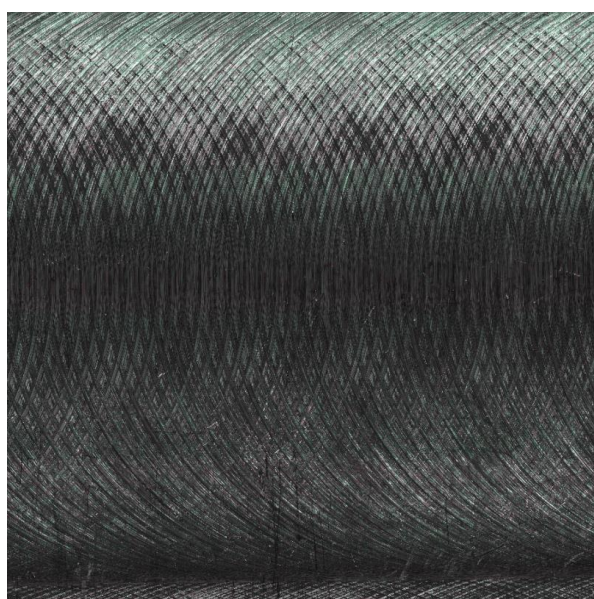


Výsledky měření

Vzorek 1 - $v_c = 90 \text{ m} \cdot \text{min}^{-1}$, $f_z = 0,05 \text{ mm}$

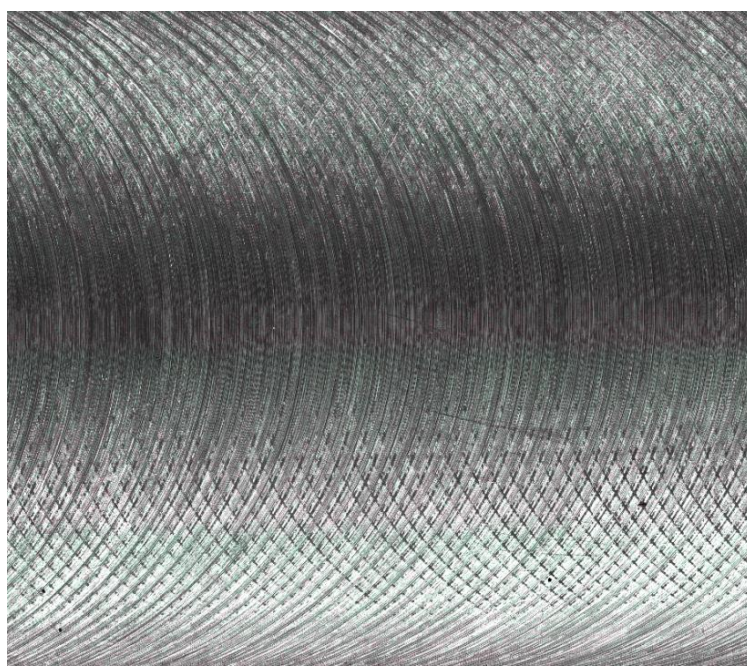
Parametr	Hodnota	Parametr	Hodnota
Ra [μm]	2,545	Sa [μm]	2,309
Rq [μm]	3,424	Sq [μm]	3,134
Rz [μm]	24,796	Sz [μm]	48,127
Rp [μm]	16,575	Sp [μm]	26,311
Rv [μm]	11,806	Sv [μm]	21,817
Rsk	0,921	Ssk [μm]	0,827
Rku	4,678	Sku [μm]	5,782
Rk [μm]	6,807	Sk [μm]	6,578
Rpk [μm]	6,084	Spk [μm]	5
Rvk [μm]	2,767	Svk [μm]	2,977
Rmr1 (%)	15,59	Smr1 (%)	13,44
Rmr2 (%)	91,61	Smr2 (%)	90,67



Povrch vzorku 1.

Vzorek 2 - $v_c = 200 \text{ m} \cdot \text{min}^{-1}$, $f_z = 0,05 \text{ mm}$

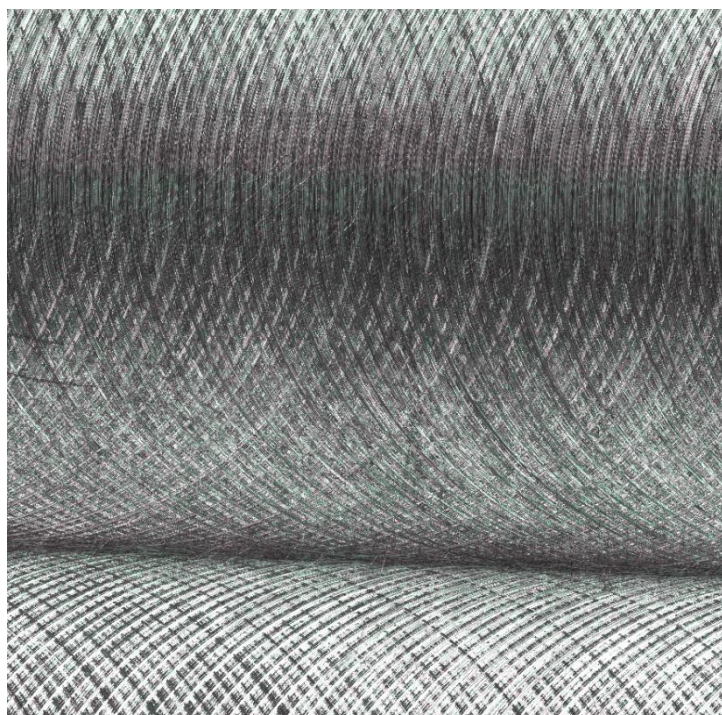
Parametr	Hodnota	Parametr	Hodnota
Ra [μm]	2,71	Sa [μm]	2,595
Rq [μm]	3,489	Sq [μm]	45,379
Rz [μm]	23,523	Sz [μm]	72,148
Rp [μm]	15,358	Sp [μm]	45,379
Rv [μm]	13,234	Sv [μm]	26,769
Rsk	0,135	Ssk [μm]	0,223
Rku	3,628	Sku [μm]	4,942
Rk [μm]	8,368	Sk [μm]	7,982
Rpk [μm]	4	Spk [μm]	4,265
Rvk [μm]	3,513	Svk [μm]	3,659
Rmr1 (%)	10,25	Smr1 (%)	9,85
Rmr2 (%)	88,86	Smr2 (%)	88,73



Povrch vzorku 2.

