



Werkzeug & Formenbau
Draht- und Senkerosion

Oberflächenrauheit

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ISO 1302	VDI 3400	Ra μm	Grenze μm	Rz μm (angenähert)	Rt μm (angenähert)
N3	0	0.1	0.05 - 0.11	0.8 - 1.1	0.8 - 1.5
	1	0.11	0.11 - 0.12	0.8 - 1.2	0.9 - 1.6
	2	0.12	0.12 - 0.13	0.9 - 1.3	0.9 - 1.7
	3	0.14	0.13 - 0.15	0.9 - 1.4	1.0 - 1.9
	4	0.16	0.15 - 0.17	1.0 - 1.5	1.0 - 2.0
N4	5	0.18	0.17 - 0.19	1.0 - 1.6	1.1 - 2.2
	6	0.2	0.19 - 0.21	1.1 - 1.8	1.2 - 2.3
	7	0.22	0.21 - 0.24	1.2 - 1.9	1.3 - 2.5
	8	0.25	0.24 - 0.27	1.2 - 2.1	1.3 - 2.7
	9	0.28	0.27 - 0.30	1.3 - 2.2	1.4 - 2.9
N5	10	0.32	0.30 - 0.34	1.4 - 2.4	1.5 - 3.1
	11	0.35	0.34 - 0.38	1.5 - 2.6	1.6 - 3.4
	12	0.4	0.38 - 0.43	1.6 - 2.8	1.7 - 3.6
	13	0.45	0.43 - 0.48	1.7 - 3.1	1.9 - 4.0
	14	0.5	0.48 - 0.53	2.0 - 3.4	2.1 - 4.3
N6	15	0.56	0.53 - 0.60	2.2 - 3.7	2.3 - 4.7
	16	0.63	0.60 - 0.67	2.4 - 4.0	2.6 - 5.1
	17	0.71	0.67 - 0.76	2.7 - 4.4	2.9 - 5.5
	18	0.8	0.76 - 0.85	3.0 - 4.8	3.2 - 6.0
	19	0.9	0.85 - 0.95	3.4 - 5.2	3.6 - 6.6
N7	20	1	0.95 - 1.06	3.8 - 5.7	4.0 - 7.1
	21	1.12	1.06 - 1.19	4.2 - 6.2	4.5 - 7.8
	22	1.25	1.19 - 1.33	4.7 - 6.7	5.0 - 8.4
	23	1.4	1.33 - 1.50	5.3 - 7.4	5.6 - 9.2
	24	1.6	1.50 - 1.70	5.9 - 8.1	6.3 - 10.0
N8	25	1.8	1.70 - 1.90	6.6 - 9.0	7.1 - 11.2
	26	2	1.90 - 2.12	7.4 - 10.1	8.0 - 12.5
	27	2.24	2.12 - 2.37	8.3 - 11.3	9.0 - 13.9
	28	2.5	2.37 - 2.65	9.4 - 12.7	10.1 - 15.6
	29	2.8	2.65 - 2.98	10.5 - 14.2	11.3 - 17.4
N9	30	3.15	2.98 - 3.35	11.7 - 15.8	12.7 - 19.5
	31	3.55	3.35 - 3.78	13.2 - 17.7	14.2 - 21.8
	32	4	3.78 - 4.25	14.7 - 19.9	16.0 - 24.3
	33	4.5	4.25 - 4.75	16.5 - 22.2	17.9 - 27.2
	34	5	4.75 - 5.30	18.5 - 24.9	20.1 - 30.4
N10	35	5.6	5.30 - 5.95	20.7 - 27.8	22.6 - 34.0
	36	6.3	5.95 - 6.70	23.2 - 30.4	25.1 - 37.6
	37	7.1	6.70 - 7.55	26.0 - 33.9	28.1 - 41.7
	38	8	7.55 - 8.50	29.2 - 37.8	31.3 - 46.2
	39	9	8.50 - 9.50	32.7 - 42.2	35.0 - 51.1
N11	40	10	9.50 - 10.60	36.6 - 47.0	39.1 - 56.6
	41	11.2	10.60 - 11.85	41.1 - 52.4	43.6 - 62.8
	42	12.5	11.85 - 13.25	45.8 - 58.4	48.3 - 68.8
	43	14	13.25 - 15.00	51.4 - 65.1	54.1 - 76.5
	44	16	15.00 - 17.00	57.5 - 72.6	60.6 - 85.1
N12	45	18	17.00 - 19.00	64.5 - 81.0	67.9 - 94.7
	46	20	19.00 - 21.20	72.2 - 90.3	76.0 - 105.4
	47	22.4	21.20 - 23.70	80.9 - 100.6	85.1 - 117.2
	48	25	23.70 - 26.50	90.7 - 112.2	95.3 - 130.4
	49	28	26.50 - 29.75	101.6 - 125.1	106.8 - 145.0
N12	50	31.5	29.75 - 33.25	113.8 - 139.4	119.6 - 161.3
	51	35	33.25 - 37.00	127.5 - 155.4	133.9 - 179.4
	52	39	37.00 - 41.00	142.9 - 173.3	150.0 - 199.6
	53	43	41.00 - 46.50	160.1 - 193.2	168.0 - 222.0
	54	50	46.50 - 55.00	179.3 - 215.4	188.2 - 246.9