



PHARMACEUTICAL

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STANDARD SHICKEL STAINLESS STEEL SURFACE FINISHES

Finish Name	Finish Description	R _a	Common Uses	Notes
Shickel Glass Bead	Dull, uniform	R _a 70 to R _a 110	Ladders, platforms, crossovers, some carts and conveyors and the like.	Bead blasting may tend to "peen" or warp stainless.
Shickel #4 (satin)	120 to 180 grit, grained, directional lay, "satin" look.	R _a 30 or less	Cabinetry, exterior of vessels, chutes, machines, carts	Can be blended by hand but not matched perfectly, sheet stock will vary some in appearance, as will finished product.
Shickel R _a 30-R	R _a 30 or less, random lay, may mix circular and linear patterns. Mechanically polished.	R _a 30 or less	Exterior surfaces where eye appeal is not a priority. Non-product contact surfaces of process equipment	The most economical way to achieve R _a 30 or less. May not have "eye appeal" depending upon lighting. Random R _a readings will be taken, none to exceed 30.
Shickel R _a 30-G	R _a 30 or less, applied with a directional grain (lay).	R _a 30 or less	Exterior surfaces where eye appeal is a priority.	More costly, uniform appearance. Direction of the LAY may be specified. Random R _a readings will be taken across the grain, none to exceed 30. Similar to #4 except applied after fabrication.
Shickel R _a 15-R	R _a 15 or less, random lay, mechanically polished.	R _a 15 or less	Product contact surfaces of process equipment.	Mechanically applied after fabrication.
Shickel R _a 15-RE	R _a 15 or less, random lay, mechanically polished, then electropolished	R _a 15 or less	Product contact surfaces of process equipment.	Often used on PRODUCT CONTACT SURFACES of process equipment. Electro Polishing is self passivating.
Shickel 2B	Smooth, semi-bright, mill finish, can not be reproduced by mechanical polishing	R _a 15 or less	Both product contact and non-product contact surfaces	Typical mill finish. Welds are often "ribbon polished" (Taped off and "cleaned" or "ground and polished"). Specify as desired.
Shickel Mirror	R _a 3 or less, highly polished mechanically	R _a 3 or less	Product contact, valves	Produced by successive polishing and buffing with finer and finer abrasives.

STANDARD SHICKEL WELD, PASSIVATION, AND IDENTIFICATION TREATMENTS

Finish Name	Finish Description	R _a	Common Uses	Notes
Welds cleaned	Discoloration removed from heat affected zone.	N/A	Ladders, platforms, crossovers, some carts and conveyors and the like.	Welds will not match surrounding surfaces. If special treatment is required, specify on drawings.
Welds cleaned and ribboned	Surfaces beside weld zone protected during cleaning	N/A	Same as above	Same as above
Welds ground and blended	Weld seams will be ground and blended to visually match surrounding surfaces (except 2B, which can not be mechanically reproduced)	Matches adjacent surfaces	Product contact OR where eye appeal is very important.	This type of weld treatment will be done per ASME BPE-1997 specification.
Welds ground and polished and ribboned	Weld seams ground and polished, appearance differs from surrounding surface	May not match adjacent	Same as above	Same as above. Gives pleasing eye appeal to fabrications made from 2B. (2B finish can not be mechanically reproduced)
Passivated	Controlled Citric Acid Bath. (Paste will be used on very large weldments)	No effect		Pharmaceutical weldments and machined parts will be passivated IF specified. Passivation certifications are supplied.
Electro etched	Various identification markings.	N/A	Part numbers, alignment marks, serials, logos	Durable identification markings electro etched onto your parts. Standard up to 5/8" tall letters or numbers. Custom markings up to 3" are available.

NOTE: Typical uses listed above are not to be interpreted as recommendations for specific applications. Customer must determine suitability of materials and finishes for their particular application.