

Machining Deviation as per class to ISO 2768

D/m	Machining Deviations as per ISO 2768 m		SURFACE ROUGHNESS SYMBOLS / VALUES IN µm Ra		FEED & GRD	
	Over	Upto & Inc.	Symbol	Value	N12	N15
6	30	120	N12	50	N3	N6
30	120	400	N15	25	N6	N12
1000	400	1000	N3	16	N12	N18
2000	1000	2000	N6	10	N18	N25
4000	2000	4000	N12	6.3	N25	N32
			N18	4	N32	N40
			N25	3	N40	N50
			N32	2	N50	N63
			N40	1.6	N63	N80
			N50	1	N80	N100
			N63	0.8	N100	N125
			N80	0.63	N125	N160
			N100	0.5	N160	N200
			N125	0.4	N200	N250
			N160	0.3	N250	N315
			N200	0.25	N315	N400
			N250	0.2	N400	N500
			N315	0.15	N500	N630
			N400	0.125	N630	N800
			N500	0.1	N800	N1000
			N630	0.08	N1000	N1250
			N800	0.07	N1250	N1600
			N1000	0.063	N1600	N2000
			N1250	0.05	N2000	N2500
			N1600	0.04	N2500	N3150
			N2000	0.035	N3150	N4000
			N2500	0.03	N4000	N5000
			N3150	0.025	N5000	N6300
			N4000	0.02	N6300	N8000
			N5000	0.018	N8000	N10000
			N6300	0.016	N10000	N12500
			N8000	0.015	N12500	N16000
			N10000	0.014	N16000	N20000
			N12500	0.013	N20000	N25000
			N16000	0.012	N25000	N31500
			N20000	0.011	N31500	N40000
			N25000	0.01	N40000	N50000
			N31500	0.009	N50000	N63000
			N40000	0.008	N63000	N80000
			N50000	0.0075	N80000	N100000
			N63000	0.007	N100000	N125000
			N80000	0.0065	N125000	N160000
			N100000	0.006	N160000	N200000
			N125000	0.0055	N200000	N250000
			N160000	0.005	N250000	N315000
			N200000	0.0045	N315000	N400000
			N250000	0.004	N400000	N500000
			N315000	0.0035	N500000	N630000
			N400000	0.003	N630000	N800000
			N500000	0.0025	N800000	N1000000
			N630000	0.002	N1000000	N1250000
			N800000	0.0015	N1250000	N1600000
			N1000000	0.001	N1600000	N2000000
			N1250000	0.0008	N2000000	N2500000
			N1600000	0.0007	N2500000	N3150000
			N2000000	0.0006	N3150000	N4000000
			N2500000	0.0005	N4000000	N5000000
			N3150000	0.0004	N5000000	N6300000
			N4000000	0.00035	N6300000	N8000000
			N5000000	0.0003	N8000000	N10000000
			N6300000	0.00025	N10000000	N12500000
			N8000000	0.0002	N12500000	N16000000
			N10000000	0.00015	N16000000	N20000000
			N12500000	0.00012	N20000000	N25000000
			N16000000	0.0001	N25000000	N31500000
			N20000000	0.00008	N31500000	N40000000
			N25000000	0.00007	N40000000	N50000000
			N31500000	0.00006	N50000000	N63000000
			N40000000	0.00005	N63000000	N80000000
			N50000000	0.00004	N80000000	N100000000
			N63000000	0.000035	N100000000	N125000000
			N80000000	0.00003	N125000000	N160000000
			N100000000	0.000025	N160000000	N200000000
			N125000000	0.00002	N200000000	N250000000
			N160000000	0.000015	N250000000	N315000000
			N200000000	0.000012	N315000000	N400000000
			N250000000	0.00001	N400000000	N500000000
			N315000000	0.000008	N500000000	N630000000
			N400000000	0.000007	N630000000	N800000000
			N500000000	0.000006	N800000000	N1000000000
			N630000000	0.000005	N1000000000	N1250000000
			N800000000	0.000004	N1250000000	N1600000000
			N1000000000	0.0000035	N1600000000	N2000000000
			N1250000000	0.000003	N2000000000	N2500000000
			N1600000000	0.0000025	N2500000000	N3150000000
			N2000000000	0.000002	N3150000000	N4000000000
			N2500000000	0.0000015	N4000000000	N5000000000
			N3150000000	0.0000012	N5000000000	N6300000000
			N4000000000	0.000001	N6300000000	N8000000000
			N5000000000	0.0000008	N8000000000	N10000000000
			N6300000000	0.0000007	N10000000000	N12500000000
			N8000000000	0.0000006	N12500000000	N16000000000
			N10000000000	0.0000005	N16000000000	N20000000000
			N12500000000	0.0000004	N20000000000	N25000000000
