

NIPPON KINZOKU DENCHU 

Surface Roughness Scale

Surface Roughness Scale

C.000

JSR GROUP

SURFACE ROUGHNESS SCALE

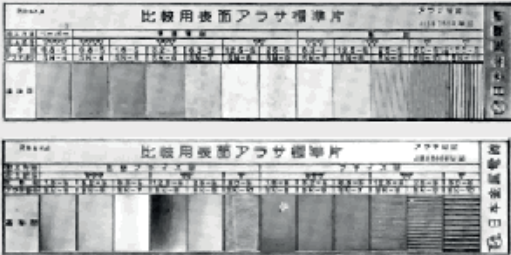
Surface Roughness Scale

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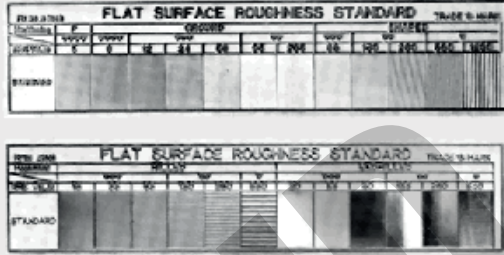
SURFACE ROUGHNESS SCALE

แผ่นเทียบผิวงานกลึง-งานเจียรนัยและอื่น ๆ
SURFACE ROUGHNESS SCALE

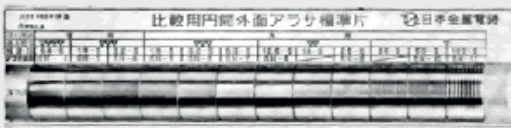
A) PLANE SURFACE 2PCS/SET



G) USAS PLANE SURFACE(Rrms) 2PCS/SET



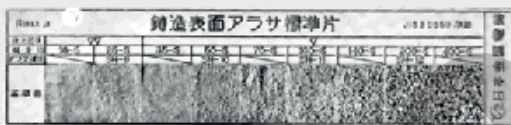
B) TUBULAR OUTER SURFACE



H) USAS TUBULAR OUTER SURFACE(Rrms)



