

Item Number	Machining Method	Number of Patches	Ranges of roughness values		
			Ra (μm)	Rz (μm)	N-groups
130	Flat Lapping Criss-cross / parallel	6	0.05 to 1.6	0.55 to 10	2 to 7
	Surface Grinding	6	0.05 to 1.6	0.55 to 10	2 to 7
	Horizontal milling	6	0.4 to 12.5	2.5 to 50	5 to 10
	End milling	6	0.4 to 12.5	2.5 to 50	5 to 10
	Cylindrical turning	6	0.4 to 12.5	2.5 to 50	5 to 10
315	Surface grinding	8	0.025 to 3.2	0.25 to 16	1 to 8
316	Cylindrical grinding	8	0.025 to 3.2	0.25 to 16	1 to 8
319	Face turning	8	0.4 to 50.0	1.6 to 160	5 to 12
320	Cylindrical turning	8	0.4 to 50.0	1.6 to 160	5 to 12
321	End milling	8	0.4 to 50.0	1.6 to 160	5 to 12
333	Hand filing	5	0.4 to 6.4	2.5 to 63	5 to 9