



ISO 2632
Parts 1 and 2

Rust-resistant
nickel

Specimens
for roughness
comparison
cannot be used as reference
ones. Therefore, they are
not suitable for calibrating
surface roughness testers.

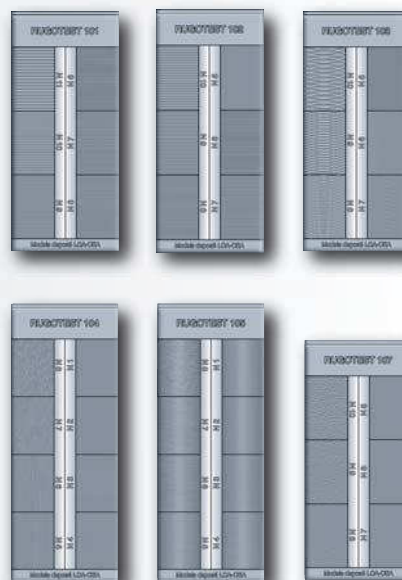
Leather case

RUGOTEST Roughness Comparison Specimens

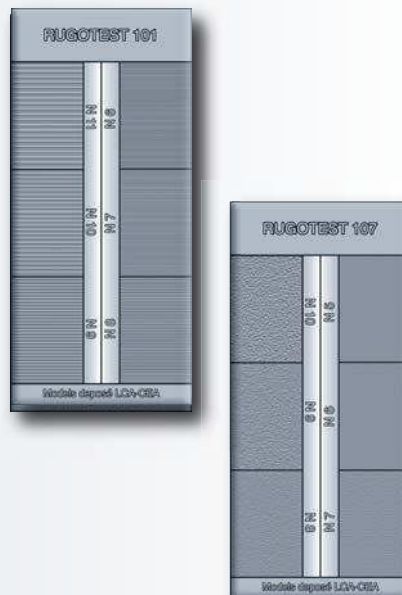
For touch and/or sight comparisons of the workpiece surface finish.

Sets of roughness specimens for single machining methods according to ISO roughness parameters

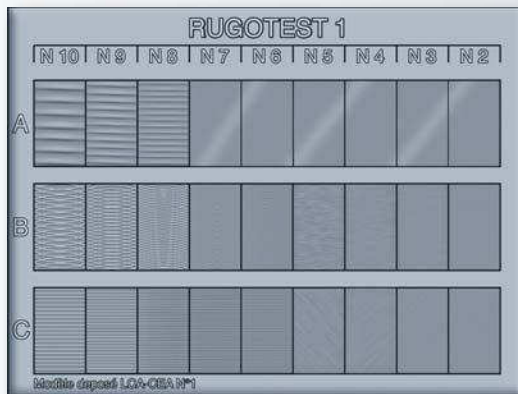
No	RUGOTEST	RUGO-TEST	Number of single specimens	ISO roughness parameters
081112346	RUGOTEST A4			
<i>Consistina of the followinga single specimens :</i>				
081112053	Metal workina	1	27	N2 ÷ N10
081112054	Hand arindina	2	6	N6 ÷ N11
081112055	Shot blastina	3	18	N6 ÷ N11
081112056	Hand filina	4	6	N6 ÷ N8
081112345	RUGOTEST A6			
<i>Consistina of the followinga single specimens :</i>				
081112058	Planina	101	6	N6 ÷ N11
081112059	Turnina	102	6	N5 ÷ N10
081112060	Face millina	103	6	N5 ÷ N10
081112061	Surface arindina	104	8	N1 ÷ N8
081112062	Circular arindina	105	8	N1 ÷ N8
081112063	Spark erosion	107	6	N5 ÷ N10



No	RUGOTEST	mm	α
081112053	1	135 x 105	160
081112054	2	120 x 90	160
081112055	3	120 x 90	190
081112056	4	120 x 90	160
081112057	5	120 x 90	200
081112058	101	110 x 50	110
081112059	102	110 x 50	105
081112060	103	110 x 50	110
081112061	104	130 x 50	125
081112062	105	130 x 50	130
081112063	107	110 x 50	110
081112344	12	127 x 27	60
081112346	A4	330 x 250	710
081112345	A6	330 x 250	780



Specimens for individual machining methods according to ISO roughness parameters



ISO roughness parameters				N0	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11
Mean roughness value Ra	um			0.0125	0.025	0.05	0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25
	uin			0.5	1	2	4	8	16	32	63	125	250	500	1000
Mean roughness value Rz ISO	um / uin			These values are changing depending on the machining method used.											
Nº	=	RUGO-TEST No.	Number of single-specimens												
081112053	Metal working	1	27												
	Side milling		3									•	•	•	
	Face milling		5							•	•	•	•	•	
	Turning/Planing		5							•	•	•	•	•	
	Grinding		6			•	•	•	•						
	Lapping		4			•	•	•	•						
	Finish grinding/Honing		4		•	•	•	•							
081112054	Hand grinding	2	6							•	•	•	•	•	•
081112055	Shot blasting	3	18												
	Blasting grains														
	– spherical	coarse	3										•	•	•
		fine	6							•	•	•	•	•	•
	– angular	coarse	3										•	•	•
		fine	6							•	•	•	•	•	•
081112056	Hand filing	4	6												
	– straight		3							•	•	•			
	– intersected		3							•	•	•			
081112057	Hand polishing	5	10												
	Surface shape														
	– cylindrical		5		•	•	•	•	•						
	– plane		5		•	•	•	•	•						
081112058	Planing	101	6							•	•	•	•	•	•
081112059	Turning	102	6						•	•	•	•	•	•	
081112060	Face milling	103	6						•	•	•	•	•	•	
081112061	Plane grinding	104	8		•	•	•	•	•	•	•	•			
081112062	Circular grinding	105	8		•	•	•	•	•	•	•	•			
081112063	Spark erosion	107	6						•	•	•	•	•	•	

Specimens according to Charmille roughness parameters (VDI 3400)

Charmille roughness parameters				12	15	18	21	24	27	30	33	36	39	42	45
Mean roughness Ra	um			0.40	0.56	0.80	1.12	1.60	2.24	3.15	4.5	6.3	9.0	12.5	18.0
Nº	=		Number of single-specimens												
081112344	Spark erosion		12	•	•	•	•	•	•	•	•	•	•	•	•