



Emnor Mechanical Inc.
20 Depew Street
Hamilton, Ontario
L8L 7H8

CASTING QUALITY SPECIFICATION (1001)

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Casting quality shall equal and/or exceed the requirements of MSS-SP-55 (latest revision), Visual Inspection Guide for Steel Castings, Valves, Flanges, and Fittings. Noncompliance with these specifications and MSS-SP-55 will constitute rejection of the casting(s). The hydraulic surfaces shall be free of any visible surface voids, cracks, holes, scale, and gas porosity. All hydraulic surfaces shall be free of casting irregularities (humps, bumps, etc.) which may be determined to be detrimental to component performance. All hydraulic surfaces shall be free from hammer/cutter blemishes caused during removal of casting auxiliaries (gates, risers, etc.). All flashing must be removed from the edges of the castings and all holes deburred. If necessary (per Purchaser's inspection), the Vendor may be required to grind the hydraulic surface(s) to meet acceptable surface standards.

Parts must be clearly marked with Pattern number, Material Code, and foundry ID.

All castings must be supplied in accordance with the ASTM specification(s) as indicated on the PO.

Any weld repairs pre-machining or post-machining necessary to meet the above requirements will require a review and acceptance by the Purchaser.

Castings shall be supplied shot blasted and clean, sandblasting to be substituted only with Purchasers approval.

Dimensional accuracy to be less than 1% deviation for any dimension designated as critical by the Purchaser.

It is not the Purchaser's intent to induce abnormal casting quality requirements or to set forth those requirements adequately covered by applicable codes and standards. The Vendor shall furnish a high-quality product meeting and/or exceeding the requirements of this specification and the referenced standard.