Vzorek 3 - $v_c = 400 \text{ m} \cdot \text{min}^{-1}$, $f_z = 0,05 \text{ mm}$

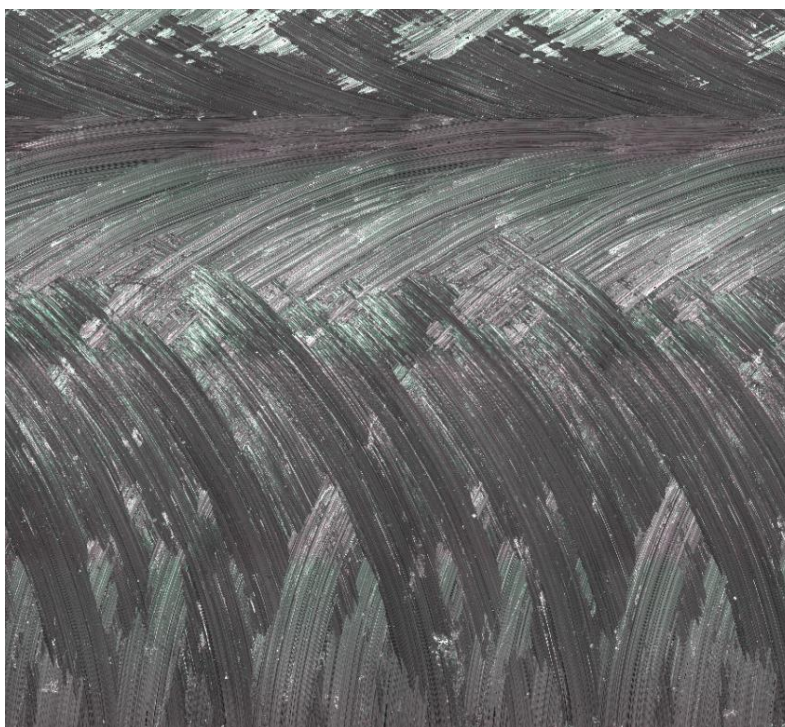
Parametr	Hodnota	Parametr	Hodnota
Ra [μm]	1,632	Sa [μm]	1,998
Rq [μm]	2,139	Sq [μm]	2,641
Rz [μm]	15,594	Sz [μm]	80,610
Rp [μm]	10,729	Sp [μm]	32,243
Rv [μm]	9,022	Sv [μm]	48,367
Rsk	0,025	Ssk [μm]	0,635
Rku	4,14	Sku [μm]	6,153
Rk [μm]	4,9	Sk [μm]	5,965
Rpk [μm]	2,509	Spk [μm]	3,728
Rvk [μm]	2,499	Svk [μm]	2,537
Rmr1 (%)	10,82	Smr1 (%)	13,12
Rmr2 (%)	88,77	Smr2 (%)	91,83



Povrch vzorku 3.

Vzorek 4 - $v_c = 90 \text{ m} \cdot \text{min}^{-1}$, $f_z = 0,5 \text{ mm}$

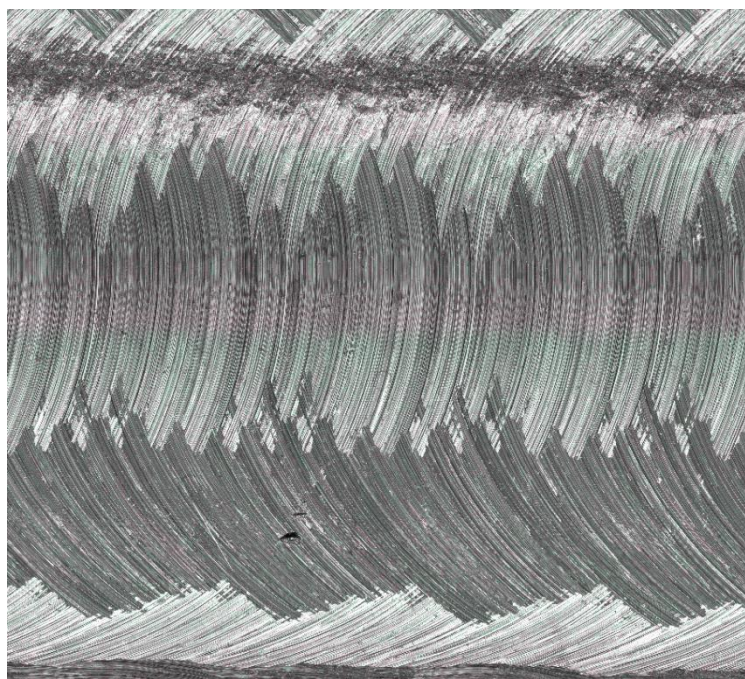
Parametr	Hodnota	Parametr	Hodnota
Ra [μm]	1,951	Sa [μm]	2,486
Rq [μm]	2,431	Sq [μm]	3,056
Rz [μm]	15,453	Sz [μm]	21,467
Rp [μm]	9,068	Sp [μm]	11,226
Rv [μm]	9,186	Sv [μm]	10,241
Rsk	-0,098	Ssk [μm]	-0,290
Rku	3,015	Sku [μm]	2,567
Rk [μm]	6,535	Sk [μm]	8,387
Rpk [μm]	2,125	Spk [μm]	1,610
Rvk [μm]	2,343	Svk [μm]	2,993
Rmr1 (%)	9,24	Smr1 (%)	6,38
Rmr2 (%)	91,7	Smr2 (%)	88,61



Povrch vzorku 4.

