

...ers, Foremen etc.
 The 30 Specimens are calibrated in μ'' AA (Arithmetical Average) and in the metric equivalents $\mu m Ra$. They are accurate to within $\pm 12\%$ of the nominal values indicated, excluding instrumentation errors.
 For many purposes it is of importance to know also the total peak to valley depth of roughness (referred to in Europe as Rt), which varies from 4 to 12 times the AA values.
 In the table below the Rt values are given in μ'' and μm . Since during the last few years it has proved impossible to measure Rt to a high degree of accuracy it is of little use to quote respective Rt for every Specimen. The Rt equivalents quoted are therefore only rounded-up figures which may deviate by $\pm 30\%$ from the actual values.

	$\mu'' AA$	100	250	625	125	32	16	8	4	2
Horizontal Milling	$\mu'' Rt$	2000	1250	630	320	160	100			
Vertical Milling	$\mu m Rt$	50	32	16	8.0	4.0	2.5			
Turning	Rt/AA	4	5	5	5	5	4.25			
Flat Lapping	$\mu'' Rt$				400	240	120	63	40	22
Bore Reaming	$\mu m Rt$				10	6.0	3.0	1.6	1.0	0.50
Grinding	Rt/AA				6.4	7.5	7.5	7.9	10	11

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$\mu'' AA$ $\mu m Ra$

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$\mu m Ra$ $\mu'' AA$

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Rms Finish Guide

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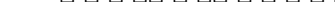
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