



SURFACE ROUGHNESS SPECIMEN



ISR-CS315

- For checking, identifying and specifying the roughness by symbol
- Accuracy: +20% ~ -25%, $Ra \leq 0.1 \mu m$
Accuracy: +12% ~ -17%, $Ra > 0.1 \mu m$
- Meets ISO 2632 (ISR-CS329 meets ISO 8503/1)
- Rust-proof, made of pure Nickel

Code	Machining method	Roughness (Ra)	Roughness (Rz)	Quantity
ISR-CS315	Surface grinding	0.025, 0.05, 0.1, 0.2, 0.4, 0.8, 1.6, 3.2 μm	0.29, 0.55, 0.91, 1.74, 2.6, 4.65, 7.87, 15.6 μm	8pcs
ISR-CS316	Cylindrical grinding	0.025, 0.05, 0.1, 0.2, 0.4, 0.8, 1.6, 3.2 μm	0.3, 0.53, 0.88, 1.56, 2.64, 4.4, 7.71, 15.3 μm	8pcs
ISR-CS317	Flat lapping	Criss-cross	0.025, 0.05, 0.1, 0.2 μm	0.4, 0.6, 0.74, 1.26 μm
		Parallel	0.025, 0.05, 0.1, 0.2 μm	0.34, 0.56, 1.12, 1.5 μm
ISR-CS318	Cylindrical lapping	0.025, 0.05, 0.1, 0.2 μm	0.46, 0.54, 0.63, 1.23 μm	4pcs
	Superfinishing	0.025, 0.05, 0.1, 0.2 μm	0.36, 0.7, 1, 1.4 μm	4pcs
ISR-CS319	Face turning	0.4, 0.8, 1.6, 3.2, 6.3, 12.5, 25, 50 μm	1.92, 3.2, 6.15, 12.5, 23.7, 48.7, 102, 185 μm	8pcs
ISR-CS320	Cylindrical turning	0.4, 0.8, 1.6, 3.2, 6.3, 12.5, 25, 50 μm	1.7, 3.2, 6.1, 12.2, 23.7, 47.5, 95, 190 μm	8pcs
ISR-CS321	End milling	0.4, 0.8, 1.6, 3.2, 6.3, 12.5, 25, 50 μm	1.92, 3.82, 6.45, 12.2, 25.2, 49.8, 92.6, 191 μm	8pcs
ISR-CS322	Reaming	0.4, 0.8, 1.6, 3.2 μm	1.7, 3.2, 6.4, 12.8 μm	4pcs
	Drilling	1.6, 3.2, 6.3, 12.5 μm	7.5, 15.5, 31, 60 μm	4pcs
ISR-CS323	Horizontal milling	0.4, 0.8, 1.6, 3.2, 6.3, 12.5, 25, 50 μm	1.8, 3.68, 6.63, 12.8, 25.6, 53, 97.5, 197 μm	8pcs
ISR-CS325	Shaping (planing)	0.8, 1.6, 3.2, 6.3, 12.5, 25, 50, 100 μm	3.84, 6.7, 12.2, 25.2, 48.7, 99.9, 190, 361 μm	8pcs
ISR-CS326	Linishing (belt sanding)	0.1, 0.2, 0.4, 0.8, 1.6, 3.2 μm	0.9, 1.55, 3.37, 7.42, 18.5, 31 μm	6pcs
ISR-CS328	Vertical grinding	0.2, 0.4, 0.8, 1.6, 3.2, 6.3 μm	1.1, 3.5, 6.15, 8.78, 22.19, 40.8 μm	6pcs
ISR-CS329	Grit blasting	3.2, 10.5, 18, 25 μm	19.2, 63, 108, 150 μm	4pcs
	Shot blasting	3.2, 8, 13, 18 μm	19.2, 48, 78, 108 μm	4pcs
ISR-CS331	Spark erosion (EDM)	0.4, 0.8, 1.6, 3.2, 6.3, 12.5, 25, 50 μm	2.5, 4.5, 7.2, 14.2, 24.7, 51.2, 105, 196 μm	8pcs
ISR-CS333	Hand filing	0.4, 0.8, 1.6, 3.2, 6.3 μm	3, 5.6, 12.4, 22.5, 61 μm	5pcs
ISR-CS334	Castings	0.8, 1.6, 3.2, 6.3, 12.5, 25, 50 μm	3.2, 8, 16, 32, 56, 112, 225 μm	7pcs
ISR-CS335	Honing	0.05, 0.1, 0.2, 0.4, 0.8, 1.6 μm	0.31, 0.56, 1, 2, 4.2, 9 μm	6pcs
ISR-CS336	Polishing	0.0125, 0.025, 0.05, 0.1, 0.2 μm	0.29, 0.35, 0.67, 0.72, 1.52 μm	5pcs