

# DME Micro-Finish Mold & Tool Finish Guide

## SPI Finish Designation/Preparation Guideline

## Approx. Resulting Ra

	<b>Micro inches</b>
A-1 (Grade #3 Diamond Buff)	0-1
A-2 (Grade #6 Diamond Buff)	1-2
A-3 (Grade #15 Diamond Buff)	2-3
B-1 (600 Grit Paper)	2-3
B-2 (400 Grit Paper)	4-5
B-3 (320 Grit Paper)	9-10
C-1 (600 Stone)	10-12
C-2 (400 Stone)	25-28
C-3 (320 Stone)	38-42
D-1 (Dry Blast Glass Bead #11; 8" distance at 100 psi; 5 secs)	10-12
D-2 (Dry Blast #240 Oxide; 5" distance at 100 psi; 6 secs)	26-32
D-3 (Dry Blast #24 Oxide; 6" distance at 100 psi; 5 secs)	190-230

### Correlation of these finishes to the DME Mold Finish Comparison Kit:

#### "High polish" finishes

- A1 is comparable to #1
- A2 is slightly finer than #2
- A3 has more imperfections than #2

#### "Paper finishes"

- B1 is slightly finer than #3
- B2 is slightly finer than #3
- B3 is comparable to #3

#### "Stone finishes"

- C1 is finer than #4
- C2 is slightly finer than #4
- C3 is comparable to #4

#### "Dry blasted" finishes

- D1 is finer than #5
- D2 is comparable to #5
- D3 is a little more coarse than #5



There are no current finishes that are comparable to the original #6 finish.

(Reference DME Equipment & Supplies Catalog)