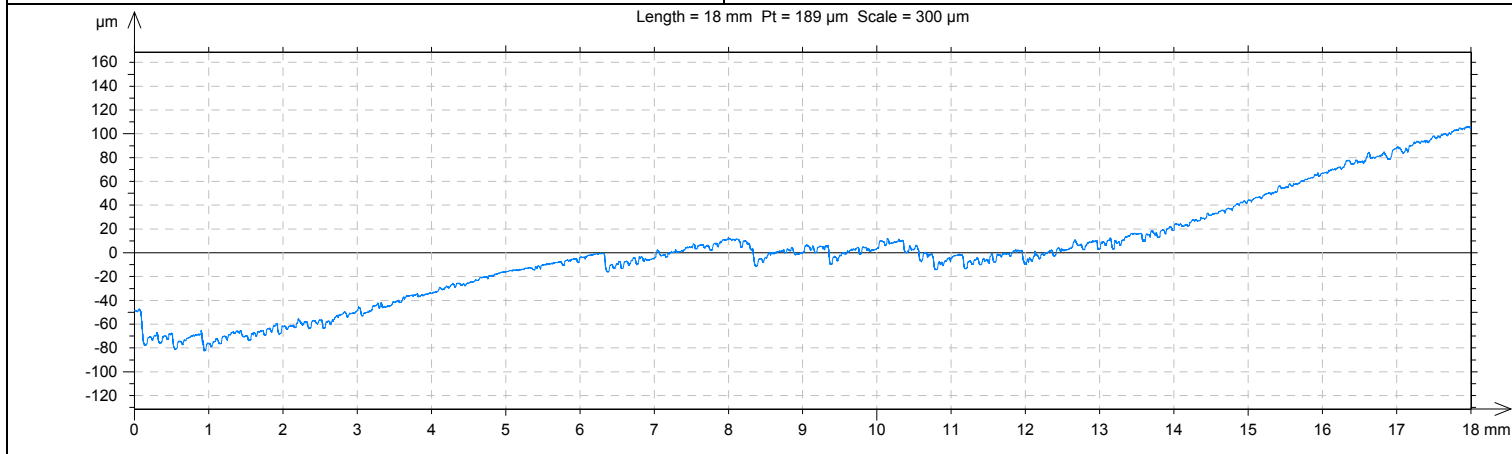
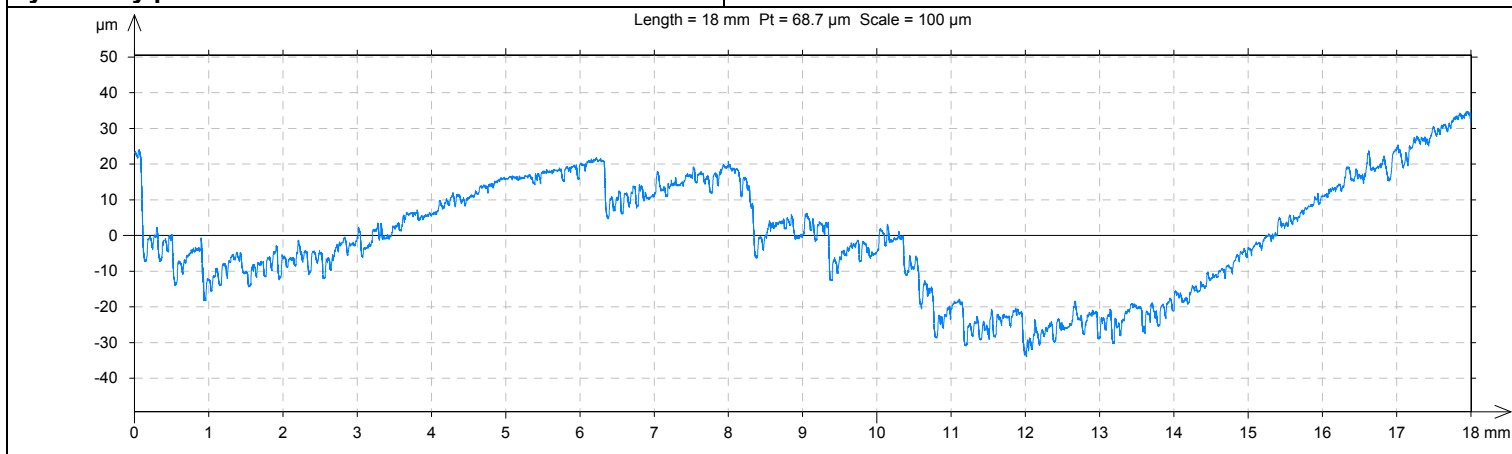


