel. A wide choice of unidirectional finishes are available, but controlled by the original stainless surface, the type and texture of the belts and brushes employed, and the nature of the polishing process used.

To achieve a consistent surface quality, it is recommended to agree, with the contractor, a polishing specification which can include a surface roughness Ra, and inspection criteria. Reference samples should be prepared to the agreed standard and held by each party.

ASM (DEK) Applications:

The preferred DEK -ASM condition is:-

1J or 2J

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

SURFACE FINISH
STAINLESS STEEL _BRUSHED
DSF 3.2.13

Special Finishes. (BS EN 10088-2:2014)

SPECIAL FINISHES			
Finishing Routine	Class	Description	Typical (Ra) μm
Ground	1G or 2G	Based on either '1' or '2' ex-mill finishes. A unidirectional texture, not very reflective.	
Brushed or Dull polished	1J or 2J	Based on either '1' or '2' ex-mill finishes. Smoother than 'G' with a unidirectional texture, not very reflective.	0.2 -1.0
Satin polish	1K or 2K	Based on either '1' or '2' ex-mill finishes. Smoothest of the special non reflective finishes with corrosion resistance suitable for most external applications.	≤ 0.5
Bright polish	1P or 2P	Based on either '1' or '2' ex-mill finishes. Mechanically polished reflective finish. Can be a mirror finish.	≤ 0.1
Cold rolled, heat treated, passed on roughened rollers	2F	Uniform non-reflective matt surface, can be based on either 2B (Skin passed) or 2R (Bright annealed) mill finishes.	
Patterned	1M or 2M	One side only patterned plates: '1' ex-mill finish: Includes 'chequer.' '2' ex-mill finish: Includes fine textures.	
Corrugated	2W	Twin sided patterned plates: The rolled or pressed patterns are produced on male & female rolls	
Coloured	2L	Applied to flat (2R, 2P or 2K type finishes) or patterned (2M) sheet base finishes in a range of colours.	
Surface Coated	1S or 2S	Based on either '1' or '2' ex-mill finishes. One side only metallic coating : Tin, Aluminium or Titanium	

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