



Web: <http://www.grefeemold.com> Email: info@grefeemold.com



Texture



Texture blend polish.



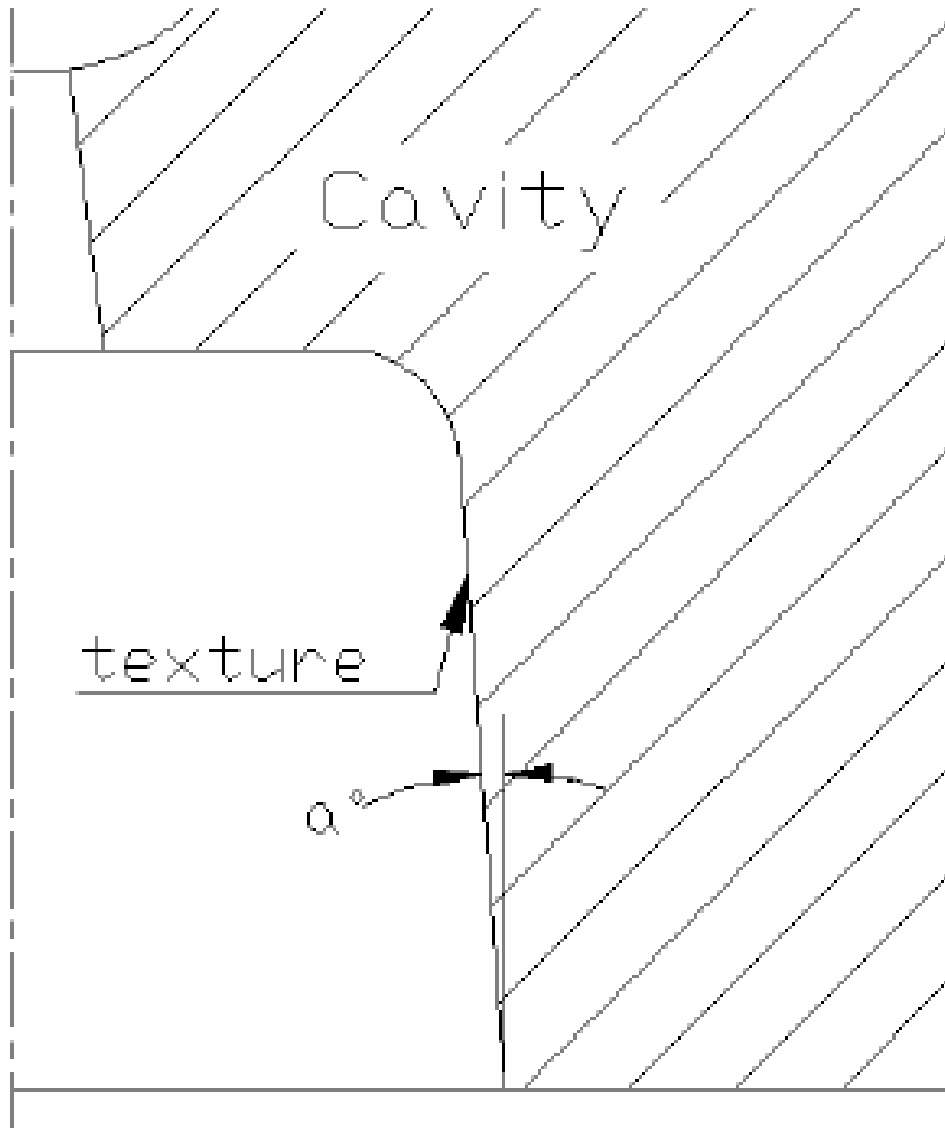
High glossy

TYPE OF FINISHES	CURRENT SPI FINISH NUMBERS		DESCRIPTION & PREVIOUS FINISH NUMBERS		ROUGHNESS COMPARISON R.A.
DIAMOND	#3 Diamond Buff	A1	is comparable to	#1	0-1
	#6 Diamond Buff	A2	is slightly finer than	#2	1-2
	#15 Diamond Buff	A3	has more imperfections than		2-3
PAPER	600 Grit	B1	is finer than	#3	2-3
	400 Grit	B2	is slightly finer than		4-5
	320 Grit	B3	is comparable to		9-10
STONE	600 Stone	C1	is finer than	#4	10-12
	400 Stone	C2	is slightly finer than		25-28
	320 Stone	C3	is comparable to		38-42
DRY BLASTED	#11 Glass Bead	D1	is finer than	#5	10-12
	240 Aluminum Oxide Blast	D2	is comparable to		26-32
	#24 Aluminum Oxide Blast	D3	is a little more coarse than		190-230

SPI finish



When design the product , the draft angle of the parts should be considered. Here provide the design guide for reference.