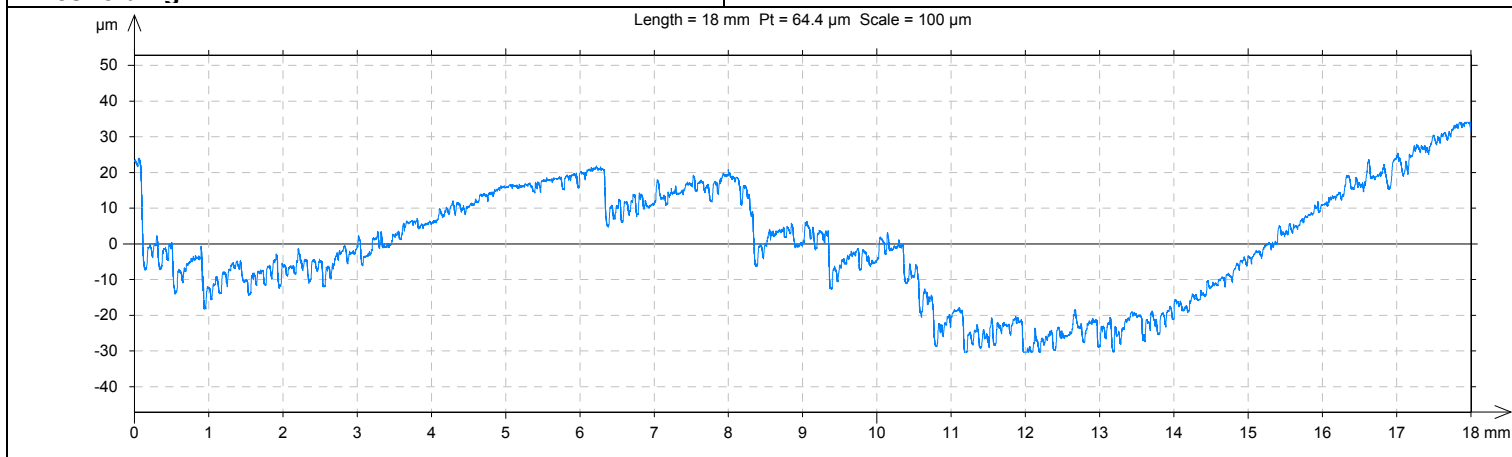
## Změřený profil



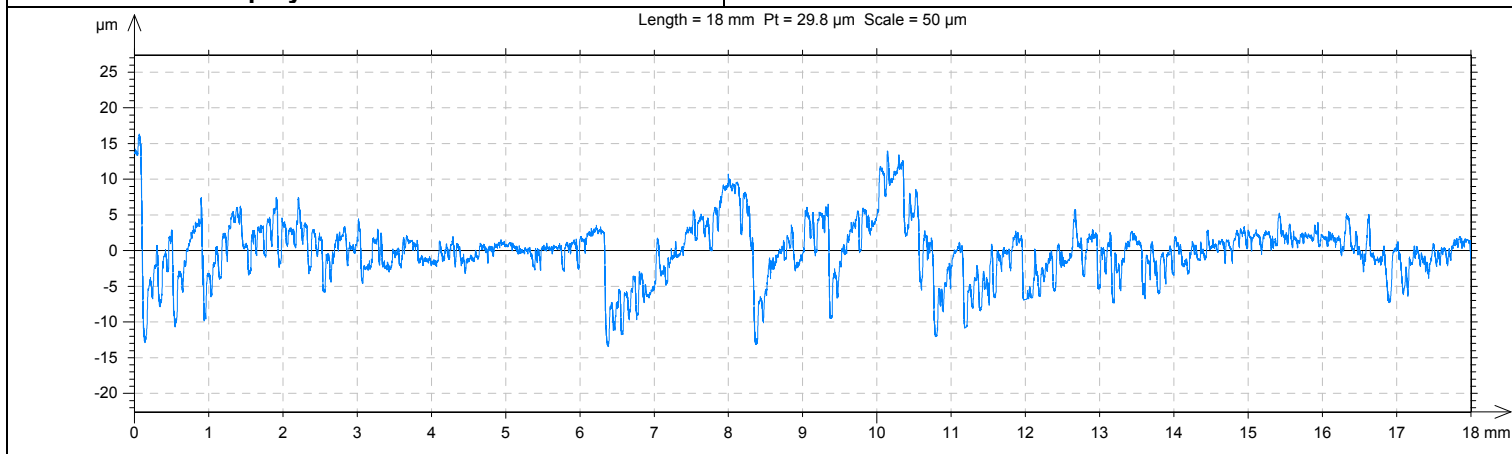
## Vyrovnaný profil



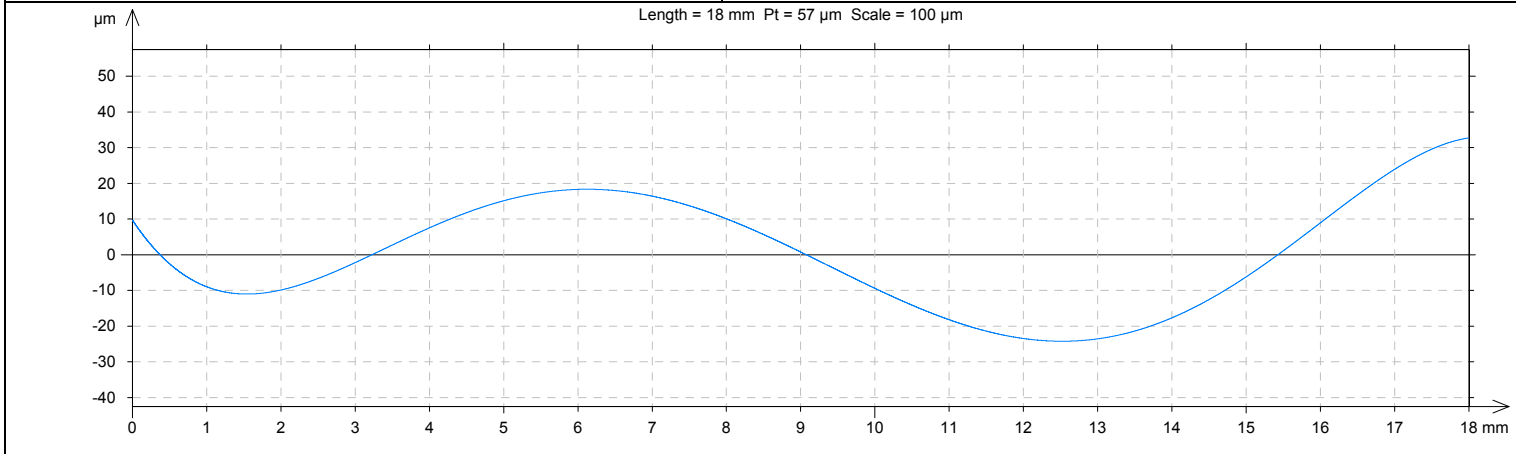
## Thresholding



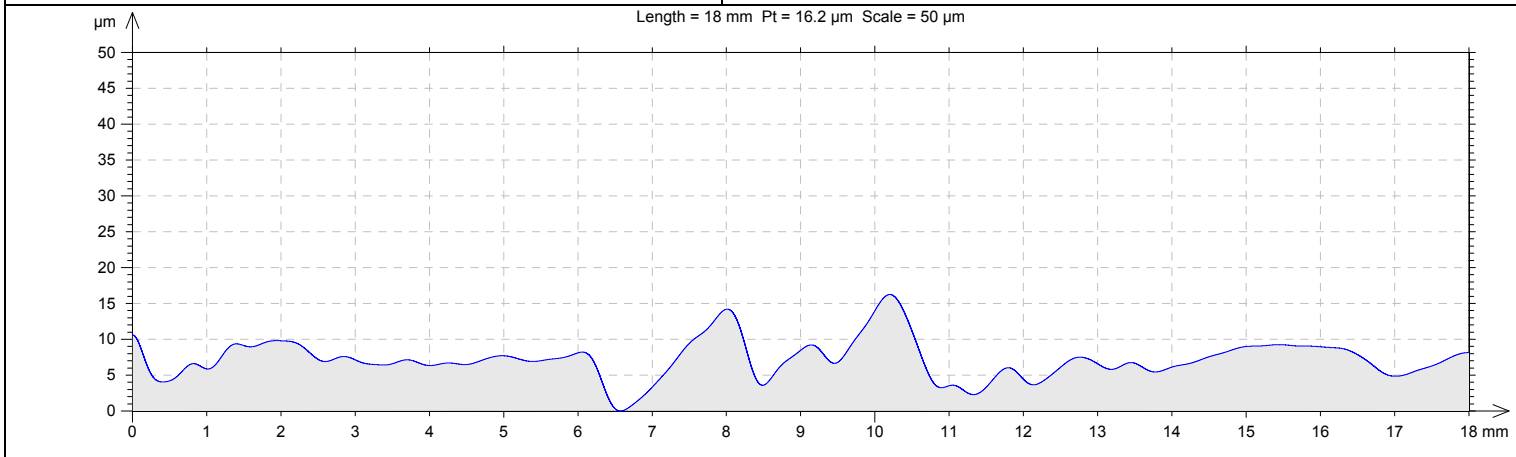
