

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.

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