

Surface Finish Guide



<div> <div>✓ Basic symbol</div> <div>✓ Material removal through mechanical processing required</div> <div>✓ Material removal not permitted</div> <div>✓ Identical texture of all surfaces</div> </div>			
			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
ISO 1302	Ra μm	Ra μin	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 ✓	

Surface Finish Comparison Guide

Yijin Wang

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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Table of Contents Surface Finish Comparison Guide

1. Understanding the eBook Surface Finish Comparison Guide
 - The Rise of Digital Reading Surface Finish Comparison Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Surface Finish Comparison Guide
 - 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 Surface Finish Comparison Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Surface Finish Comparison Guide
 - Personalized Recommendations
 - Surface Finish Comparison Guide User Reviews and Ratings
 - Surface Finish Comparison Guide and Bestseller Lists

5. Accessing Surface Finish Comparison Guide Free and Paid eBooks
 - Surface Finish Comparison Guide Public Domain eBooks
 - Surface Finish Comparison Guide eBook Subscription Services
 - Surface Finish Comparison Guide Budget-Friendly Options
6. Navigating Surface Finish Comparison Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Surface Finish Comparison Guide Compatibility with Devices
 - Surface Finish Comparison Guide Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Surface Finish Comparison Guide
 - Highlighting and Note-Taking Surface Finish Comparison Guide
 - Interactive Elements Surface Finish Comparison Guide
8. Staying Engaged with Surface Finish Comparison Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Surface Finish Comparison Guide
9. Balancing eBooks and Physical Books Surface Finish Comparison Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Surface Finish Comparison Guide
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Surface Finish Comparison Guide
 - Setting Reading Goals Surface Finish Comparison Guide
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Surface Finish Comparison Guide
 - Fact-Checking eBook Content of Surface Finish Comparison Guide
 - 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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web below is a list of the essentials you need to have ready should you have to leave your house in an emergency and can only grab a bug out bag before you go it provides you with the most basic of provisions to get you through 72 hours away from home

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web this checklist s focus is on the bug out bag a backpack or duffel bag or even a suitcase that is packed a ready to go when an emergency hits however if you have the means for say a bug out vehicle making the weight and space issue of a single pack less of a priority an additional wish list of supplies and gear is included below the bug out bag basics

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