

Mold Finish Comparison Kit

EXPANDED VERSION – 12 SAMPLES FINISHED TO SPI STANDARDS

- 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 $\frac{3}{8}$ "-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.



ITEM NUMBER

MFK-1200

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
B-2	400 grit paper	4-5	<ul style="list-style-type: none"> • provides good mold release
B-3	320 grit paper	9-10	<ul style="list-style-type: none"> • light reflecting finish on molded part, some sheen
C-1	600 stone	10-12	<ul style="list-style-type: none"> • removes all tool and machining marks
C-2	400 stone	25-28	<ul style="list-style-type: none"> • provides good mold release
C-3	320 stone	38-42	<ul style="list-style-type: none"> • mute finish on molded part, no sheen
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
D-2	dry blast # 240 oxide (5" distance at 100 psi; 6 secs.)	26-32	<ul style="list-style-type: none"> • often used for diecast and thermoset tooling • helps hide shrink marks and other imperfections
D-3	dry blast # 24 oxide (6" distance at 100 psi; 5 secs.)	190-230	<ul style="list-style-type: none"> • dull, non-reflecting finish on molded or cast part