



## ■ Surface conditions after external grinding

Two radial wet grinding machines are available for outside treatment at BUTTING for the dimensional range NB 15–350 mm and pipe lengths of 1 000–12 000 mm.

**Table 3.4.3\_1: Achievement of the desired surface roughness:**  
the graining of the abrasive enables a specific surface roughness to be achieved

Grain	Industrial grinding	Special requirements
	Average roughness $R_a$ in microns	Average roughness $R_a$ in microns
180–240	$\leq 1.3$	$\leq 0.9$
320–400	$\leq 0.9$	$\leq 0.5$
320–400 polished	$\leq 0.5$	$\leq 0.3$