MoldTech 蚀纹制作参考资料(Technical data)

Mold-Tech A			Mold-Tech B		
Ptn. #	Depth(metric)	Mini Draft Angle	Ptn. #	Depth(metric)	Mini Draft Angle
MT-11000	0.01	1°	MT-11200	0.0762	4.5°
MT-11010	0.0254	1.5°	MT-11205	0.0635	4°
MT-11020	0.0381	2.5°	MT-11210	0.0889	5.5°
MT-11030	0.0508	3°	MT-11215	0.1143	6.5°
MT-11040	0.0762	4.5°	MT-11220	0.127	7.5°
MT-11050	0.1143	6.5°	MT-11225	0.1143	6.5°
MT-11060	0.0762	4.5°	MT-11230	0.0635	4°
MT-11070	0.0762	4.5°	MT-11235	0.1016	6°
MT-11080	0.0508	3°	MT-11240	0.0381	2.5°
MT-11090	0.0889	5.5°	MT-11245	0.0508	3°
MT-11100	0.1524	9°	MT-11250	0.0635	4°
MT-11110	0.0635	4°	MT-11255	0.0508	3°
MT-11120	0.0508	3°	MT-11260	0.1016	6°
MT-11130	0.0635	4°	MT-11265	0.1778	7°
MT-11140	0.0635	4°	MT-11270	0.1016	6°
MT-11150	0.06985	4°	MT-11275	0.0889	5°
MT-11160	0.1016	6°	MT-11280	0.1397	8°

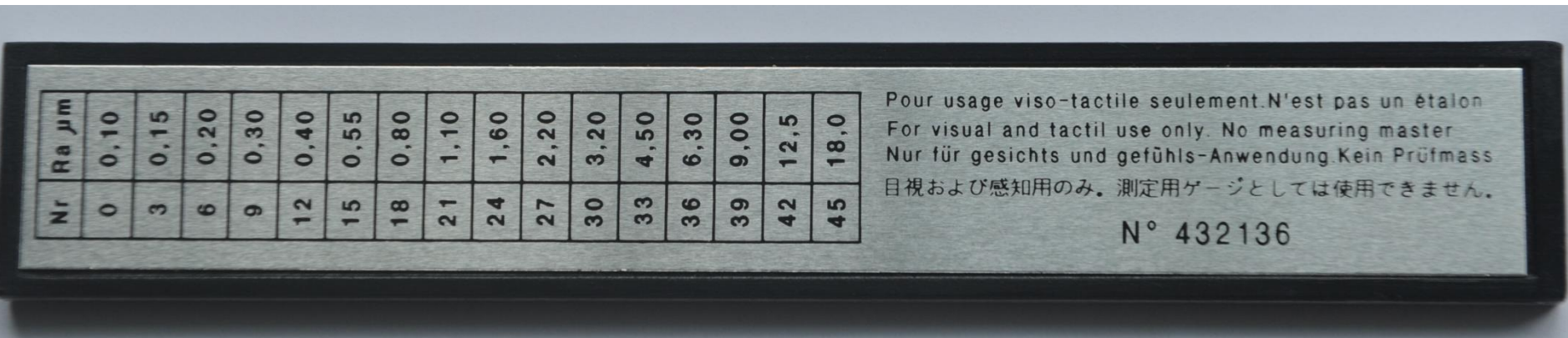
Suggest add more 0.5 degree draft for safety.

Mold-Tech C			Mold-Tech D		
Ptn. #	Depth(inch)	Mini Draft Angle	Ptn. #	Depth(Inch)	Mini Draft Angle
MT-11300	0.0635	3.5°	MT-11400	0.0508	3°
MT-11305	0.127	7.5°	MT-11405	0.0635	4°
MT-11310	0.127	7.5°	MT-11410	0.0889	5.5°
MT-11315	0.0254	1.5°	MT-11415	0.0508	3°
MT-11320	0.0635	4°	MT-11420	0.0635	4°
MT-11325	0.0762	4.5°	MT-11425	0.0889	5.5°
MT-11330	0.0508	3°	MT-11430	0.1778	10°
MT-11335	0.0508	3°	MT-11435	0.254	15°
MT-11340	0.0762	4.5°	MT-11440	0.0127	1.5°
MT-11345	0.0762	4.5°	MT-11445	0.0381	2.5°

Suggest add more 0.5 degree draft for safety.



VDI texture



Charm Nc VDI 3400 Rei	Ra(um)	Rz(um)	Draft angle α°		
			PBT NLG	PC	ABS
12	0.040	1.5	0.5	1.0	0.5
15	0.56	2.4	0.5	1.0	0.5
18	0.80	3.3	0.5	1.0	0.5
21	1.12	4.7	0.5	1.0	0.5
24	1.60	6.5	0.5	1.5	1.0
27	2.24	10.5	1.0	2.0	1.5
30	3.15	12.5	1.5	2.0	2.0
33	4.50	17.5	2.0	3.0	2.5
36	6.30	24.0	2.5	4.0	3.0
39	9.00	34.0	3.0	5.0	4.0
42	12.5	48.0	4.0	6.0	5.0
45	18.00	69.0	5.0	7.0	6.0

Suggest add more 0.5 degree draft for safety.