

Surface Finish Guide



<input checked="" type="checkbox"/> Basic symbol			<input checked="" type="checkbox"/> Material removal through mechanical processing required			<input checked="" type="checkbox"/> Material removal not permitted			<input checked="" type="checkbox"/> Identical texture of all surfaces		
			<p> a A single surface finish requirement b Additional surface requirement c Production process (e.g. turned, ground, chrome-plated) d Symbol for direction of lay e Machining allowance (in mm) x Letter for simplified benchmarking, if space is limited </p>								
ISO 1302	Ra Lim	Ra Lim	APPLICATION								
N11	25	1000	Rough, low grade surface resulting from sand casting, torch or saw cutting, chipping or rough forging. Machine operations are not required because appearance is not objectionable. This surface, rarely specified, is suitable for unmachined clearance areas on rough construction items.								
N10	12.5	500	Rough, low grade surface resulting from heavy cuts and coarse feeds in milling, turning, shaping, boring and rough filing, disc grinding and snagging. It is suitable for clearance areas on machinery jigs and fixtures. Sand casting or rough forging produces this surface.								
N9	6.3	250	Coarse production surface, for unimportant clearance and cleanup operation, resulting from coarse surface grind, rough file, disc grind, rapid feeds in turning, milling, shaping, drilling, boring, grinding, etc., where tool marks are not objectionable. The natural surfaces of forgings, permanent mold castings, extrusions and rolled surfaces also produce this roughness. It can be produced economically and is used on parts where stress requirements, appearance, and conditions of operations and design permit.								
N8	3.2	125	The roughest surface recommended for parts subject to loads, vibration, and high stress. It is also permitted for bearing surfaces when motion is slow and loads light or infrequent. It is a medium commercial machine finish produced by relatively high speeds and fine feeds taking light cuts with sharp tools. It may be economically produced on lathes, milling machines, shapers, grinders, etc., or on permanent mold castings, die castings, extrusion, and rolled surfaces.								
N7	1.6	63	A good machine finish produced under controlled conditions using relatively high speeds and fine feeds to take light cuts with sharp cuttings. It may be specified for close fits and used for all stressed parts, except fast rotating shafts, axles, and parts subject to severe vibration or extreme tension. It is satisfactory for bearing surfaces when motion is slow and loads light or infrequent. It may also be obtained on extrusions, rolled surfaces, die castings and permanent mold casting when rigidly controlled.								
N6	0.8	32	A high-grade machine finish requiring close control when produced by lathes, shapers, milling machines, etc. but relatively easy to produced by centerless, cylindrical, or surface grinders. Also, extruding, rolling or die casting may produce a comparable surface when rigidly controlled. This surface may be specified in parts where stress concentration is present. It is used for bearings when motion is not continuous and loads are light. When finer finishes are specified, production costs rise rapidly; therefore, such finishes must be analyzed carefully.								
N5	0.4	16	A high quality surface produced by fine cylindrical grinding, emery buffing, coarse honing, or lapping. It is specified where smoothness is of primary importance, such as rapidly rotating shaft bearings, heavily loaded bearing and extreme tension members.								
N4	0.2	8	A fine surface produced by honing, lapping, or buffing. It is specified where packings and rings must slide across the direction of the surface grain, maintaining or withstanding pressures, or for interior honed surface of hydraulic cylinders. It may also be required in precision gauges and instrument work, or sensitive valve surfaces, or on rapidly rotating shafts and on bearings where lubrication is not dependable.								
N3	0.1	4	A costly refined surface produced by honing, lapping and buffing. It is specified only when the design requirements make it mandatory. It is required in instrument work, gauge work, and where packing and rings must slide across the direction of surface grain such as on chrome plated piston rods, etc. where lubrication is not dependable.								
N2	0.05	2	Costly refined surfaces produced by only the finest of modern honing, buffing, and superfinishing equipment. These surfaces may have a satin or highly polished appearance depending on the finishing operation and material. These surfaces are specified only when design requirements make it mandatory. They are specified on fine or sensitive instrument parts or other laboratory items, and certain gauge surfaces, such as precision gauge blocks.								
N1	0.025	1									

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Table of Contents Machinist Guide Surface Finish

1. Understanding the eBook Machinist Guide Surface Finish
 - The Rise of Digital Reading Machinist Guide Surface Finish
 - Advantages of eBooks Over Traditional Books
2. Identifying Machinist Guide Surface Finish
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Machinist Guide Surface Finish
 - User-Friendly Interface
4. Exploring eBook Recommendations from Machinist Guide Surface Finish

- Personalized Recommendations
 - Machinist Guide Surface Finish User Reviews and Ratings
 - Machinist Guide Surface Finish and Bestseller Lists
5. Accessing Machinist Guide Surface Finish Free and Paid eBooks
 - Machinist Guide Surface Finish Public Domain eBooks
 - Machinist Guide Surface Finish eBook Subscription Services
 - Machinist Guide Surface Finish Budget-Friendly Options
 6. Navigating Machinist Guide Surface Finish eBook Formats
 - ePub, PDF, MOBI, and More
 - Machinist Guide Surface Finish Compatibility with Devices
 - Machinist Guide Surface Finish Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Machinist Guide Surface Finish
 - Highlighting and Note-Taking Machinist Guide Surface Finish
 - Interactive Elements Machinist Guide Surface Finish
 8. Staying Engaged with Machinist Guide Surface Finish
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Machinist Guide Surface Finish
 9. Balancing eBooks and Physical Books Machinist Guide Surface Finish
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Machinist Guide Surface Finish
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Machinist Guide Surface Finish
 - Setting Reading Goals Machinist Guide Surface Finish
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Machinist Guide Surface Finish

- Fact-Checking eBook Content of Machinist Guide Surface Finish
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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