## Odstranění tvaru - polynomem 5. řádu



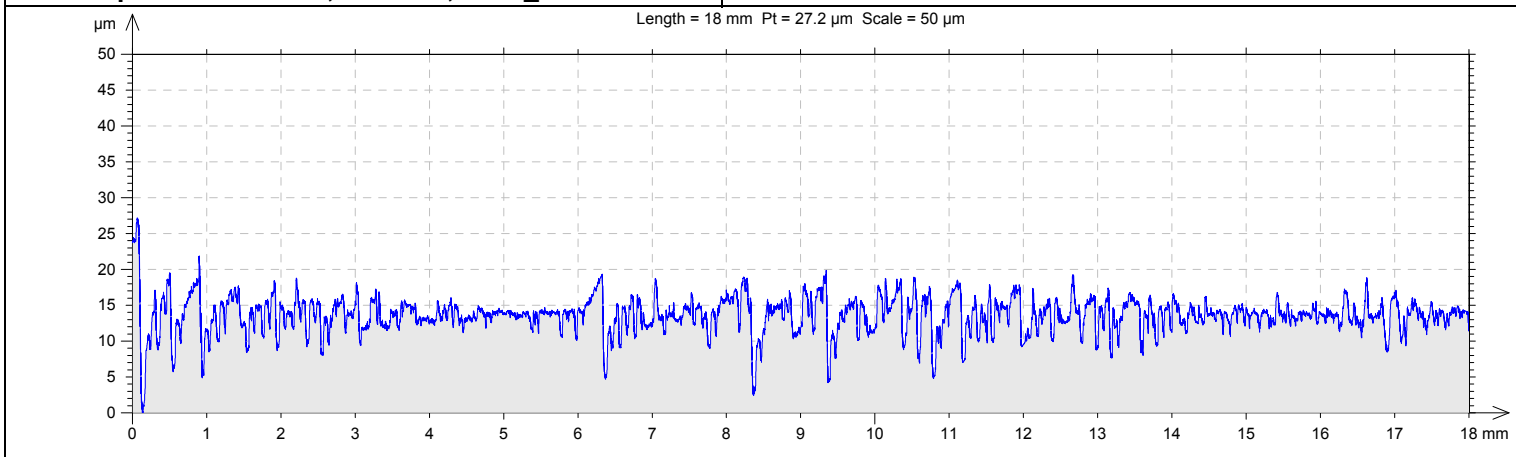
Samotný tvar
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**Vlnitost povrchu - Gauss, cut-off 0,8 mm\_celá díra**



**Drsnost povrchu - Gauss, cut-off 0,8 mm\_celá díra**



**Parameters calculated on the profile dira 4XA\_2 > ... >  
Roughness, Gaussian Filter, 0.8 mm**

- \* Parameters calculated as average value of all sampling lengths.
- \* A microroughness filtering is used, with a ratio of 2.5  $\mu\text{m}$ .

