

Diamond Mold Polishing & Finishing Specifications

Types of Finishes	Current SPI Finish Numbers	Description and Previous Finish Numbers	Roughness Comparison R.A.
Diamond	#3 Diamond Buff	A1 is comparable to	#1 0-1
	#6 Diamond Buff	A2 is slightly finer than	#2 1-2
	#15 Diamond Buff	A3 has more imperfections than	2-3
Paper	600 Grit	B1 is finer than	2-3
	400 Grit	B2 is slightly finer than	#3 4-5
	320 Grit	B3 is comparable to	9-10
Stone	600 Stone	C1 is finer than	10-12
	400 Stone	C2 is slightly finer than	#4 25-28
	320 Stone	C3 is comparable to	38-42
Dry Blasted	#11 Glass Bead	D1 is finer than	10-12
	240 Aluminum Oxide Blast	D2 is comparable to	#5 26-32
	#24 Aluminum Oxide Blast	D3 is a little more coarse than	190-230

The D1, D2 and D3 finishes can also be accomplished using EDM machining finishes that do not require post machining polishing for parts that desire a textured or satin appearance on the molded part.