







SURFACE FINISH SPECIFICATION

		Activities							Picture	Impeller selection and fixing method
	All surfaces sloped >30°	Pickling	welds grinding and smoothing out	Smoothing out without Ra measure	Smoothing out with measured Ra < 0,8	Smoothing out with measured Ra < 0,15	Electropolishing			
Finishing	Pickled		X							Bolts/Screws
	Smooth		X		X			X		
	Smooth Ra 0,8				X		X	X		
	Smooth Ra 0,8 all welded	X		X		X		X		Impeller able to pass through manhole welded on shaft: Sabre C preferred
	Mirror all welded	X		X				X		Bottom impeller able to pass through manhole welded on shaft: Sabre C preferred with screwed dead end connection and flat PTFE gasket Impeller larger than manhole: Hub welded to shaft, one or more blades to be welded within vessel. Impeller should be tipe F or G for their flat connection to hub