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MEASURING  
SURFACE FINISHES

*Page 4/31*

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ISO vs. ASME – Ra  
Example □ ISO  
4287 computes the  
values over the  
entire evaluation  
length (and  
sometimes  
computes the  
values within a  
sampling length) □  
ISO 4288 and ASME  
B46.1, modifies  
this computation  
methodology to

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include estimates of parameters (computed over one sampling length) versus average value of parameters (computed over all

Surface Texture  
(Surface Roughness, Waviness, and Lay)

ASME B46.1 2009

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Edition, 2009.  
Complete  
Document Surface  
Texture (Surface  
Roughness,  
Waviness, and Lay)  
View Abstract  
Product Details  
Document History  
ASME B46.1  
(Complete  
Document ) 2002  
Edition, 2. ASME  
B46.1 (Complete

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Document ...

Waviness height -  
Mahr

ASME B46. 1-2009  
(Revision of ASME  
B46.1-2002).

Surface Texture  
(Surface

Roughness,

Waviness, and

Lay). A N A M E R I

C A N N A T I O N A

L S T A N D A R D



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ASME B46.1-2009  
(Revision of ASME  
B46.1-2002).

Surface Texture  
(Surface  
Roughness,  
Waviness, and  
Lay). A N A M E R I  
C A N N A T I O N A  
L S T A N D A R D

Surface Metrology  
Guide - Surfaces  
and Profiles

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Surface ...

400 & up .300 1.5

B46.1-2002 3.3.20

“Roughness filter cutoff length is determined in part by the x and z aspects of the surface under evaluation as related To the intended function of the surface. The roughness filter

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cutoff length  
should be chosen  
by the designer in  
light of the  
Intended function  
of the surface.

Asme B46 1  
ASME B46.1 – 2009  
for the metrologist  
to establish  $c$  and  
 $s$ . These guidelines  
are intended to

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include the dominant features of the surface in the measurement whether these surface features are relevant to the function of the surface or not.

ASME B46.1 2009 –  
Key Concepts

B46.1 Intro  
Webinar - ASME

*Page 12/31*

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ASME B46.1  
January 1, 2009  
Surface Texture  
(Surface  
Roughness,  
Waviness, and Lay)  
This Standard is  
concerned with the  
geometric  
irregularities of  
surfaces. It defines  
surface texture and  
its constituents:  
roughness,

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waviness, and lay.  
It also defines  
parameters for  
specifying...

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N A T I O N A L S T A  
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Surface Texture  
(Surface

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Waviness, and Lay)  
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ASME B46.1 : 2009  
| SURFACE  
TEXTURE



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(SURFACE  
ROUGHNESS ...  
designation,  
measurement and  
control of surface  
texture is ANSI  
B46.1-1978 Surface  
Texture Standard  
(formerly ASA  
B46.1-1962). This  
document  
standardizes  
terminology and  
measurement of

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the various aspects  
of surface texture,  
defines  
characteristics of  
stylus  
instrumentation for  
measuring

Ra & RMS Surface  
Roughness  
Calculation -  
Surface Finish ...  
Wt waviness height  
EN ISO 4287, ASME

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B46.1. Waviness height. Waviness height  $W_t$  (total height of W-profile) is the sum of the largest profile peak height and the largest profile valley depth of the W-profile within the evaluation length  $l_n$  (reference length).

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Surface Texture  
(Surface  
Roughness,  
Waviness ...

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2009 surface  
texture (surface  
roughness,  
waviness, and lay)

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from sai global

Surface Texture  
(Surface  
Roughness,  
Waviness, and Lay)  
- ASME

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Surface Texture  
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STANDARD Three  
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York, NY □ 10016  
USA

ASME B46.1 -  
Surface Texture  
(Surface  
Roughness,  
Waviness ...  
As described in  
ASME B46.1, Ra is

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the arithmetic average of the absolute values of the profile height deviations from the mean line, recorded within the evaluation length. Simply put, Ra is the average of a set of individual measurements of a surfaces peaks and valleys. Reveal the



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Ra formula for  
more insight.

ASME B46.1 /  
ANSI/ASME B1.2 -  
Surface Texture  
and Gaging ...  
Surface Metrology  
Guide - Surfaces  
and Profiles.  
Roughness  
Roughness  
includes the finest  
(shortest

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wavelength)  
irregularities of a  
surface. ...  
According to the  
ANSI B46.1  
standard a flaw is  
defined when  
agreed upon in ...  
Surface Metrology  
Guide - Surfaces  
and Profiles.  
Modified Profiles  
Modified Profile

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ISO vs. ASME: The Basics of Surface Profile Filtering  
an american national standard surface texture (surface roughness, waviness, and lay)  
asme b46.1-2002 (revision of asme b46.1-1995)

ASME B46.1-1985

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Surface Texture  
(Surface  
Roughness ...  
The ASME B46.1 /  
ANSI/ASME B1.2 -  
Surface Texture  
and Gaging for  
Screw Threads  
Package provides  
the surface  
texture, gaging,  
and dimension  
specifications for  
unified screw

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threads. It specifically supports surfaces produced by means such as abrading, casting, coating, cutting, etching, sintering and more.

ASME B46.1-2009  
Surface Roughness  
| Interferometry ...  
ASME B46.1-1985

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Surface Texture  
(Surface  
Roughness,  
Waviness, and Lay)  
Description This  
Standard is  
concerned with the  
geometric  
irregularities of  
surfaces of solid  
materials and  
physical specimens  
for gaging  
roughness, and the

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characteristics of  
instrumentation for  
measuring  
roughness.

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