



AEROSPACE STANDARD

AS4194™**REV. B**

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Superseding AS4194A

Sheet and Strip Surface Finish Nomenclature

RATIONALE

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NOTE: In many cases, the purchaser may represent a sub tier supplier and not the cognizant engineering organization.

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1. SCOPE

This SAE Aerospace Standard (AS) defines the nomenclature for surface finishes commonly used for sheet and strip in aerospace material specifications. It is applicable to steel and to iron, nickel, cobalt, and titanium base alloys.

2. REFERENCES

There are no referenced publications specified herein.

3. GENERAL

There is no other industry-wide agreement on nomenclature for surface finish. Terms such as No. 1 or 2D as have historically been used in numerous specifications were adapted from the steel industry and were based on method of manufacture rather than end product appearance. Since current technology can produce a particular finish or appearance in several acceptable ways, the definitions herein are based on end product visual appearance that depends on material and manufacturing method. Where more definitive standards are required, these should be negotiated between purchaser and supplier of the product.

4. CHARACTERISTICS OF SHEET AND STRIP FINISHES

4.1 Sheet Finish Appearance

4.1.1 2D Finish

The surface will vary from a dull matte appearance, similar to a pickled or vapor blasted finish, to a diffusely reflective appearance, similar to a fine ground appearance or finish produced on dull rolls.

4.1.2 2B Finish

The surface will vary from fairly reflective to very reflective. The appearance is usually produced by using polished rolls in the final cold reduction with no additional descaling.

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