Vzorek 5 - $v_c = 200 \text{ m} \cdot \text{min}^{-1}$, $f_z = 0,5 \text{ mm}$

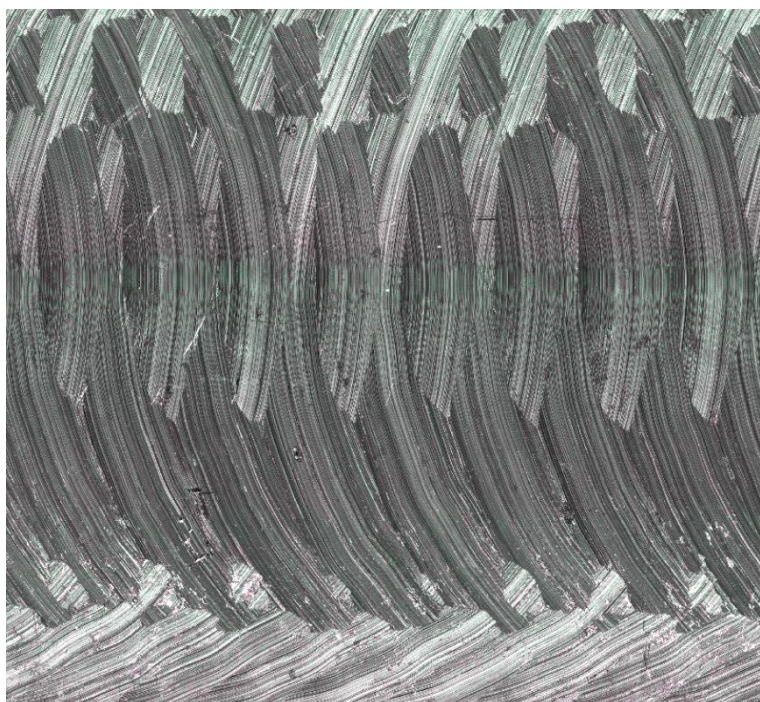
Parametr	Hodnota	Parametr	Hodnota
Ra [μm]	3,334	Sa [μm]	3,561
Rq [μm]	4,242	Sq [μm]	4,625
Rz [μm]	28,207	Sz [μm]	69,153
Rp [μm]	18,137	Sp [μm]	40,646
Rv [μm]	14,628	Sv [μm]	28,507
Rsk	0,112	Ssk [μm]	0,030
Rku	3,395	Sku [μm]	4,013
Rk [μm]	10,655	Sk [μm]	10,956
Rpk [μm]	4,615	Spk [μm]	5,201
Rvk [μm]	4,183	Svk [μm]	5,310
Rmr1 (%)	10,12	Smr1 (%)	10,14
Rmr2 (%)	90,36	Smr2 (%)	88,71



Povrch vzorku 5.

Vzorek 6 - $v_c = 90 \text{ m} \cdot \text{min}^{-1}$, $f_z = 0,9 \text{ mm}$

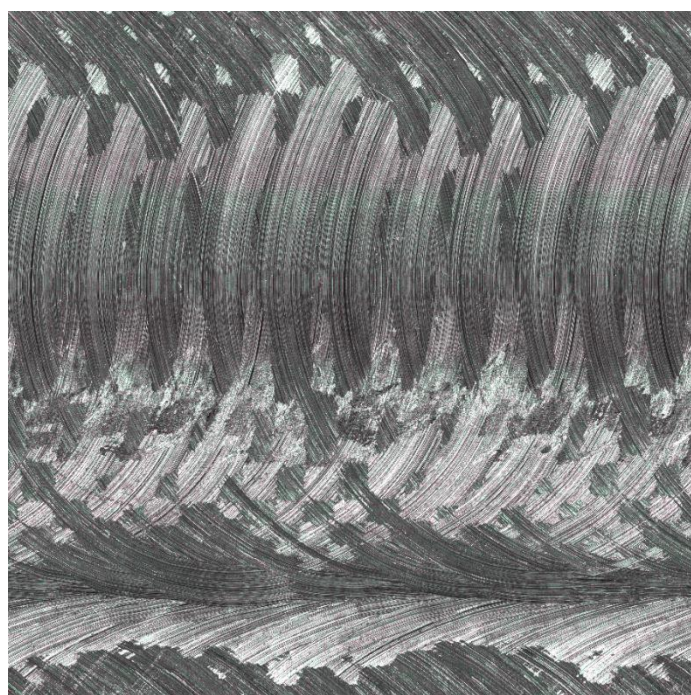
Parametr	Hodnota	Parametr	Hodnota
Ra [μm]	3,944	Sa [μm]	4,812
Rq [μm]	4,534	Sq [μm]	5,998
Rz [μm]	20,761	Sz [μm]	57,741
Rp [μm]	15,513	Sp [μm]	30,778
Rv [μm]	9,852	Sv [μm]	26,964
Rsk	0,276	Ssk [μm]	0,022
Rku	1,941	Sku [μm]	2,985
Rk [μm]	11,525	Sk [μm]	16,137
Rpk [μm]	3,766	Spk [μm]	5,546
Rvk [μm]	1,385	Svk [μm]	5,335
Rmr1 (%)	19,21	Smr1 (%)	9,03
Rmr2 (%)	96,73	Smr2 (%)	91,3



Povrch vzorku 6.

