



Diamond Polishing



- Lens quality finish
- Ideal for visible or decorative parts
- Works well with Chrome & Nickel

Diamond Polishing

Crushed industrial diamonds that are 1 to 15 micron in diameter are used to produce these mirror-like quality finishes.

An SPI A-1 Diamond Finish is a specialty of Bales Mold Service. We use it to produce the finest finish on highly visible or lens quality parts. The SPI A-2 is the most widely used Diamond Finish, providing good release and good visual parts. An SPI A-3 is a fine choice for release where a high gloss appearance is not required. All Diamond Finishes work well with Chrome and Nickel.

Bales also offers:

Paper Finishes, SPI B-1 to B-3 — Next to Diamond Polishing, Paper Finishes are the second most refined

finishes available. Paper Finishes produce a slightly reflective or glossy shine and very good release. They are often recommended for products that do not require a big decorative or visual impact.

Stone Finishes, SPI C-1 to C-3 — The most economical finish, Stone finishes are also the first step in the process of creating both the Paper and Diamond finishes. Stone Finishes provide good release but very little gloss to the plastic part. It is a good choice for strictly functional molded parts where aesthetics is of no importance.

Blast Finishes, SPI D-1 to D-3 — When done properly, Blasted Finishes can produce some of the most interesting stipples and textures on mold surfaces. From a fine satin texture with varied degrees of gloss to a flat, no-gloss, coarse stipple, Bales has the Blast media to produce the proper finish for you. Plus, Blast Finishes are an excellent way to camouflage weld repairs and slight imperfections.

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



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