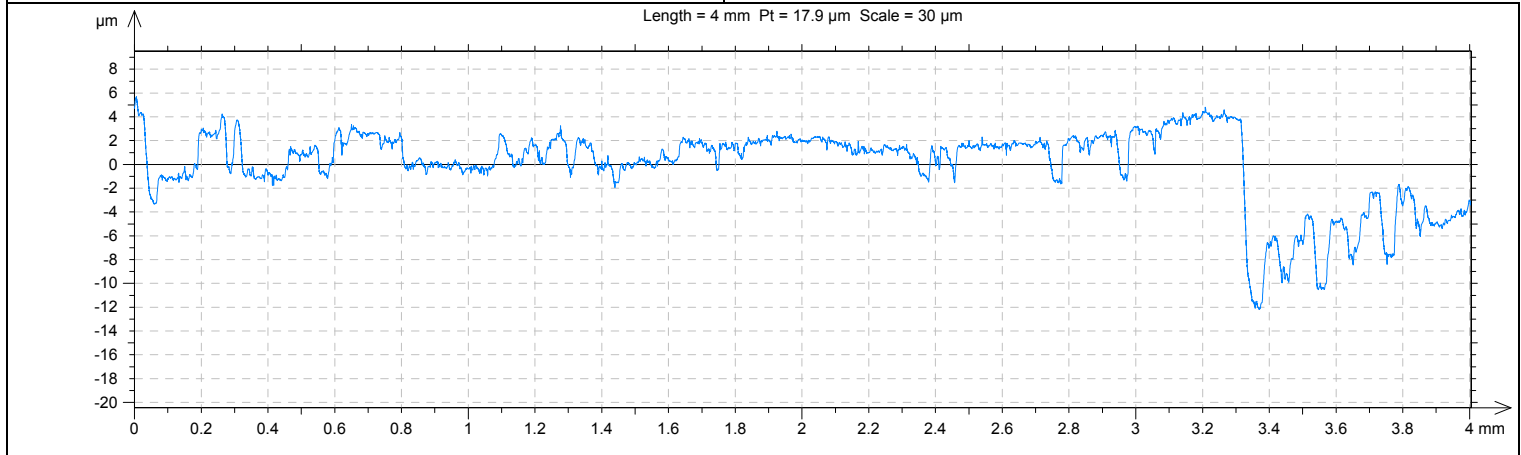
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 1.6  $\mu\text{m}$   
 Ra: Arithmetic Mean Deviation of the roughness profile.  
 Rz = 9.46  $\mu\text{m}$   
 Rz: Maximum Height of roughness profile.  
 RSm = 0.112 mm  
 RSm: Mean Width of the roughness profile elements.

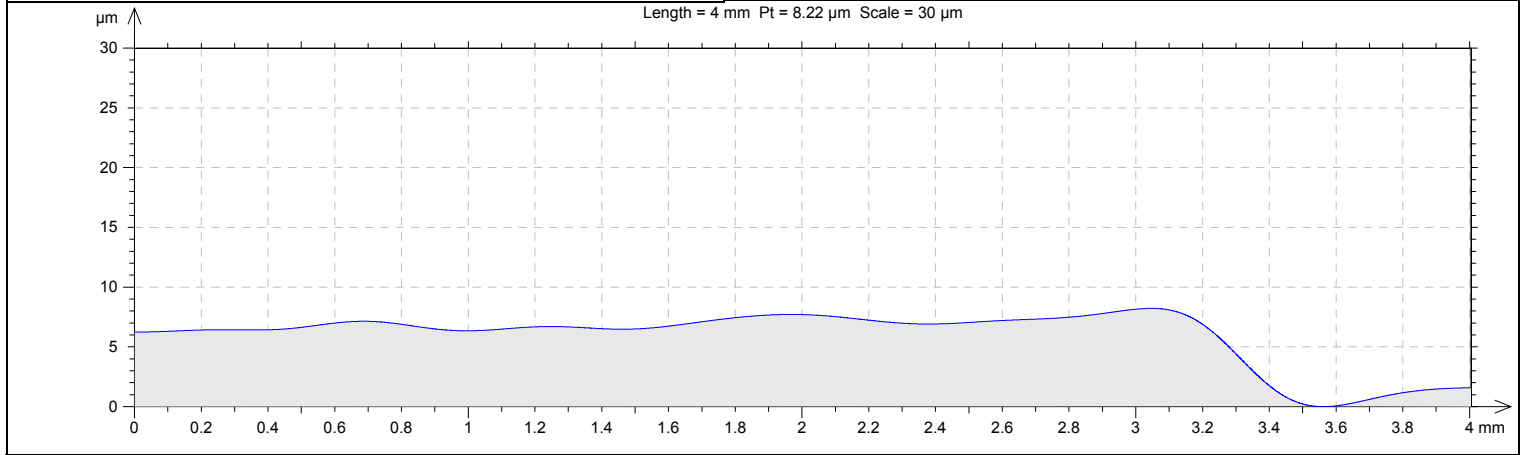
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.303  $\mu\text{m}$   
 Wa: Arithmetic Mean Deviation of the waviness profile.  
 Wz = 1.09  $\mu\text{m}$   
 Wz: Maximum Height of waviness profile.  
 WSm = 0.902 mm  
 WSm: Mean Width of the waviness profile elements.

