

SURFACE ROUGHNESS BY DIFFERENT PROCESSING METHODS

Arithmetical mean roughness Ra		0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25	50	100			
Former designations of surface roughness	Max. height Rmax.	0.1 —S	0.2 —S	0.4 —S	0.8 —S	1.6 —S	3.2 —S	6.3 —S	12.5 —S	25 —S	50 —S	100 —S	200 —S	400 —S			
	Standard values of standard length (mm)	0.25				0.8				2.5		8		25			
	Triangular indication	▽▽▽▽				▽▽▽				▽▽		▽		—			
Working method	Forging									Precision							
	Casting									Precision							
	Die casting																
	Hot rolling																
	Cold rolling																
	Drawing																
	Extruding																
	Tumbling																
	Sandblasting																
	Rolling																
	Face cutter grinding									Precision							
	Planing																
	Carving(Slotting)																
	Cutter grinding									Precision							
	Precision boring																
	Filing									Precision							
	Round grinding									Precision		Fine		Medium		Rough	
	Boring									Precision							
	Drilling																
	Reaming									Precision							
	Broach grinding									Precision							
	Shaving																
	Grinding									Precision		Fine		Medium		Rough	
	Hone finishing									Precision							
	Super finishing									Precision							
	Buffing									Precision							
	Paper finishing									Precision							
	Lapping									Precision							
	Liquid honing									Precision							
	Burnishing																
Surface rolling																	
Electric discharge carving																	
Wire cut electric spark																	
Chemical polishing									Precision								
Electrolytic abrasion									Precision								