



CITY OF BATON ROUGE
PARISH OF EAST BATON ROUGE

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 r_{max} 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 r_{pi} max r_{vi} rz jis 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 usage note a direct allocation of an rz value to a roughness grade is not possible due to the conversion interval in this rz ra calculator the input rz value is first converted to the average value of the ra interval and the n class is determined based on this value

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web r_{max} vertical distance from highest peak to lowest valley r_{max} 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 nov 11 2021 surface finish conversion chart in this section there s a table for the surface finish conversion chart this table compares the different surface roughness scales for manufacturing processes meanwhile let s go through some of the abbreviations you ll find there ra roughness average rms root mean square cla center line

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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 $\mu\text{m} \times 40$ 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 10 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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