



*Surface Finish Values  
For Electroplated (Single Layer)  
Diamond and CBN Tooling*

Tech Sheet # 11

**SURFACE FINISH**

Use the table as a starting point in selecting the proper mesh size for your diamond or CBN electroplated plated wheel. Other variables such as type of material being ground, material removal rate, machine condition, infeed and the use of coolant will all influence eventual part finish.

Diamond or CBN Mesh Size	RMS Finish In Micro Inch	Ra Finish In Microns
100/120	64 - 90	1.5 - 2.09
140/170	32 - 48	.73 - 1.09
170/200	24 - 32	.55 - .73
200/230	20 - 24	.45 - .55
230/270	14 - 16	.32 - .36
325/400	13 - 14	.29 - .32
400/500	12 - 13	.27 - .29

RMS—is defined as the " root mean square " of the profile height deviations from the mean line of the surface. Lower values indicate a smoother finish. The above table expresses the RMS values in micro inches.

RA is the arithmetic average of the mean deviation of the surface valleys and peaks. Again, the lower the value, the smoother the finish. The RA values listed here are in microns.

**Graff DIAMOND PRODUCTS LIMITED**

35 Hale Road Brampton Ontario Phone: (905) 457 8132 email: [info@graffdiamond.com](mailto:info@graffdiamond.com)  
[www.graffdiamond.com](http://www.graffdiamond.com)