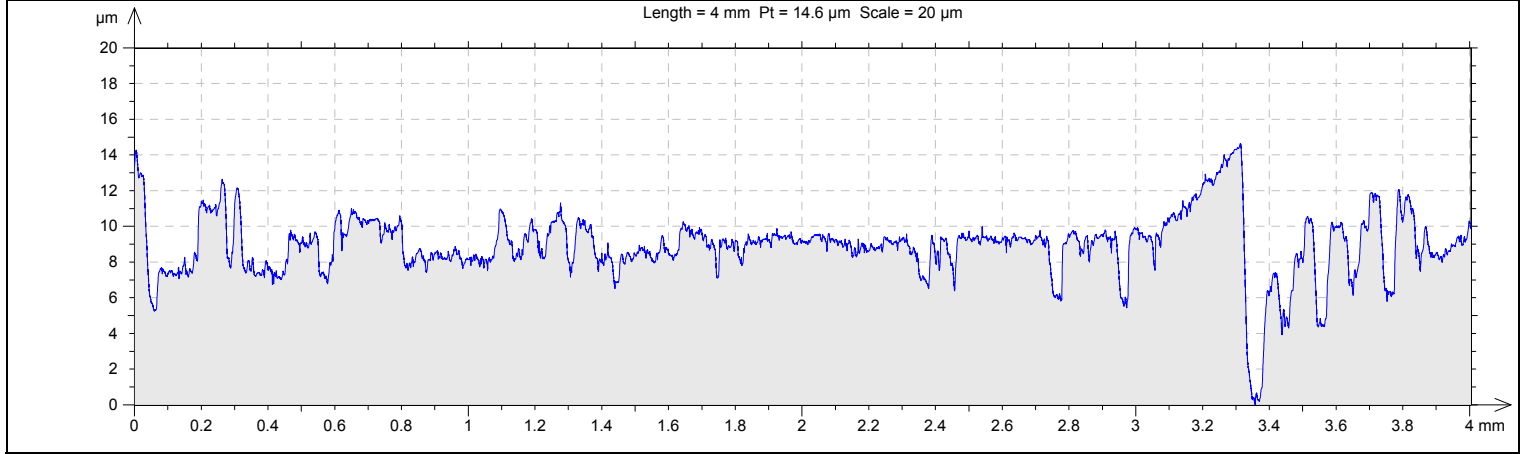
### Samotná drsnost\_výjezd vrtáku



### Vlnitost povrchu - Gauss, cut-off 0,8 mm\_výjezd vrtáku



### Drsnost povrchu - Gauss, cut-off 0,8 mm\_výjezd vrtáku



## Parametry drsnosti\_výjezd vrtáku

### Parameters calculated on the profile díra 4XA\_2 > ... > Roughness, Gaussian Filter, 0.8 mm

\* Parameters calculated as average value of all sampling lengths.  
\* A microroughness filtering is used, with a ratio of 2.5  $\mu\text{m}$ .

