

## SPI Surface Finishes

Finsh	SPI Standard	Surface Roughness(Ra $\mu\text{m}$ )	Description	Applications	Suitable Mold Steel	Hardness	Suitable Materials	Note
Glossy	A1	0.012-0.025	Grade #3, 6000 Grit Diamond Buff	High polish parts	420SS, S136H, NAK80	55+HRC	Acrylic, PC	For mirror or optical surface finishes. Extremely high requirements for steel grade
	A2	0.025-0.05	Grade #6, 3000 Grit Diamond Buff	High polish parts	420SS, S136H, NAK80	52+HRC	Acrylic, PC	
	A3	0.05-0.10	Grade #15, 1200 Grit Diamond Buff	High low polish parts	S136	300HB	ABS, Acrylic, PS, Nylon, PC	
Semi-Glossy	B1	0.05-0.10	600 Grit Paper polish	Medium polish parts	718H, 2738H		ABS, Acrylic, PP, PS, HDPE, Nylon, PC	Removes processing marks, helps stripping, and is mostly used on the internal surface of molded parts.
	B2	0.10- 0.15	400 Grit Paper polish	Medium polish parts	718H, 2738H		ABS, Acrylic, PP, PS, HDPE, Nylon, PC	
	B3	0.28-0.32	320 Grit Paper polish	Medium low polish parts	718H, 2738H		ABS, Acrylic, PP, PS, HDPE, Nylon	
Matte	C1	0.35-0.40	600 Stone polish	Low polish parts	P20, 718H		ABS, Acrylic, PP, PS, HDPE, Nylon, TPU	Remove mold processing marks. The surface of the molded parts is matte, no sheen.
	C2	0.45-0.55	400 Stone polish	Low polish parts	P20, 718H		ABS, Acrylic, PP, PS, HDPE, Nylon, TPU	
	C3	0.63-0.70	320 Stone polish	Low polish parts	P20, 718H		ABS, Acrylic, PP, PS, HDPE, Nylon, TPU	
Textured	D1	0.80-1.00	Dry Blast Glass Bead	Satin finish	P20, 718H		ABS, PP, PS, HDPE, Nylon, PC, TPU	Resulting in a textured surface, some roughness can hide shrinkage marks and other molding defects. injection molded parts have a dull, non-reflective surface.
	D2	1.00-2.80	Dry Blast #240 Oxide	Dull finish	P20, 718H		ABS, PP, PS, HDPE, Nylon, TPU	
	D3	3.20-18	Dry Blast #24 Oxide	Dull finish	P20, 718H		ABS, PP, PS, HDPE, Nylon, TPU	