Vzorek 7 - $v_c = 200 \text{ m} \cdot \text{min}^{-1}$, $f_z = 0,9 \text{ mm}$

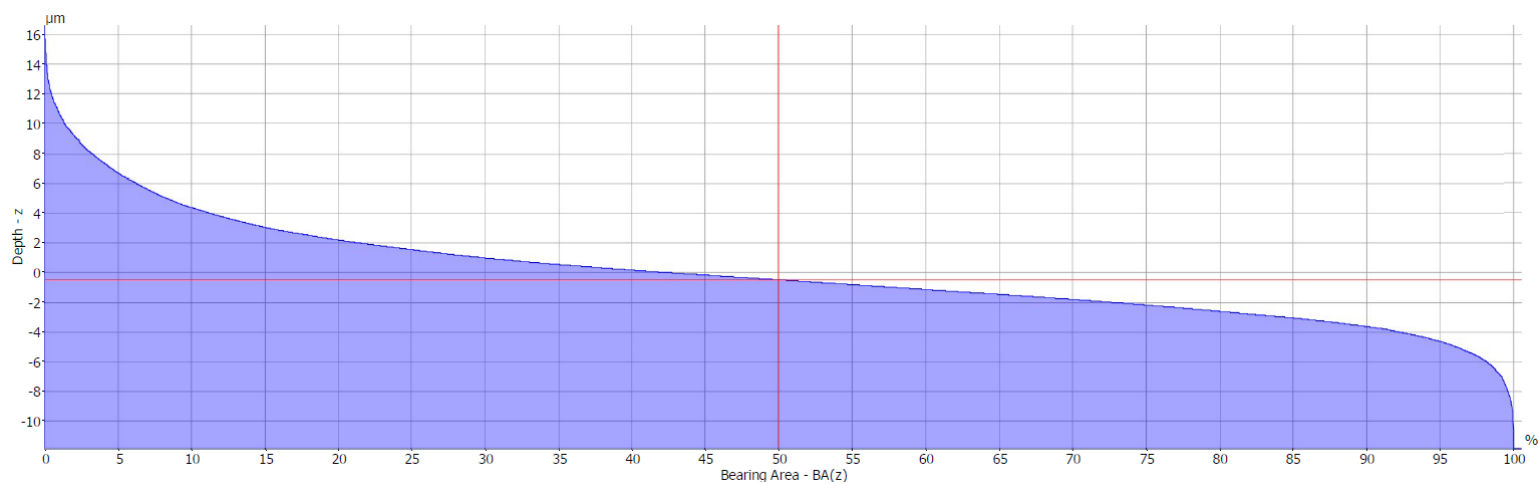
Parametr	Hodnota	Parametr	Hodnota
Ra [μm]	4,303	Sa [μm]	5,306
Rq [μm]	5,267	Sq [μm]	6,433
Rz [μm]	29,349	Sz [μm]	68,098
Rp [μm]	16,856	Sp [μm]	32,750
Rv [μm]	16,924	Sv [μm]	35,347
Rsk	0,217	Ssk [μm]	0,276
Rku	2,566	Sku [μm]	2,521
Rk [μm]	13,434	Sk [μm]	17,834
Rpk [μm]	4,767	Spk [μm]	5,822
Rvk [μm]	3,580	Svk [μm]	3,647
Rmr1 (%)	14,93	Smr1 (%)	12
Rmr2 (%)	92,73	Smr2 (%)	94,51



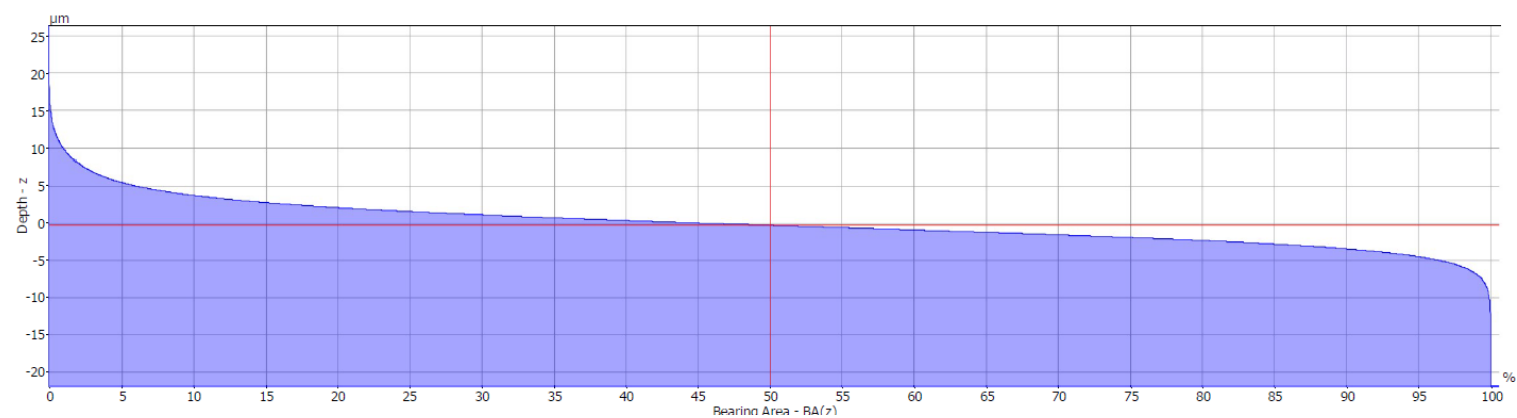
Povrch vzorku 7.

