





Procedure 03-8083-P08

External Surface Finishing

PRECISION					
metal	works				



<u>ADTECH</u> manufacturing

Procedure 03-8083-P08 Date: 02/11/04

External Surface Finishing

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REVISION RECORD

Revision	Date of Issue	Description of Change	Prepared by	Reviewed by	Approved by
0	01/15/03	New	Elaine Steele	Tom Gilmore	Dave Rioux
1	01/12/04	Modified to address Rohwedder's comments	Gary Armstrong	Tom Gilmore	Dave Rioux
2	02/11/04	Modified to address Rohwedder's comments	Gary Armstrong	Tom Gilmore	Dave Rioux

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Purpose:

To establish the method for creating a uniform finish on exterior for the Prototype Vacuum Vessel Segment for the National Compact Stellarator Experiment.

Scope:

All exterior surfaces shall be mill finish with no gouges greater than 0.06".

Equipment:

• All equipment shall be nonferrous ceramics or nonmagnetic stainless steel and must be new or previously used on Inconel or austenitic stainless steel.

Orbital sander Sanding pads A-Tork wipe Methyl hydrate

Procedure:

- 1. Mill finish is acceptable for external finish
- 2. If there are any gouges greater than 0.06", they shall be repaired as per Procedure 03-8083-P013, Weld Repair.
- 3. Use orbital sander to sand smooth.
- 4. Wipe down surface using an A-Tork wipe and methyl hydrate.
- 5. Cover surface with tape and white plastic to protect from exposure.