

## Roughness measurement standards

**line of products KNT 4058/02 (for the determination of roughness of sheet metal surfaces)**

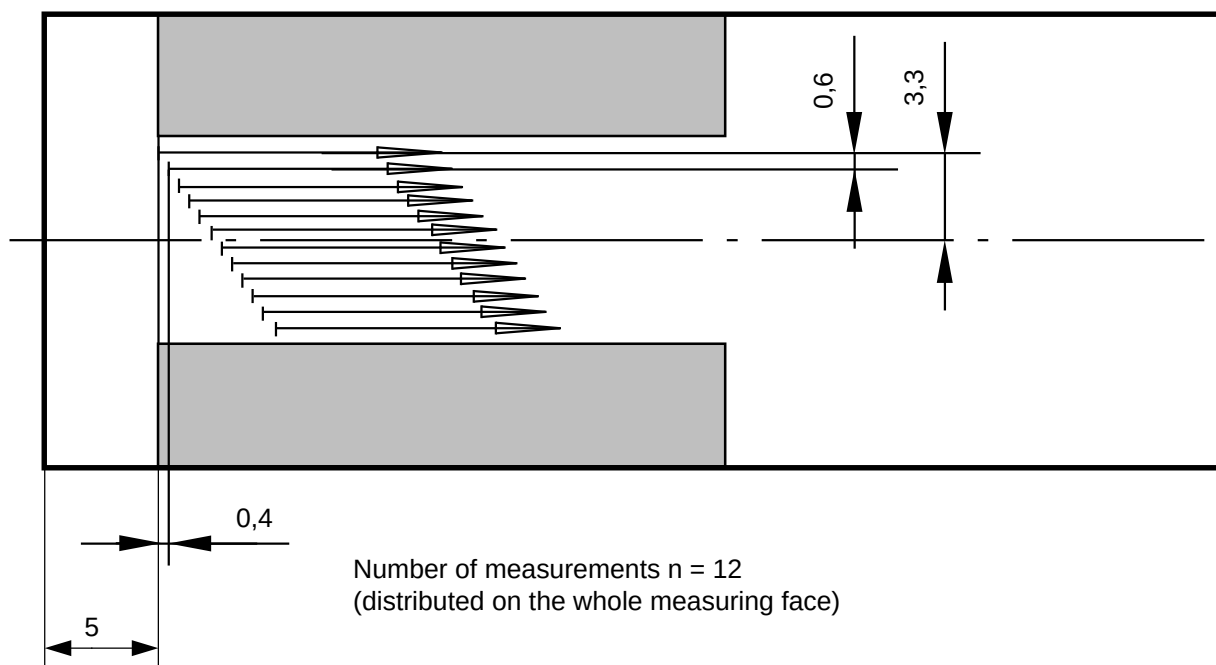
corresponding to Physikalisch-Technische Bundesanstalt (PTB)-measurement standards 2B

for calibrating and checking of the complete contact stylus instrument from the stylus to the read-out display.

Definitions and measured quantities for the measurement of roughness at sheet metal:

| Definition                  | Measurement quantities                   | Standard              |
|-----------------------------|------------------------------------------|-----------------------|
| Total evaluation length     | l <sub>m</sub> in mm                     | ISO 4288 and SEP 1940 |
| Wave length limit (cut off) | λ <sub>c</sub> in mm                     | EN 10049 from 2000    |
| Arithmetical mean deviation | R <sub>a</sub> in μm                     | EN 10049 from 2000    |
| Peak count                  | RP <sub>c</sub> (NR) in cm <sup>-1</sup> | EN 10049 from 2000    |
| Average surface roughness   | R <sub>z</sub> in μm                     | ISO 4287 from 1997    |
| Counting thresholds         | c1 and c2 in μm                          | EN 10049 from 2000    |
| Filter                      | Phase correct profile filter             | ISO 11562 from 1996   |
| Pick-up                     | Pick-up with two skids                   | EN10049 from 2000     |

Scheme of measuring points of the PTB-calibration



scale: 3 : 1

Price list (with times of delivery, article No. ...etc): see page No.: 14.1

**HALLE-Präzisions-Kalibriernormale GmbH**

**DE-31234 Edemissen • Zum Wehnser See 19a**

Tel.: +49 5176 - 975978 • Fax: +49 5176 - 975988

Prepared on:

21.02.1996

Revised on:

12.05.2009

**Page No.**

**4.2**