

ARPM Drawing Designation for Flash Extension

Drawing Designation	
T .00mm	(T .000) No flash permitted on area designated. (Standard notation regarding other surfaces shall accompany this notation.)
T .08mm	(T .003) This tolerance will normally require buffing, facing, grinding or a similar operation.
T .40mm	(T .016) This tolerance will normally require precision die trimming, buffing or extremely accurate trimming.
T .80mm	(T .032) This tolerance will normally necessitate die trimming, machine trimming, tumbling, hand trimming, or tear trimming.
T 1.60mm	(T .063) This would be the normal tear trim tolerance.
T 2.35mm	(T .093) This tolerance will normally require die trimming, tear trimming, or hand trimming of some type.
T ∞	(T ∞) No flash limitation.

Drawing Designation	ARPM Drawing Designation for Finish
F1	A smooth, polished and uniform finish completely free of tool marks, dents, nicks and scratches, as produced from a highly polished steel mold. In areas where F1 is specified, the mold will be polished to a surface finish of 10 micro-inches (250nm) or better.
F2	A uniform finish as produced from a polished steel mold. In areas where F2 is specified, the mold will be polished to a surface finish of 32 micro-inches (800nm) or better but with very small tool marks not polished out.
F3	Surfaces of the mold will conform to good machine shop practice and no micro-inch finish will be specified. This is "Commercial Finish".
F4	Satin finish.