

# SURFACE ROUGHNESS SPECIMEN



ISR-CSE315

- For checking, identifying and specifying the roughness by symbol
- Accuracy: +20% ~ -25%,  $R_a \leq 4\mu\text{m}$   
Accuracy: +12% ~ -17%,  $R_a > 4\mu\text{m}$
- Meets ISO 2632 (ISR-CS329 meets ISO 8503/1)
- Rust-proof, made of pure Nickel

Part No.	Machining method	Roughness (Ra)	Roughness (Rz)	Quantity
ISR-CSE315	Surface grinding	1, 2, 4, 8, 16, 32, 63, 125 $\mu\text{m}$	11.8, 22.1, 36.3, 69.6, 104, 186, 315, 625 $\mu\text{m}$	8pcs
ISR-CSE316	Cylindrical grinding	1, 2, 4, 8, 16, 32, 63, 125 $\mu\text{m}$	11.9, 21.0, 35.2, 62.4, 106, 176, 309, 613 $\mu\text{m}$	8pcs
ISR-CSE317	Flat lapping	Criss-cross	1, 2, 4, 8 $\mu\text{m}$	16, 24, 30, 50 $\mu\text{m}$
		Parallel	1, 2, 4, 8 $\mu\text{m}$	14, 22, 45, 60 $\mu\text{m}$
ISR-CSE318	Cylindrical lapping	1, 2, 4, 8 $\mu\text{m}$	18, 22, 25, 49 $\mu\text{m}$	4pcs
	Superfinishing	1, 2, 4, 8 $\mu\text{m}$	14, 28, 40, 56 $\mu\text{m}$	4pcs
ISR-CSE319	Face turning	16, 32, 63, 125, 250, 500, 1000, 2000 $\mu\text{m}$	76.8, 128, 246, 500, 950, 1950, 4010, 7400 $\mu\text{m}$	8pcs
ISR-CSE320	Cylindrical turning	16, 32, 63, 125, 250, 500, 1000, 2000 $\mu\text{m}$	68, 128, 244, 488, 950, 1900, 3800, 7600 $\mu\text{m}$	8pcs
ISR-CSE321	End milling	16, 32, 63, 125, 250, 500, 1000, 2000 $\mu\text{m}$	76.8, 153, 258, 488, 1011, 1992, 3704, 7620 $\mu\text{m}$	8pcs
ISR-CSE322	Reaming	16, 32, 63, 125 $\mu\text{m}$	68, 128, 256, 512 $\mu\text{m}$	4pcs
	Drilling	63, 125, 250, 500 $\mu\text{m}$	300, 620, 1240, 2400 $\mu\text{m}$	4pcs
ISR-CSE323	Horizontal milling	16, 32, 63, 125, 250, 500, 1000, 2000 $\mu\text{m}$	72, 147, 265, 512, 1025, 2120, 3900, 7880 $\mu\text{m}$	8pcs
ISR-CSE325	Shaping (planing)	32, 63, 125, 250, 500, 1000, 2000, 4000 $\mu\text{m}$	154, 268, 488, 1009, 1950, 3998, 7603, 14440 $\mu\text{m}$	8pcs
ISR-CSE326	Linishing (belt sanding)	4, 8, 16, 32, 63, 125 $\mu\text{m}$	36, 62, 135, 297, 740, 1240 $\mu\text{m}$	6pcs
ISR-CSE328	Vertical grinding	8, 16, 32, 63, 125, 250 $\mu\text{m}$	44, 140, 246, 351, 888, 1632 $\mu\text{m}$	6pcs
ISR-CSE329	Grit blasting	128, 420, 720, 1000 $\mu\text{m}$	768, 2520, 4320, 6000 $\mu\text{m}$	4pcs
	Shot blasting	128, 320, 520, 720 $\mu\text{m}$	768, 1920, 3120, 4320 $\mu\text{m}$	4pcs
ISR-CSE331	Spark erosion (EDM)	16, 32, 63, 125, 250, 500, 1000, 2000 $\mu\text{m}$	100, 180, 288, 568, 988, 2048, 4200, 7840 $\mu\text{m}$	8pcs
ISR-CSE333	Hand filing	16, 32, 63, 125, 250 $\mu\text{m}$	120, 224, 496, 900, 2440 $\mu\text{m}$	5pcs
ISR-CSE334	Castings	32, 63, 125, 250, 500, 1000, 2000 $\mu\text{m}$	128, 320, 640, 1280, 2240, 4480, 9000 $\mu\text{m}$	7pcs
ISR-CSE335	Honing	2, 4, 8, 16, 32, 63 $\mu\text{m}$	12, 22, 40, 80, 168, 360 $\mu\text{m}$	6pcs
ISR-CSE336	Polishing	.5, 1, 2, 4, 8 $\mu\text{m}$	12, 14, 27, 29, 61 $\mu\text{m}$	5pcs