

VDI 3400 Mold Texture



NO.	Description	Surface Roughness Ra (µm)	Rz (µm)	ISO 1302/TC 213	Applications	ABS Min Draft (°)	PC Min Draft (°)	Nylon Min Draft (°)	
# 0		0.1		N3					
# 1		0.112							
# 2		0.126							
# 3		0.14							
# 4		0.16							
# 5		0.18							
# 6		0.2		N4					
# 7		0.22							
# 8		0.25							
# 9		0.29							
# 10		0.32							
# 11		0.35							
# 12	600 Stone	0.4	1.5	N5	Low polish parts	0.5°	1°	0°	
# 13		0.45							
# 14		0.5							
# 15	400 Stone	0.56	2.4			Low polish parts	0.5°	1°	0.5°
# 16		0.63							
# 17		0.7							
# 18	Dry Blast Glass Bead	0.8	3.3	N6	Satin finish	0.5°	1°	0.5°	
# 19		0.9							
# 20		1							
# 21	Dry Blast # 240 Oxide	1.12	4.7			Dull finish	0.5°	1°	0.5°
# 22		1.26							
# 23		1.4							
# 24	Dry Blast # 240 Oxide	1.6	6.5	N7	Dull finish	1°	1.5°	0.5°	
# 25		1.8							
# 26		2							
# 27	Dry Blast # 240 Oxide	2.2	10.5			Dull finish	1.5°	2°	1°
# 28		2.5							
# 29		2.8							
# 30	Dry Blast # 24 Oxide	3.2	12.5	N8	Dull finish	2°	2°	1.5°	
# 31		3.5							
# 32		4							
# 33	Dry Blast # 24 Oxide	4.5	17.5			Dull finish	2.5°	3°	2°
# 34		5							
# 35		5.6							
# 36	Dry Blast # 24 Oxide	6.3	24	N9	Dull finish	3°	4°	2.5°	
# 37		7							
# 38		8							
# 39	Dry Blast # 24 Oxide	9	34			Dull finish	4°	5°	3°
# 40		10							
# 41		11.2							
# 42	Dry Blast # 24 Oxide	12.6	48	N10	Dull finish	5°	6°	4°	
# 43		14							
# 44		16							
# 45	Dry Blast # 24 Oxide	18	69			Dull finish	6°	7°	5°