

TECHNICAL DRAWINGS

Positions of respective indicating symbols relative to indicating symbol of surface

Each grain surface position is indicated as shown in Fig. 1. This includes surface roughness, cut-off value or reference length, processing method, symbol of direction of lay, surface waviness, etc.

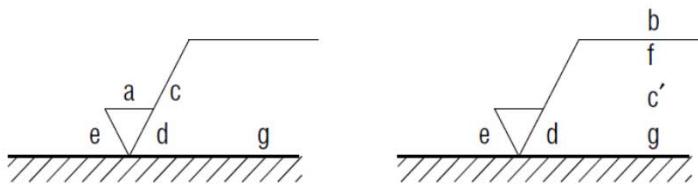


Fig. 1 Legend

- a : Value of Ra
- b : Processing method
- c : Cutoff value. Evaluation length
- c' : Reference length. Evaluation length
- d : Symbol of direction of lay
- f : Parameter other than Ra (With tp, parameter/cutoff level)
- g : Surface waviness (according to JIS B 0610)

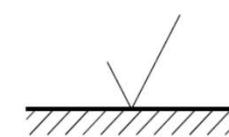
Note : Items other than a and f are added as necessary.

Reference : The location of lay of e in Fig. 1. is given as the finish allowance in ISO 1302.

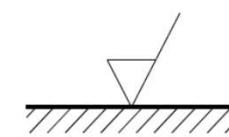
Symbol	Meaning	Figure
=	Parallel to the projected surface on which the direction of lay of the cutting blade is indicated. (ex) Shaped surface	
⊥	Perpendicular to the projected surface on which the direction of lay of the cutting blade is indicated. (ex) Shaped surface (when viewed from the side), machined or cylindrical ground surface.	
X	Intersection of two diagonal lines on the projected surface on which the direction of lay of the cutting blade is indicated. (ex) Honing finished surface	
M	Multidirectional intersection or non-directional point on the projected surface on which the direction of lay of the cutting blade is indicated. (ex) Rapping finished surface, super finished surface, face milled or end milled surface in surfacing feed direction	
C	Concentric circles roughly centered on the same on the surface on which the direction of lay of the cutting blade is indicated. (ex) Facing surface	
R	Radiating shape roughly centered on the same point on the surface on which the direction of lay of the cutting blade is indicated.	

■ Examples indicating surface texture on drawing

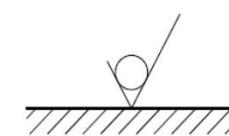
Indicating symbol of surface



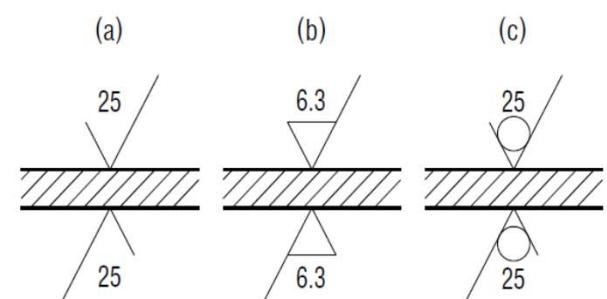
Indicating symbol of surface requiring removal press



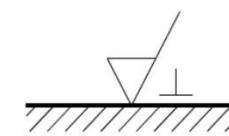
Indicating symbol of surface on which no removal process is permitted



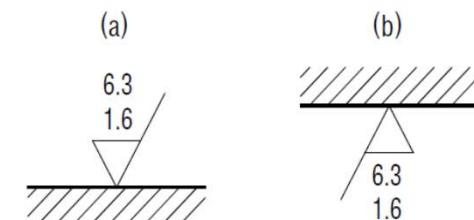
Examples indicating the upper limits of Ra



Examples indicating direction of lay



Examples indicating the upper limit and lower limit of Ra



Examples indicating processing method

