



PRODUCT FINISHING GRADES

SURFACE FINISHES AND WELD FINISH DESCRIPTIONS

UTILITY GRADE

Welds:

- » Internal and external: Intermittent, spot and full welds determined by the product.
- » Welds to be free of slag, soot and spatter. Burn marks are present.
- » Product contact surfaces may contain cracks and ledges.

Finish:

- » Internal and external surfaces will be wiped down.



CUSTOMARY GRADE (IMI Standard Finish)

Welds:

- » Internal and external: Intermittent, spot and full welds determined by the product.
- » Welds to be free of slag, soot, spatter and burn marks.
- » Product contact surfaces may contain cracks and ledges.

Finish:

- » Interior and exterior to be bead blasted on stainless steel surfaces. Mild steel will be painted exterior surfaces only. Magnets over 42x42x18 may be painted or wiped down and have weld burns removed.



FOOD GRADE

Welds:

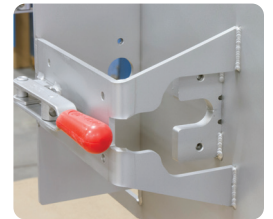
- » Interior product contact surfaces: Fully seam welded. Exterior product containment areas: Fully seam welded.
- » Exterior components, brackets and guards: Stitch welded.
- » Product contact surfaces shall contain no more than .030" undercut.
- » Welds to have no pits, pinholes or cracks

Finish:

- » Interior and exterior stainless steel finishes to be bead blasted. Magnets over 42"x42"x18" may be painted or wiped down and have weld burns removed.



**Food Grade - Ground welds available*



TOLL FREE **1.888.582.0821** imi@magnetics.com



SURFACE FINISHES AND WELD FINISH DESCRIPTIONS CONTINUED

SANITARY GRADE

Welds:

- » Interior product contact surfaces: fully seam welded, ground smooth and blended to 1/8 inch minimum radius.
- » Exterior product containment areas: fully seam welded, NOT ground.
- » Exterior components, brackets and guards: stitch welded & silicone where no weld is present.
- » Welds to be free of pits, pinholes and cracks.

Finish:

- » Interior product contact areas to be finished to a surface roughness of 32 Ra micro inches (0.8 microns). This is comparable to a No. 4 finish or using 180 grit. The finish will be a satin, non-mirror surface.
- » Exterior stainless steel to be tumbled or blast finished.
- » Interior bend radius 1/4 inch minimum.

Note:

Special welding and finishes available upon request.

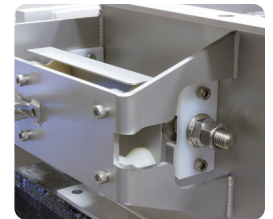
HACCP International Certified and USDA AMS Accepted Equipment.



The following items can be manufactured to conform to HACCP International's Food Safety and USDA/AMS standards:



- » Pneumatic Line Magnets
- » Drawer-in-Housing Magnets
- » Plate Magnets
- » Magnetic Tubes
- » Magnetic Grates



SURFACE ROUGHNESS / FINISH GRADE / GRIT

Micrometers (µm)	12.50			6.30			3.20			1.60			0.80			0.40			0.20			0.10			0.05	
Micro Inches (µin)	500			250			125			63			32			16			8			4			2	
Mill Finish																										
2B Mill Finish																										
#3 Finish																										
#4 Finish																										
#4 "Dairy 3A" Finish																										
#6 Finish																										
#7 Finish																										
Electropolish																										
80 Grit																										
100 Grit																										
150 Grit																										
180 Grit																										
240 Grit																										
320 Grit																										
IMI Bead Blast																										
IMI Sanitary																										

