

Superficial Roughness

Superficial Roughness in accordance with ISO R 468, DIN 4769 and VSM 10321					
		CLA	Ra"	Rz"	Rt"
Machined	N1	1	0.025	0.22 – 0.30	0.24 – 0.40
	N2	2	0.050	0.45 – 0.60	0.49 – 0.90
	N3	4	0.1	0.8 – 1.1	0.85 – 1.45
	N4	8	0.2	1.0 – 1.8	1.10 – 2.40
	N5	16	0.4	1.6 – 2.8	1.75 – 3.60
	N6	32	0.8	3.0 – 4.8	3.2 – 6.0
Investment Casting	N7	63	1.6	5.9 – 8.0	6.3 – 10.0
	N8	125	3.2	12 - 16	13.0 – 19.5
	N9	250	6.3	23 - 32	25 - 38
Sand Casting	N10	500	12.5	46 - 57	48 - 68
	N11	1000	25	90 - 110	95 - 130
	N12	2000	50	180 - 220	190 - 250
	N13	4000	100	360 - 430	380 - 500
Surface roughness of investment castings is between N7 and N9 and it depends on the part material, size and weight.					