



BSI Standards Publication

Roughness comparison specimens

Part 2: Specification for spark-eroded, shot-blasted, grit-blasted and polished specimens

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ISBN 978 0 580 69916 0

ICS 17.040.20

The following BSI references relate to the work on this standard:

Committee reference TDW/4

Draft for comment 10/30213638 DC

Publication history

First published November 1978

Second edition, February 1987

Third (present) edition, September 2010

Amendments issued since publication

Date	Text affected
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Summary of pages

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Foreword

Publishing information

This part of BS 2634 is published by BSI and came into effect on 30 September 2010. It was prepared by Subcommittee TDW/4/9, *Technical product verification*, under the authority of Technical Committee TDW/4, *Technical product realization*. A list of organizations represented on this committee can be obtained on request to its secretary.

Supersession

This part of BS 2634 supersedes BS 2634-2:1987, which is withdrawn.

Relationship with other publications

BS 2634 is published in two parts:

- Part 1: *Specification for turned, ground, bored, milled, shaped and planed specimens;*
- Part 2: *Specification for spark-eroded, shot-blasted, grit-blasted and polished specimens.*

Information about this document

BS 2634-2:1987 was dual numbered with ISO 2632-2:1985, which was withdrawn in 1997.

This is a full revision of BS 2634-2:1987, and introduces the recalibration of roughness comparison specimens after a period of use.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is "shall".

Commentary, explanation and general informative material is presented in smaller italic type, and does not constitute a normative element.

Contractual and legal considerations

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

1 Scope

This part of BS 2634 specifies the characteristics of roughness comparison specimens of spark-eroded, shot-blasted, grit-blasted and polished surfaces. These are intended for tactile and visual comparison with workpiece surfaces of similar lay that have been produced by similar manufacturing methods.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

BS 2634-1, *Roughness comparison specimens – Part 1: Specification for turned, ground, bored, milled, shaped and planed specimens*

BS EN ISO 4287:1998+A1:2009, *Geometrical product specification (GPS) – Surface texture – Profile method – Terms, definitions and surface texture parameters*

3 Terms and definitions

For the purposes of this part of BS 2634, the terms and definitions given in BS 2634-1 and BS EN ISO 4287:1998+A1 apply.

4 Methods of manufacture

The roughness comparison specimens shall be manufactured:

- a) by creating positive replicas of master surfaces which replicate the feel and appearance of the master surface, for instance by electro-forming; or
- b) by individually machining the roughness comparison specimens.

NOTE Individually machining a roughness comparison specimen involves directly applying the production process, which the roughness comparison specimen is intended to represent, to its surface.

5 Surface characteristics

Master surfaces intended for reproduction, their replicas and individually manufactured roughness comparison specimens (see Clause 4) shall exhibit only the characteristics resulting from the machining process that they are intended to represent. They shall not contain uncharacteristic surface irregularities visible by normal or corrected sight.