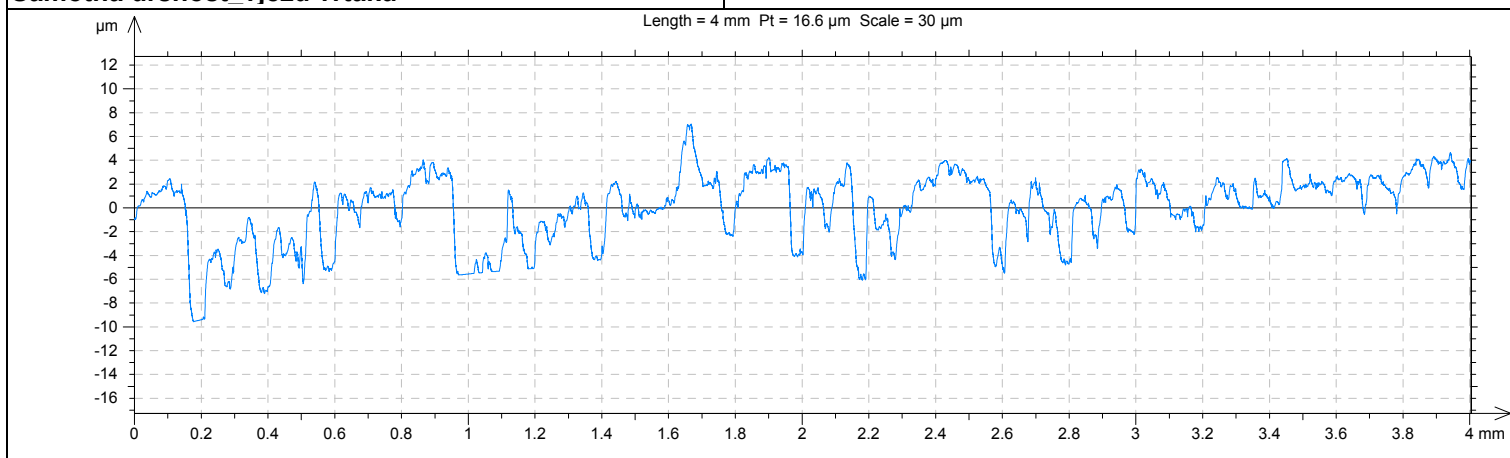
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 0.982  $\mu\text{m}$   
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 6.76  $\mu\text{m}$   
Rz: Maximum Height of roughness profile.  
RSm = 0.0949 mm  
RSm: Mean Width of the roughness profile elements.

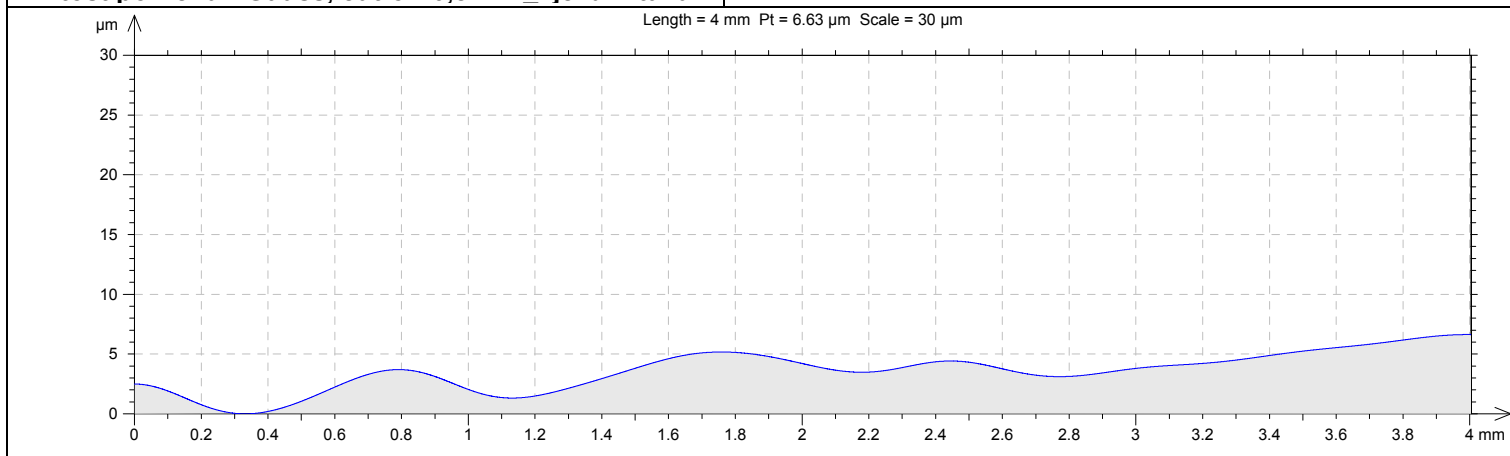
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.248  $\mu\text{m}$   
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 0.866  $\mu\text{m}$   
Wz: Maximum Height of waviness profile.  
WSm = 0.798 mm  
WSm: Mean Width of the waviness profile elements.

