Rubert 130 Composite Set Surface Roughness Comparator

The most renowned set of Roughness Standards in the World.
Can be used in accordance with BS Specs & ISO.N numbers



Comparators allow the estimation of surface roughness, by both touch and sight. This set consists of 30 comparison specimens, covering six commonly used and important machining methods:6 Turned, 6 End-Milled, 6 Horizontally Milled, 6 Ground, 3 Lapped, 3 Reamed / Drilled

A label gives the Ra values of each specimen in both metric and imperial units. (Rz-value label available on request).The set is mounted in an attractive wallet with an instruction card

Applications

The Rubert 130 Surface Roughness Comparators are used by: Planning Managers, Planning Managers, Works Managers, Designers, Inspectors, Draughtsmen

In order to use the Composite Set in conjunction with Rubert Electro-Formed Surface Roughness Scales and Rubert Microsurf Plates, the same machining data have been applied when preparing the Specimens.

The Designer or Planning Engineer may thus specify a value of roughness and machining method selected from the Composite Set and the machinist who possesses a Rubert Surface Roughness Scale or Microsurf Plate appropriate to the machine he is using, will find specimens not only of the same machining method and roughness values but also exactly of the same surface texture.

There are, however 2 exceptions to this, the specimen for 0.4 um Ra, Reamed and Horizontal Milled are included in the Composite Set but excluded from the respective Scales No's 122 and 123.

Technical Specifications

Accuracy	30 specimens are calibrated in "u" (micro) Inch Ra (CLA) and in the metric equivalents um (micro) Ra They are accurate to within +/- 10% of the nominal values indicated, excluding instrumentation errors
Size	150 x 75 mm (easily carried in a pocket)
Weight	100 g
Designation & Markings	The values of the specimens are in accordance with the recommendations of the relative B.S. Specifications and are quoted in Micrometers Ra and micro-inches CLA in the English version, but the set is also issued with ISO 'N' numbers and Rt values
Instruction Card	On the instruction card given with each set the actual depth of irregularities (Rt) has been quoted against each Ra value, from which the ratio Rt:Ra varies considerably (from 4:1 to 10:1) and this information is sometimes of great assistance
Rubert 130 Composite Set	Set contains 30 specimens each approximately 22 x 9.5 mm comprises the following: 3 Specimen Flat Lapping - 0.05, 0.1 and 0.2 um Ra - (2-8 u" CLA) 3 Specimen Reaming - 0.4, 0.8 and 1.6 un Ra (16-63 u" CLA) 6 Specimen Grinding - 0.05, 0.1, 0.2, 0.4. 0.8 and 1.6 um Ra - (2-63 u" CLA) 6 Specimen Horizontal Milling - 0.4, 0.8, 1.6, 3.2, 6.3 and 12.5 um Ra - (16-500 u" CLA) 6 Specimen Vertical Milling - 0.4, 0.8, 1.6, 3.2, 6.3 and 12.5 um Ra - (16-500 u" CLA) 6 Specimen Turning - 0.4, 0.8, 1.6, 3.2, 6.3 and 12.5 um Ra - (16-500 u" CLA)