NSF/ANSI Standard for Food Equipment –

Food equipment

5.2 Internal angles and corners, food zone

5.2.1 All internal angles or corners of less than 135° shall be smooth and have radius as set forth below:

5.2.1.1 At the intersection of two planes, which result in one angle or corner, the radius shall not be less than $\frac{1}{8}$ in (0.13 in, 3.2 mm).

5.2.1.2 At the intersection of three planes, which result in three angles or corners, the radii for two of the angles or corners shall not be less than $\frac{1}{8}$ in (0.13 in, 3.2 mm) and the radius of the third angle or corner shall not be less than $\frac{1}{4}$ in (0.25 in, 6.4 mm).

5.2.1.3 Lesser radii may be used only when necessary to ensure proper functioning of parts (such as sealing ring grooves for caps and lids or precision operating parts) provided they are easily cleanable.

5.2.2 For metals, solder or other fillet material shall not be used to effect the required minimum radius of an internal angle or corner.

5.2.3 For materials other than metal, the radii specified in 5.2.1.1 and 5.2.1.2 shall be effected using parent material or a material proven to be bonded and otherwise equal to or better than the parent material.

*Rationale: similar language is already used in many other NSF Food Equipment Standards.*