Křivky materiálového poměru

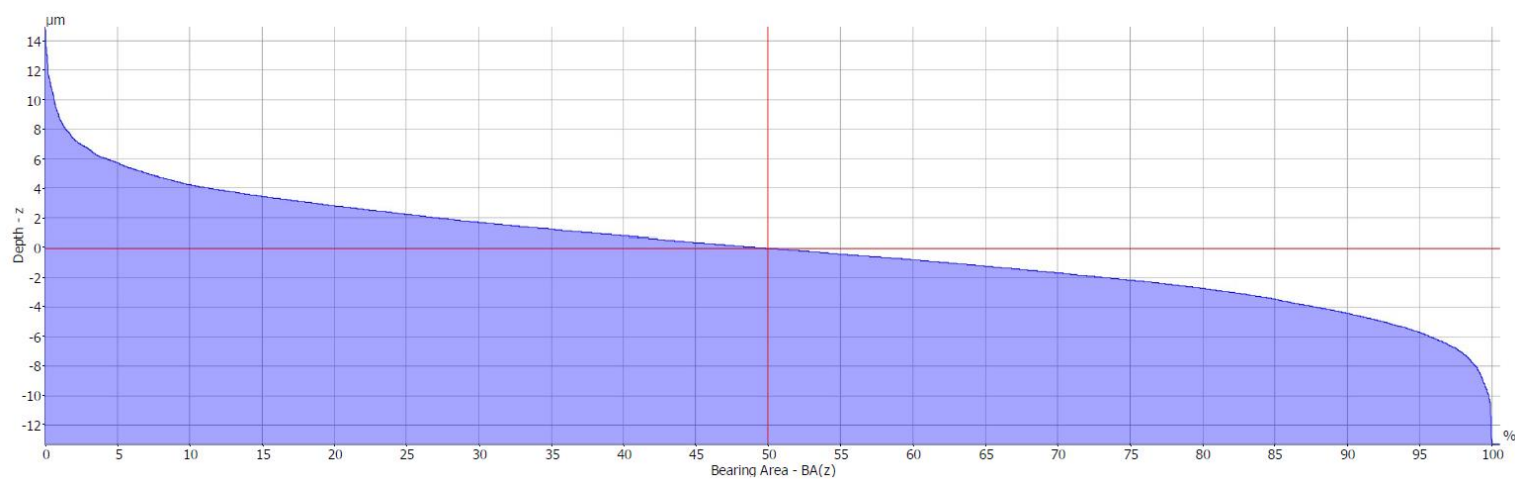
Vzorek 1 - profilová



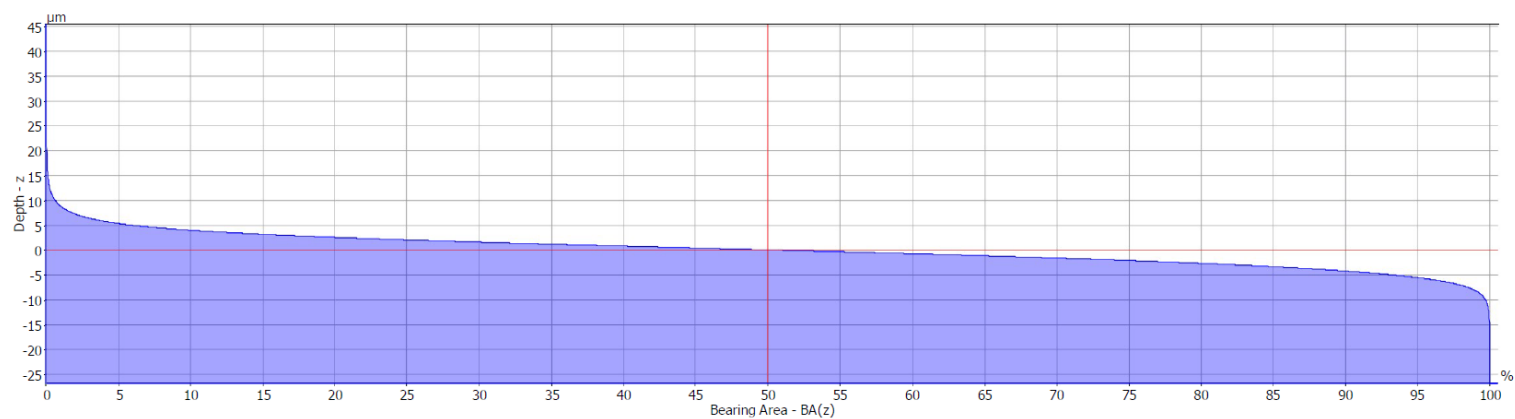
Vzorek 1 - plošná



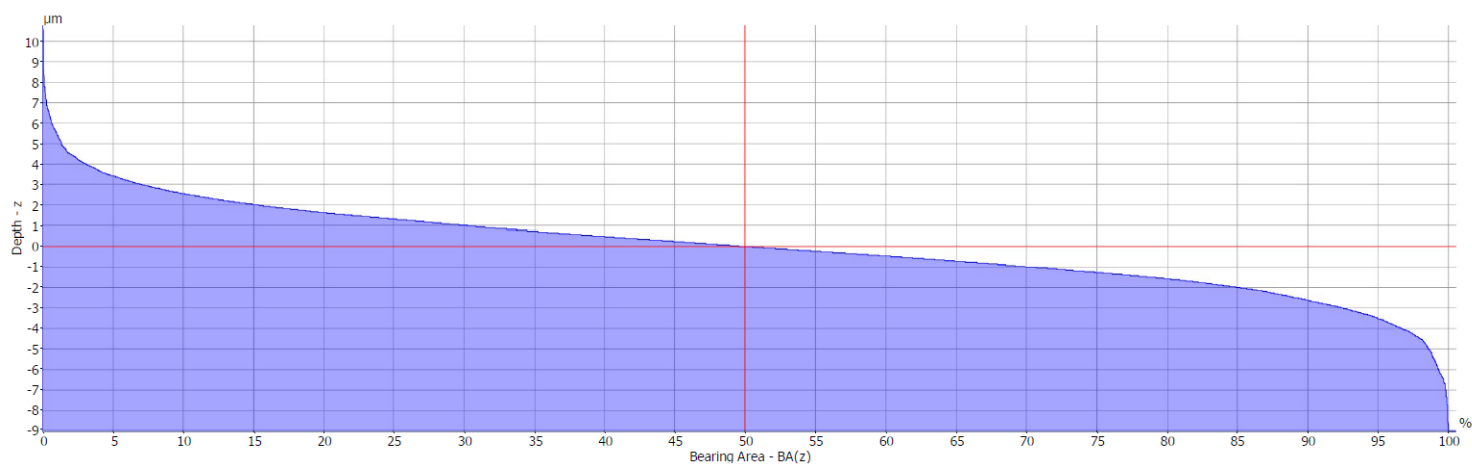
