

Hygiene class		Surface roughness [Ra] ^{a,b}				
machined	electro-polished ^c	Inner surface		Outer surface		
		without seam area	Seam area	Tubes	Moulded parts	Turned parts
H1	HE1	≤ 1,60 µm ^e	≤ 3,20 µm	etched or bright-annealed without special roughness requirements or burnished ≤ 1,00 µm ^d	etched, brushed or blasted without special roughness requirements or burnished ≤ 1,60 µm ^d	≤ 1,60 µm
H2	HE2	≤ 0,80 µm	≤ 1,60 µm			≤ 1,60 µm
H3	HE3	≤ 0,80 µm	≤ 0,80 µm		etched, brushed or blasted without special roughness requirements or burnished ≤ 1,00 µm ^d	≤ 1,00 µm
H4	HE4	≤ 0,40 µm	≤ 0,40 µm			≤ 1,00 µm
H5	HE5	≤ 0,25 µm	≤ 0,25 µm			≤ 1,00 µm

a = Surface roughness RA in acc. with DIN EN ISO 4287. The measurement is to be carried out in accordance with DIN EN ISO 4288.

b = Brackets, screws, nuts and washers are excluded.

c = Inner surfaces electropolished in accordance with standardised procedure, e.g. as per DIN EN ISO 15730.

d = In the case of external burnishing, an "o" is added to the marking for the hygiene class (e.g. H3o). The measurement for surface roughness is to be carried out axially.

e = The roughness values in the forming area of moulded parts can increase by a factor of 2.