



CITY OF BATON ROUGE
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DEPARTMENT OF HUMAN RESOURCES

Study Guide
Engineering Aide I & II
Written Examination

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Engineering Aide Study Guide

**United States. Division of Vocational
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web pt $rmax$ at jis 82 sum of height of the largest profile peak height rp and the largest profile valley rv within an evaluation length rt pt wt max rpi max rvi rzj is ten point height of roughness profile rz at jis 94 sum of mean value of largest peak to the fifth largest peak and mean value of largest valley to

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web $rmax$ vertical distance from highest peak to lowest valley $rmax$ is particularly sensitive to anomalies such as scratches and burrs that may not be obvious from measures such as ra that rely on averages rz preferred by many europeans rz is often preferred to ra in europe and particularly germany

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web r z m i n 3 8 r a 0 95 r z m a x 14 5 r a 0 75 converting between ra and rz is not a good engineering practice it is always recommended to measure according to the method in which surface roughness is indicated on the drawing as you can see in the below graphs the inaccuracy grows in higher r a r z values

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web ra roughness average in micrometers or microinches rms root mean square in microinches cla center line average in microinches rt roughness total in microns n new iso grade scale numbers cut off length length required for sample

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web conversions math cla micro inches multiply ra μm $\times 40$ r t r a $\times 8$ 7 r z r a $\times 7$ 2 r z iso r a $\times 7$ 6 r max r a $\times 8$ 0 r p r a $\times 3$ 6 rpm r a $\times 2$ 9 rms r a $\times 1$ 1 example ra to rt 1 0 micrometer ra $\times 8$ 7 rt factor 8 7 micrometer rt 40 microinch ra $\times 8$ 7 rt factor 348 microinch rt

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