



DCI, Inc.  
 600 North 54 Avenue  
 St. Cloud, MN 56303  
 Ph: (320) 252-8200  
 Fx: (320) 252-0866  
 www.dciinc.com

## DCI Surface Finish Definitions

Form F0074

Finish Designation Symbol	Ra Value (micro-inch) measured	Reference Description
MILL/AI	N/A	As-Is Material or Weld
CC	N/A	Color Cleaned Weld
BB	N/A	Bead Blasted Weld or Bead Blast Material-material As-Is
BBB	N/A	Best Bead Blasted Weld or Material-free of scratches, pits, gouges
HRAP	N/A	Hot Rolled Plate Material
2B	N/A	Cold Rolled Mill Material
155	155	Mechanical Polish-80 grit
125	125	Mechanical Polish-80/100 grit
95	95	Mechanical Polish-100 grit
70	70	Mechanical Polish-100/120 grit
50	50	Mechanical Polish-120 grit
40	40	Mechanical Polish-120/150 grit
32	32	Mechanical Polish-150/180 grit, 3A , #4
25	25	Mechanical Polish-180 grit, Biotech, BPE SF <sub>x3</sub> *
20	20	Mechanical Polish-240 grit, BPE SF <sub>x2</sub> *
15	15	Mechanical Polish-240/320 grit, BPE SF <sub>x1</sub> *
12	12	Mechanical Polish-320 grit, #7
20E	20	25-30 Mechanical Polish with final Electropolish, BPE SF <sub>x6</sub> *
15E	15	20-25 Mechanical Polish with final Electropolish, BPE SF <sub>x5</sub> *
12E	12	15-20 Mechanical Polish with final Electropolish, #8
10E	10	12-15 Mechanical Polish with final Electropolish, BPE SF <sub>x4</sub> *

All numerical designations are equivalent to Ra values. For material, these values represent mechanically polished, for welds, these values automatically designate mechanically ground smooth and flush.

\*BPE Finish Designations (x): Tubing-SFT#, Fittings-SFF#, Valves-SFV#, Vessels-SFVV#

### Measured Ra Values:

The above data has been taken from 316/316L material and is assumed to be verifiable data for 304 and other corrosion resistant alloys. These values are the average data of many tests. Therefore, slight deviations from the norm do exist. However, because of the number of tests performed, reasonable accuracy is assumed. Because of the many variables that create this data, deviations of +/- 10% or +/- 5 Ra would be considered well within good measurement parameters. The quality gauge is defined as the specified value on the prints being the 'target' value. The average of any four-profilometer readings must meet or be below this 'target' value with a maximum reading of 5 Ra above the 'target' allowed for any one reading.