SURFACE FINISH

INJECTION MOULDED COMPONENTS

DSF 3.2.11

Description:

The Society of the Plastics Industry, **SPI**, establishes standards for the United States plastics industry. These standards define the grades of mould finish, from mirror-perfect to dull, that can be applied to the moulding surface of a tool.

SPI: Society of the Plastics Industry, founded in 1937, is a trade association representing the US plastics industry.

SPE: Society of Plastics Engineers, founded in 1942, is an international organisation.

Definition:

MOULD TOOL FINISH					
FINISH TYPE	**SPI**	**SPE**	**METHOD**	**DRAWING CALL-OUT**	**COST**
High Polish	A-1	#1	Grade #3 Diamond Buff		**HIGH**
	A-2		Grade #6 Diamond Buff		
	A-3	#2	Grade #15 Diamond Buff		
Paper	B-1		600 Grit Paper		
	B-2		400 Grit Paper		
	B-3	**#3**	320 Grit Paper	**DSF 3.2.11**	
Stone	C-1		600 Stone		
	C-2		400 Stone		
	C-3		320 Stone		
	***	#4	280 Stone		
Dry Blasted	D-1		Dry Blast Glass Bead #11		
	D-2	#5	Dry Blast #240 Oxide		**LOW**
	D-3	#6	Dry Blast #24 Oxide		

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ASM (DEK) Acceptable Criteria:

This instruction applies to any ASM (DEK) designed component used on a machine, or supplied as a spare by the vendor; and should be read in conjunction with :-

(DSF 3.2.10)

''Acceptable Cosmetic Criteria for Injection Moulded Components'

Other aesthetic finishes are available, for example 'spark' (EDM) finish, these must be specified & controlled by a separate Engineering Data Sheet.