

| Non-periodic profiles | | Periodic profiles | Measuring conditions according to DIN EN ISO 4288 and DIN EN ISO 3274 | | | |
|--------------------------------|---------------------|---------------------------|---|-------------------------|-------------|-------------|
| Grinding, honing, lapping, EDM | | Turning, milling, planing | r_{tip} Maximum probe tip radius l_r Sampling length l_n Evaluation length l_t Stylus travel (evaluation length plus start and finish lengths) | | | |
| Rt, Rz μm | Ra μm | RSm mm | r_{tip} μm | $\lambda_c = l_r$ mm | l_n mm | l_t mm |
| > 0.025...0.1 | > 0.006...0.02 | > 0.013...0.04 | 2 | 0.08 | 0.4 | 0.48 |
| > 0.1...0.5 | > 0.02...0.1 | > 0.04...0.13 | 2 | 0.25 | 1.25 | 1.5 |
| > 0.5...10 | > 0.1...2 | > 0.13...0.4 | 2* | 0.8 | 4 | 4.8 |
| > 10...50 | > 2...10 | > 0.4...1.3 | 5 | 2.5 | 12.5 | 15 |
| > 50...200 | > 10...80 | > 1.3...4 | 10 | 8 | 40 | 48 |

* When $R_z > 3 \mu\text{m}$ or $R_a > 0.5 \mu\text{m}$ a probe tip radius (r_{tip}) = 5 μm may be used.

Matieres N7

WJ Hussar



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