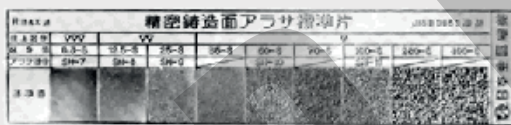
C) CASTING SURFACE



I) GAS CUTTER SURFACE A



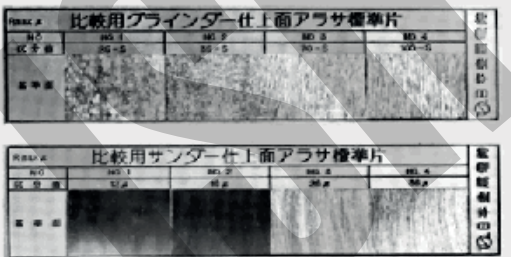
D) PRECISION CASTING



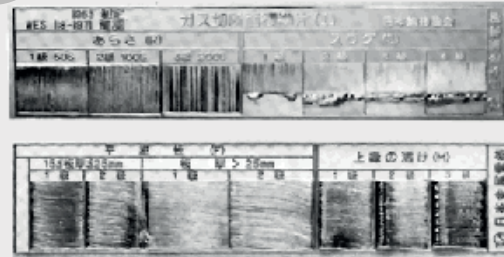
J) GAS CUTTER SURFACE B



E) STEEL PLATE FINISHE D 2PCS/SET



K) GAS WELDED SURFACE



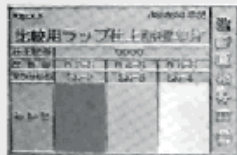
F) FOR TRAINING CENTER



L) LAPPING FINISHED



L) LAPPING FINISHED



Surface Roughness Scale



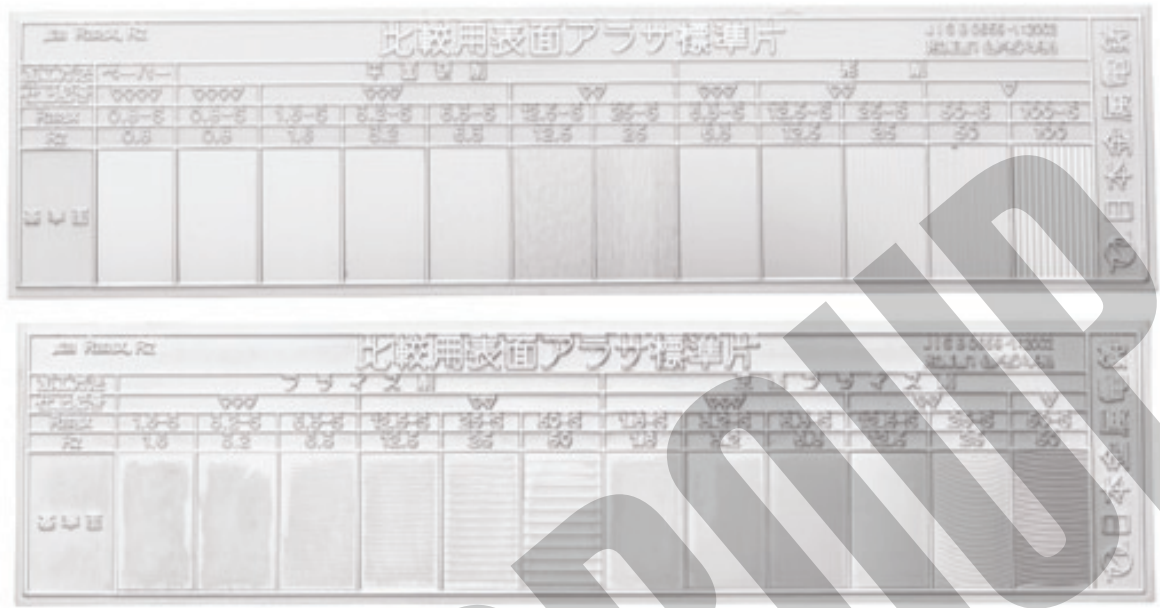
SPECIFICATION OF SURFACE ROUGHNESS SCALE

SYMBOL	METHOD	▽	▽▽▽▽			▽▽▽			▽▽			▽			
		S	0.2	0.4	0.8	1.6	3.2	6.3	12.5	18	25	35	50	100	
(A) PLANE SURFACE	PAPER(P)				○										
	GROUND				○	○	○	○	○		○				
	SHAPED							○	○		○		○	○	
	END MILLED					○	○	○	○		○		○		
	MILLED					○	○	○	○		○		○		
(B) TUBULAR OUTER SURFACE	GROUND				○	○	○								
	ROUND GROUND					○	○	○	○	○	○	○	○	○	
(K) HAND FINISHED	PAPER (P)			○	○	○	○	○							
	FILE							○	○	○					
(C) CASTING SURFACE	S		18	25	35	50	70	100	140	200	400				
			○	○	○	○	○	○	○	○	○	○	○	○	
(D) PRECISION CASTING	S		6.3	12.5	25	35	50	70	100	280	400				
			○	○	○	○	○	○	○	○	○	○	○	○	
(I) FOR GAS CUTTER SURFACE	A		0.10 mm		0.12 mm		0.16 mm		0.25 mm		0.60 mm				
	B		0.04 mm		0.05 mm		0.10 mm		0.12 mm		0.18 mm				
(J) GAS WELDED SURFACE	FLATNESS						MELTING								
	15mm. ≤ THICK ≤ 25 mm.			THICK > 25 mm			CLASS 1			CLASS 2			CLASS 3		
	CLASS 1			CLASS 2			CLASS 1			CLASS 2			CLASS 3		
	ROUGHNESS						SLUG								
	CLASS 1 50-S		CLASS 2 100-S		CLASS 3 200-S		CLASS 1		CLASS 2		CLASS 3		CLASS 4		
(L) LAPPING FINISHED	▽▽▽▽														
		0.2	0.4	0.8											
(E) STEEL PLATE FINISHED	GRINDING FACE	25-S			35-S			70-S			100-S				
	SANDER FACE	12μ			16μ			26μ			36μ				
(G) USAS PLANE SURFACE Rrms	P	5													
	GROUND	6	12	24	58	95		265							
	SHAPED				68	130		260			590	1200			
	ENDMILLED		20	35	80	135		260			540				
	MILLED		16	35	65	130		260			530				
(H) USAS TUBULAR OUTER SURFACE Rrms	GROUND	5	12	24											
	TURNED		17	34	70	130	190	260	380	530	990				
SYMBOL	▽	▽▽▽▽			▽▽▽			▽▽			▽				
	S	0.2	0.4	0.8	1.6	3.2	6.3	12.5	18	25	35	50	100		
(F) FOR TRAINING CENTER	PAPER(P)				○	○	○								
	GROUND			○	○	○									
	SHAPED						○			○		○			
	FILE						○	○	○						

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NIHON KINZOKU DENCHU CO., LTD.
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