



# **Procedure 03-8083-P08**

## **External Surface Finishing**





### **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.