

D-M-E Standard Mold Finish Comparison Kit

EXPANDED VERSION — 12 SAMPLES FINISHED TO SPI STANDARDS



CATALOG NUMBER
MFK-1200

- Eliminates errors or guesswork in achieving desired or specified finishes
- Saves time ... eliminates over-polishing
- Provides a visual and numerical standard for specifying mold/part finishes

Professionally finished to SPI standards, this kit is an invaluable tool for both selection of finishes required and comparison to work in progress. The visual and numerical standards are also helpful in communications between end user, molder and moldmaker. Each finish has been generated on a 1" diameter x 3/8 thick piece of

H-13 steel. Edges are chamfered and O.D. is knurled for safe, easy pick-up and handling. Finish numbers are stamped on the back of each sample for quick reference. A molded plaque in the kit's lid shows the part finishes that result from each mold finish.

FINISH TYPE	DESCRIPTION	ROUGHNESS AVERAGING (RA)* micro-inches range	COMMENTS
A-1	grade #3 diamond buff	0-1	<ul style="list-style-type: none"> • for mirror or optical finishes • most time consuming and costly finishes to achieve • steel grade important to results (D-M-E No. 3 or No. 5 steel recommended)
A-2	grade #6 diamond buff	1-2	
A-3	grade #15 diamond buff	2-3	
B-1	600 grit paper	2-3	<ul style="list-style-type: none"> • removes all tool and machining marks • provides good mold release • light reflecting finish on molded part, some sheen
B-2	400 grit paper	4-5	
B-3	320 grit paper	9-10	
C-1	600 stone	10-12	<ul style="list-style-type: none"> • removes all tool and machining marks • provides good mold release • mute finish on molded part, no sheen
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	<ul style="list-style-type: none"> • for decorative finishes • often used for diecast and thermoset tooling • helps hide shrink marks and other imperfections • dull, non-reflecting finish on molded or cast part
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	

* Note: Roughness average (RA) values are only a guideline and may vary dependent upon the types of stone or cloth available from different manufacturers.