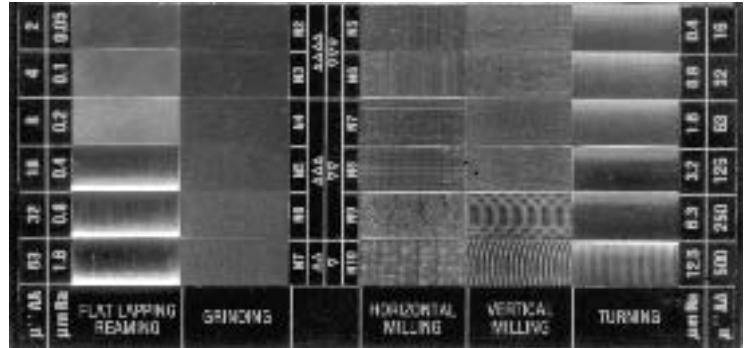


SURFACE FINISH

Applications

- For the six most important machining methods.
- Each type of surface finish is consistently reproduced, giving a realistic idea of the feel, appearance and texture of the machined components.
- For use in Drawing, Planning and Research offices; by Quality controllers, Draftspersons, Engineers, Machinists, Inspectors, Works managers, etc.



Set of 30 electro formed, solid nickel specimens.

Features

- The machining data for the master specimens were obtained in co-operation with individual companies and research establishments, in a manner consistent with the recommendations of the British Standards Institution; and the masters themselves are produced, tested and measured by Rubert & Co. in their own workshops. The specimens are in turn made from these masters by an electro-forming process which is extremely faithful to the originals. The 30 specimens are calibrated in μ'' AA (Arithmetic Average) and in the metric equivalent μ m Ra.
- Conforms to S.A.E. and military specifications for visual and tactile inspection.
- Each roughness specimen is given as the AA value, standardised in ANSI B46.1 - 1978 Military Standard 45662.

Set Includes:

- 3 plates for Flat Lapping 2,4 and 8 μ''
- 3 plates for Reaming 16, 32, and 63 μ''
- 6 plates for Grinding 2, 4, 8, 16, 32 and 63 μ''
- 6 plates for Horizontal Milling 16, 32, 63, 125, 250, 500 μ''
- 6 plates for Vertical Milling 16, 32, 63, 125, 250, 500 μ''
- 6 plates for Turning 16, 32, 63, 125, 250, 500 μ''

For some purposes it may be important to also know the peak to valley depth of roughness, referred to in ISO specifications as Ry; elsewhere as Rt. This parameter bears a rather complex relationship to AA, the ratio Ry/AA varying between 4 and 12. The Ry equivalents given in the table below are to be regarded only as approximate figures, which may deviate by $\pm 30\%$ from the actual values.

	μ'' AA	500	250	125	63	32	16	8	4	2
Horizontal Milling	μ'' Ry	2000	1250	630	320	160	100			
Vertical Milling	μ'' Ry	2000	1250	630	320	160	100			
Turning	μ mRy	50	32	16	8,0	4.0	2.5			
Ratio	Ry,AA	4	5	5	5	5	6.25			
Flat Lapping	μ'' Ry				400	240	120	63	40	22
Reaming	μ'' Ry				400	240	120	63	40	22
Grinding	μ mRy				10	6.0	3.0	1.6	1.0	.55
Ratio	Ry,AA				6.4	7.5	7.5	7.9	10	11

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