



Specifying surface properties on drawings

RON 101
edition 9637
page 1



The latest respective edition of DIN ISO 1302 shall apply when specifying surface properties and machining allowances on drawings.



General specification of surface finish:



Unless specified otherwise on the drawing or in other standards (e.g. RON 305) the following shall apply:

cut metal machined surfaces :6.3 Ra
(except for drilled mounting holes12.5 Ra)

light metal - diecast surfaces:..... 6.3 Ra
(except for combustion chamber surfaces of cylinder heads - 3.2 Ra)

light metal - permanent mold casting surfaces:25 Ra
(except for combustion chamber surfaces of cylinder heads - 6.3 Ra)

sand casting - surfaces:125 Ra

drop forging surfaces:.....25 Ra

precision casting surfaces:.....3.2 Ra

unshaped parts:.....3.2 Ra

rolled surfaces (entry on drawing: "rolled").....0.6 Ra

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9637	update/ID			RON 101_en_9637.doc
edition	description of change			document
prepared/date ID/Ai 1994 10 10	checked/date AF	approved/date ID	replaces: RON 101 edition: 9637	
checked/date QE	checked/date QF	checked/date QA	checked/date	