

# Standard CVC Welding and Surface Finishing Specifications

The Cleveland Vibrator Company consistently strives to manufacture the highest quality vibratory equipment, both from a performance as well as an aesthetic point of view. To assure that the fabricating techniques we elect to employ on a specific piece of equipment are proper for our customer's applications, CVC has defined and described the various treatments normally used to surface finish a welded structure. At both the quotation stage and the final approval print stage, CVC will specify which type of weld finish is to be provided. If the proposed surface finish does not correspond to the requirements of the application, it will

be the customer's responsibility to properly advise CVC prior to approval of the final prints.

For the purpose of defining and describing welding finishes, we have made a distinction between two different areas on the equipment. **The Product Contact Surface** is that part of the equipment which is in direct contact with the product during its normal flow through the unit. **The Exterior Structural Surface** is that part of the equipment that does not come into direct contact with the product during its normal flow through the unit.

## TYPE 1

This finish is suitable for equipment where good appearance is required, or where F.D.A. food specifications are in effect. Material product contact surfaces to be fabricated from #304 Stainless Steel with all welds continuous, ground smooth and free from cracks, pits, and undercuts. Exterior structure will also be fabricated from #304 Stainless Steel, but welds will conform to Type 3 finish noted below. The exterior structure will be sand blasted clean and painted with F.D.A. approved white epoxy paint.

Final finish of the product contact surfaces will be obtained by either or both of these two methods: a) Glass Beading (0.0059 to 0.0098 diameter beads). b) 250 Grit Abrasive Paper with all markings in one direction.

The method of final finish will be determined by the Cleveland Vibrator Company.

The Welds will be inspected with a dye penetrant test after final finish is achieved.

## TYPE 2

This finish is suitable for equipment where explosive chemicals or pigments are being handled. Product contact surfaces to be fabricated from #304 Stainless Steel, #2-B mill finish. Exterior structure will be fabricated from mild steel, with welding finished to Type 3 exterior specification shown below. Exterior only will be finish painted with CVC standard Vista Green Enamel, unless otherwise noted. All product contact welds are to be continuous, ground smooth, free from cracks, pits and undercuts

Final finish of the product contact surfaces will be obtained by either or both of these methods:

- a) Glass Beading (0.0059 to 0.0098 diameter beads).
- b) 180 Grit Abrasive Paper with random markings.

Weld area will be finished only. This is typically within 1" of actual weld. Remaining area will be mill finish (#2-B). There will be a visual difference in appearance between welded and untouched, mill area.

Welds will be inspected with a dye penetrant test after final finish is achieved if requested by customer.

## TYPE 3

This finish is designed for the majority of industrial requirements. Product contact surfaces to be mild steel or stainless steel depending on requirements. Product contact welds are continuous, rough ground or sanded to remove any high spots or burrs. No other surface preparation will be provided. Surfaces may show discoloration due to welding.

Product contact welds will be visually inspected only.

All Type 3 exterior welds will be intermittent (stitched, not continuous) type.

Loose slag and residue will be removed from all exterior structural welds. No further weld or surface finish will be provided.

All Type 3 exterior surfaces will be mild steel and painted with CVC standard Vista Green Enamel, unless otherwise noted.

**Type 3 is the standard finish for CVC equipment unless otherwise stated.**



**THE CLEVELAND VIBRATOR COMPANY**

2828 CLINTON AVE CLEVELAND, OH 44113

(800) 221-3298 216- 241-7157 FAX: 216-241-3480

WWW.CLEVELANDVIBRATOR.COM

E-MAIL: CVC@CLEVELANDVIBRATOR.COM