Vzorek 2 - profilová



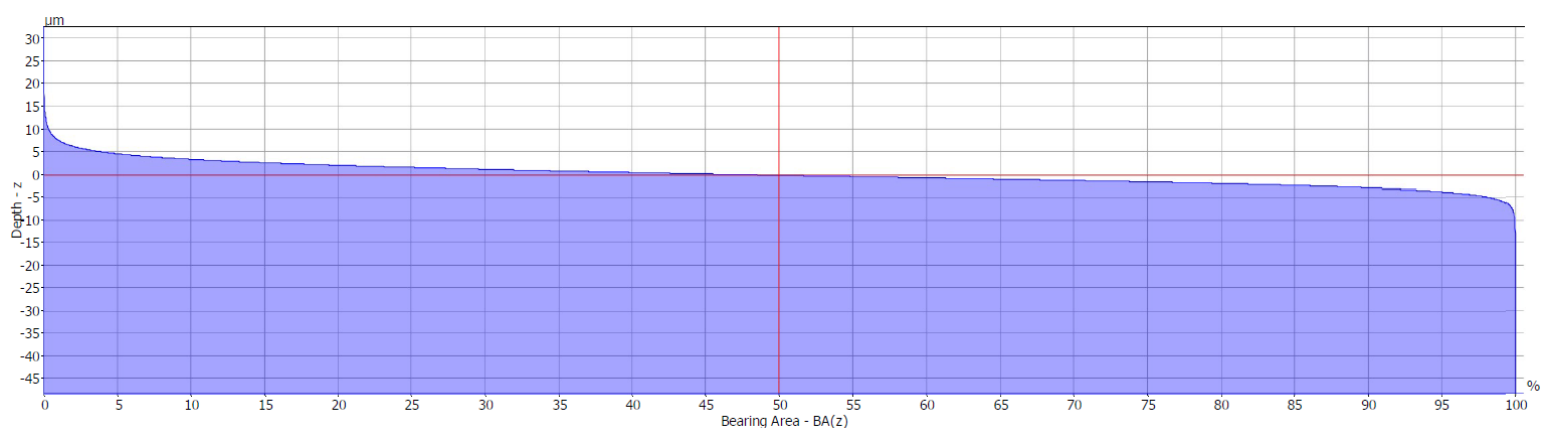
Vzorek 2 - plošná



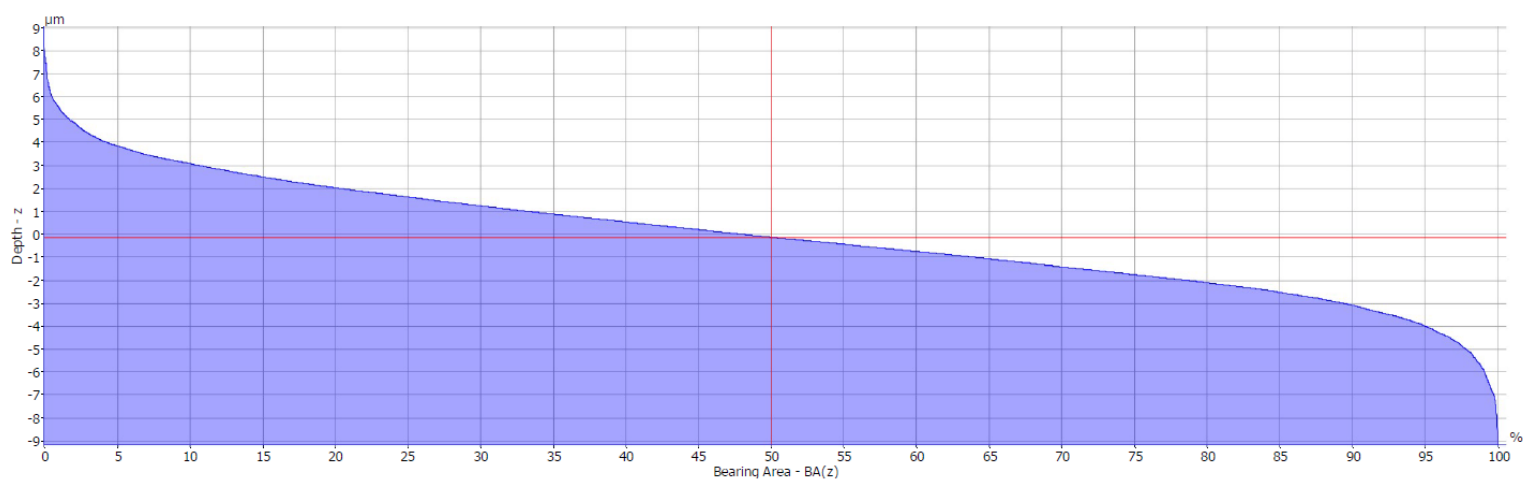
Vzorek 3 - profilová



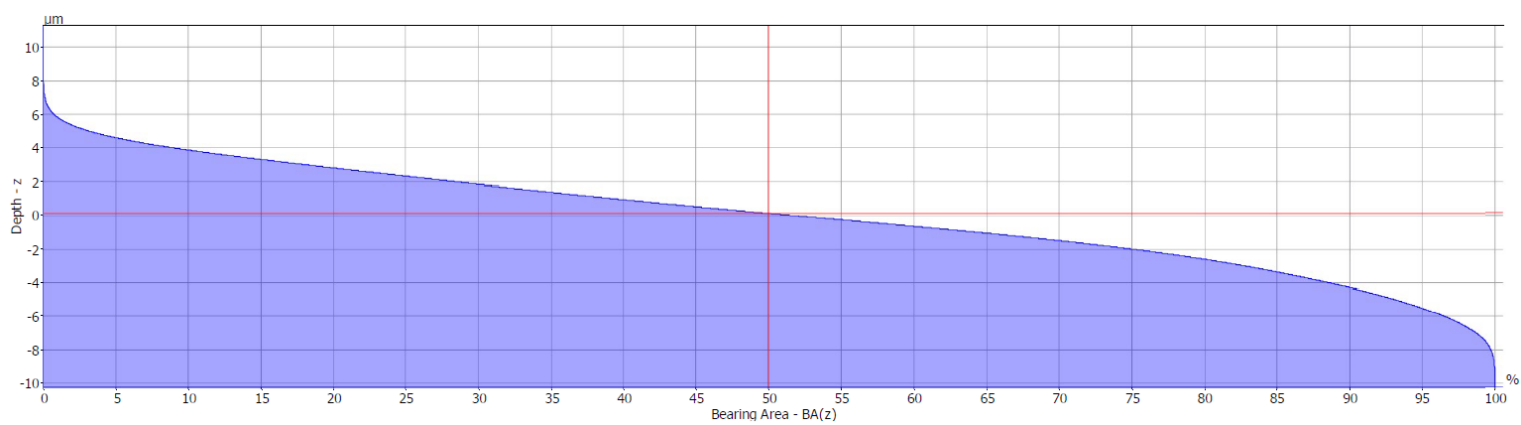
