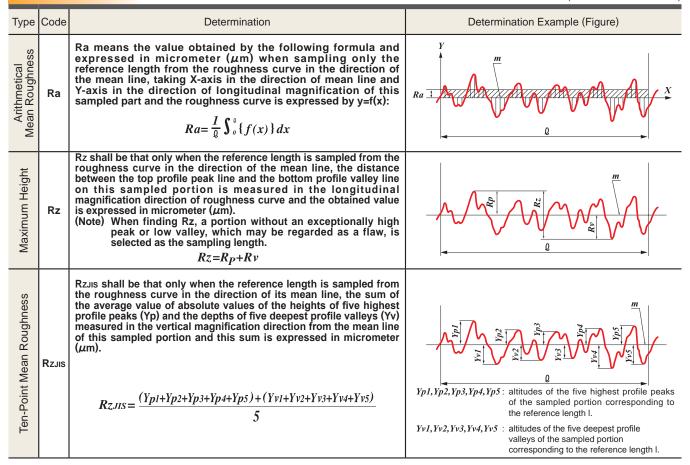
SURFACE ROUGHNESS

SURFACE ROUGHNESS

(From JIS B 0601-1994)



RELATIONSHIP BETWEEN ARITHMETICAL MEAN (Ra) AND CONVENTIONAL DESIGNATION (REFERENCE DATA)

Arithmetical Mean Roughness Ra		Max. Height Rz	Ten-Point Mean Roughness RzJIs	Sampling Length for Rz • RzJis	Conventional Finish
Standard Series	Cutoff Value λc (mm)	Standar	d Series	I (mm)	Mark
0.012a	0.08	0.05s	0.05z	0.08	
0.025 a	0.25	0.1 s	0.1 z		
0.05 a		0.2 s	0.2 z	0.25	
0.1 a	0.8	0.4 s	0.4 z		
0.2 a		0.8 s	0.8 z	0.8	
0.4 a		1.6 s	1.6 z		$\nabla\nabla\nabla$
0.8 a		3.2 s	3.2 z		
1.6 a		6.3 s	6.3 z		
3.2 a	2.5	12.5 s	12.5 z	2.5	$\nabla\nabla$
6.3 a		25 s	25 z		
12.5 a	8	50 s	50 z	8 –	∇
25 a		100 s	100 z		
50 a		200 s	200 z		_
100 a	_	400 s	400 z		

^{*}The correlation among the three is shown for convenience and is not exact.

^{*}Ra: The evaluation length of Rz and Rz is the cutoff value and sampling length multiplied by 5, respectively.