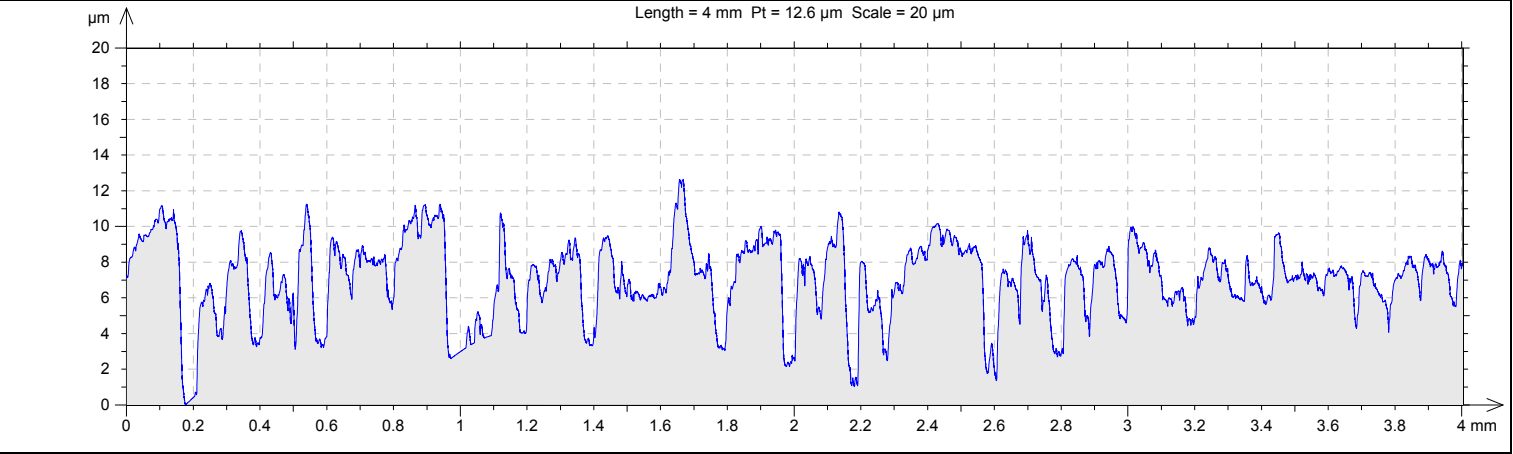
## Samotná drsnost vjezd vrtáku



## Vlnitost povrchu - Gauss, cut-off 0,8 mm vjezd vrtáku



Drsnost povrchu - Gauss, cut-off 0,8 mm\_vjezd vrtáku



Parametry drsnosti\_vjezd vrtáku

Parameters calculated on the profile dira  
4XA\_2 > ... > Roughness, Gaussian Filter, 0.8  
mm

\* Parameters calculated as average value of all sampling lengths.  
\* A microroughness filtering is used, with a ratio of 2.5 µm.

Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 1.63 µm  
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 8.84 µm  
Rz: Maximum Height of roughness profile.  
RSm = 0.103 mm  
RSm: Mean Width of the roughness profile elements.

Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.257 µm  
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 0.892 µm  
Wz: Maximum Height of waviness profile.  
WSm = 0.649 mm  
WSm: Mean Width of the waviness profile elements.