

Overview SPI standard for polishing

Philips standard	SPI (old)	SPI (new)	Description	Ra in μm (DIN)	Comments
0 - UN - D 249	1	A-1	Diamond buff grade 3	0 - 0.025	For mirror or optical finishes. Most time consuming. Steel grade important to results
1 - UN - D 249		A-2	Diamond buff grade 6	0.025 - 0.05	
	2	A-3	Diamond buff grade 15	0.05 - 0.076	
2 - UN - D 249		B-1	600 grit paper	0.05 - 0.076	Removes all tool and machining marks. Provides good mould release. Light reflecting finish on moulded part, some sheen.
		B-2	400 grit paper	0.10 - 0.127	
3 - UN - D 249	3	B-3	320 grit paper	0.23 - 0.25	
		C-1	600 stone	0.25 - 0.30	Removes all tool and machining marks. Provides good mould release. Mute finish on moulded part, no sheen.
		C-2	400 stone	0.64 - 0.71	
		C-3	320 stone	0.97 - 1.07	
4 - UN - D 249				0.40	Technical Smooth, polishing only needed for proper moulding function
	4				No more in use.
		D-1	Dry blast glass bead 11, 200 distance at 0.7 Mpa; 5 sec	0.25 - 0.30	For decorative finishes. Often used for diecast and thermoset cooling. Helps hide shrink marks and other imperfections. Dull, non reflecting finish on moulded or cast part.
	5	D-2	Dry blast 240 oxyde, 125 distance at 0.7 Mpa; 5 sec	0.66 - 0.81	
		D-3	Dry blast 240 oxyde, 150 distance at 0.7 Mpa; 5 sec	4.83 - 5.84	