			N16000000000	0.00000035	N25000000000	N31500000000
			N20000000000	0.0000003	N31500000000	N40000000000
			N25000000000	0.00000025	N40000000000	N50000000000
			N31500000000	0.0000002	N50000000000	N63000000000
			N40000000000	0.00000015	N63000000000	N80000000000
			N50000000000	0.00000012	N80000000000	N100000000000
			N63000000000	0.0000001	N100000000000	N125000000000
			N80000000000	0.00000008	N125000000000	N160000000000
			N100000000000	0.00000007	N160000000000	N200000000000
			N125000000000	0.00000006	N200000000000	N250000000000
			N160000000000	0.00000005	N250000000000	N315000000000
			N200000000000	0.00000004	N315000000000	N400000000000
			N250000000000	0.000000035	N400000000000	N500000000000
			N315000000000	0.00000003	N500000000000	N630000000000
			N400000000000	0.000000025	N630000000000	N800000000000
			N500000000000	0.00000002	N800000000000	N1000000000000
			N630000000000	0.000000015	N1000000000000	N1250000000000
			N800000000000	0.000000012	N1250000000000	N1600000000000
			N1000000000000	0.00000001	N1600000000000	N2000000000000
			N1250000000000	0.000000008	N2000000000000	N2500000000000
			N1600000000000	0.000000007	N2500000000000	N3150000000000
			N2000000000000	0.000000006	N3150000000000	N4000000000000
			N2500000000000	0.000000005	N4000000000000	N5000000000000
			N3150000000000	0.000000004	N5000000000000	N6300000000000
			N4000000000000	0.0000000035	N6300000000000	N8000000000000
			N5000000000000	0.000000003	N8000000000000	N10000000000000
			N6300000000000	0.0000000025	N10000000000000	N12500000000000
			N8000000000000	0.000000002	N12500000000000	N16000000000000
			N10000000000000	0.0000000015	N16000000000000	N20000000000000
			N12500000000000	0.0000000012	N20000000000000	N25000000000000
			N16000000000000	0.000000001	N25000000000000	N31500000000000
			N20000000000000	0.0000000008	N31500000000000	N40000000000000
			N25000000000000	0.0000000007	N40000000000000	N50000000000000
			N31500000000000	0.0000000006	N50000000000000	N63000000000000
			N40000000000000	0.0000000005	N63000000000000	N80000000000000
			N50000000000000	0.0000000004	N80000000000000	N100000000000000
			N63000000000000	0.00000000035	N100000000000000	N125000000000000
			N80000000000000	0.0000000003	N125000000000000	N160000000000000
			N100000000000000	0.00000000025	N160000000000000	N200000000000000
			N125000000000000	0.0000000002	N200000000000000	N250000000000000
			N160000000000000	0.00000000015	N250000000000000	N315000000000000
			N200000000000000	0.00000000012	N315000000000000	N400000000000000
			N250000000000000	0.0000000001	N400000000000000	N500000000000000
			N315000000000000	0.00000000008	N500000000000000	N630000000000000
			N400000000000000	0.00000000007	N630000000000000	N800000000000000
			N500000000000000	0.00000000006	N800000000000000	N1000000000000000
			N630000000000000	0.00000000005	N1000000000000000	N1250000000000000
			N800000000000000	0.00000000004	N1250000000000000	N1600000000000000
			N1000000000000000	0.000000000035	N1600000000000000	N2000000000000000
			N1250000000000000	0.00000000003	N2000000000000000	N2500000000000000
			N1600000000000000	0.000000000025	N2500000000000000	N3150000000000000
			N2000000000000000	0.00000000002	N3150000000000000	N4000000000000000
			N2500000000000000	0.000000000015	N4000000000000000	N5000000000000000
			N3150000000000000	0.000000000012	N5000000000000000	N6300000000000000
			N4000000000000000	0.00000000001	N6300000000000000	N8000000000000000
			N5000000000000000	0.000000000008	N80000000000	