Vzorek 3 - plošná



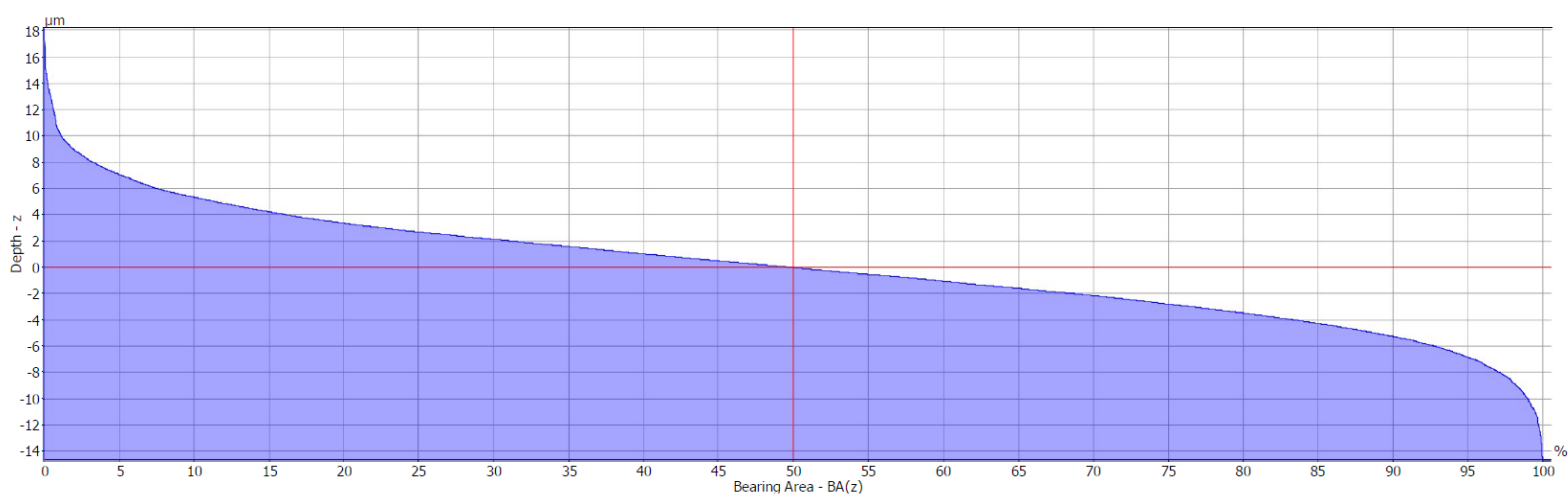
Vzorek 4 - profilová



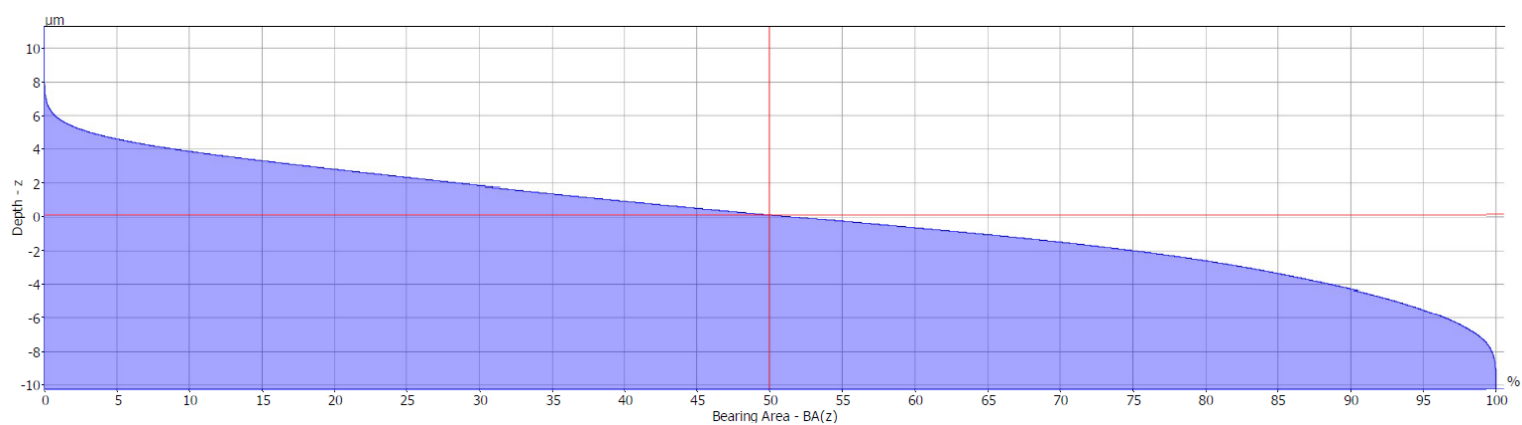
Vzorek 4 - plošná



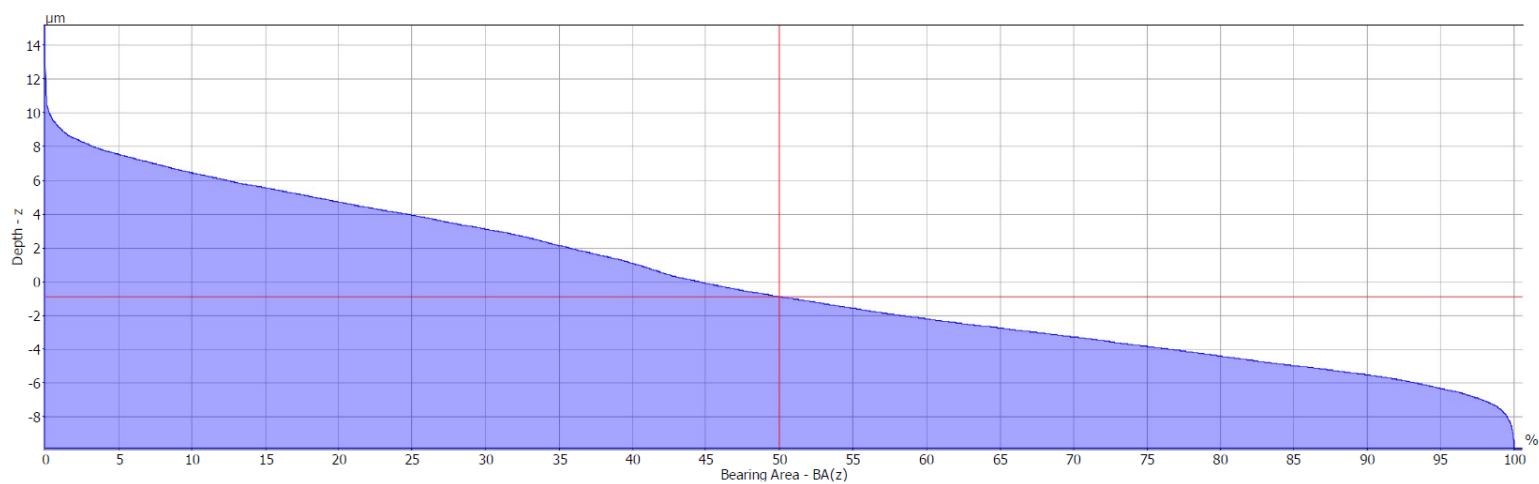
Vzorek 5 - profilová



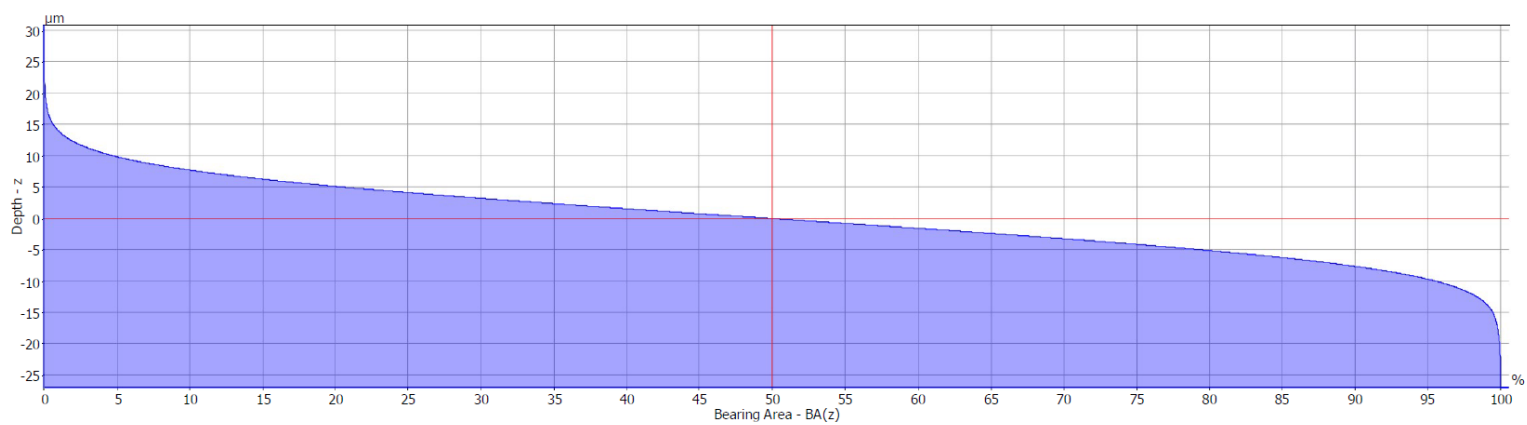
Vzorek 5 - plošná



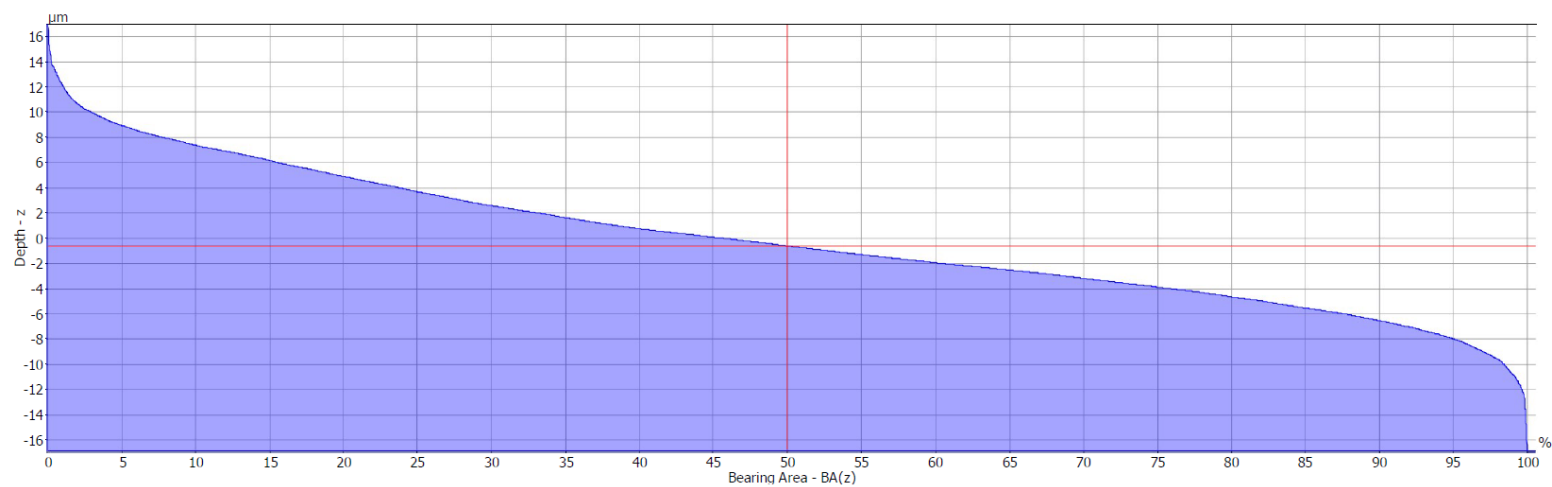
Vzorek 6 - profilová



Vzorek 6 - plošná



Vzorek 7 - profilová



Vzorek 7 - plošná

