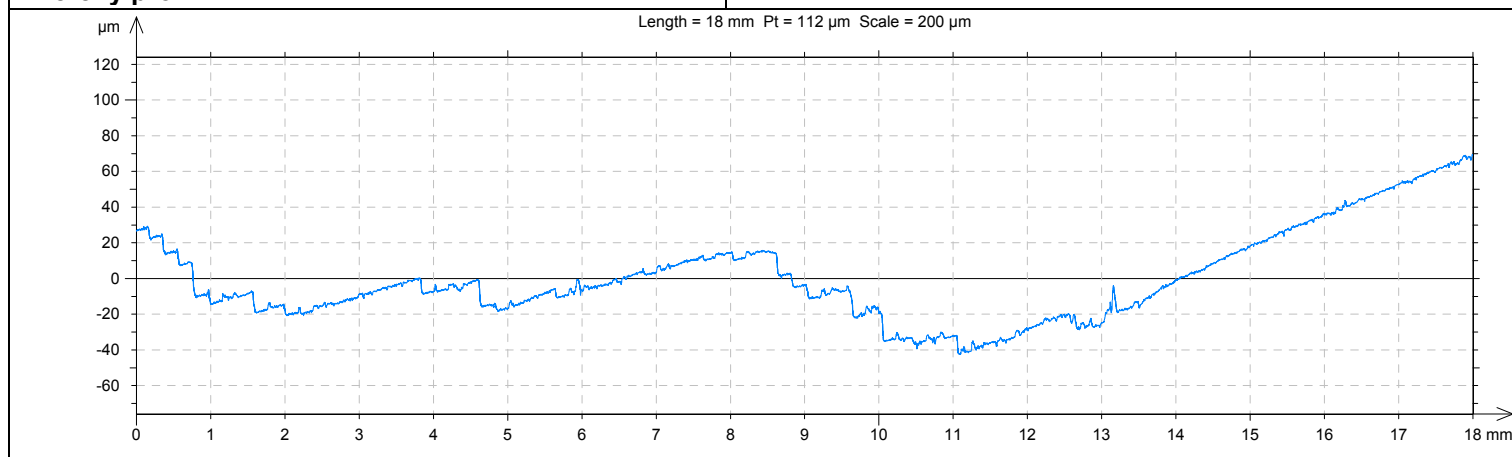
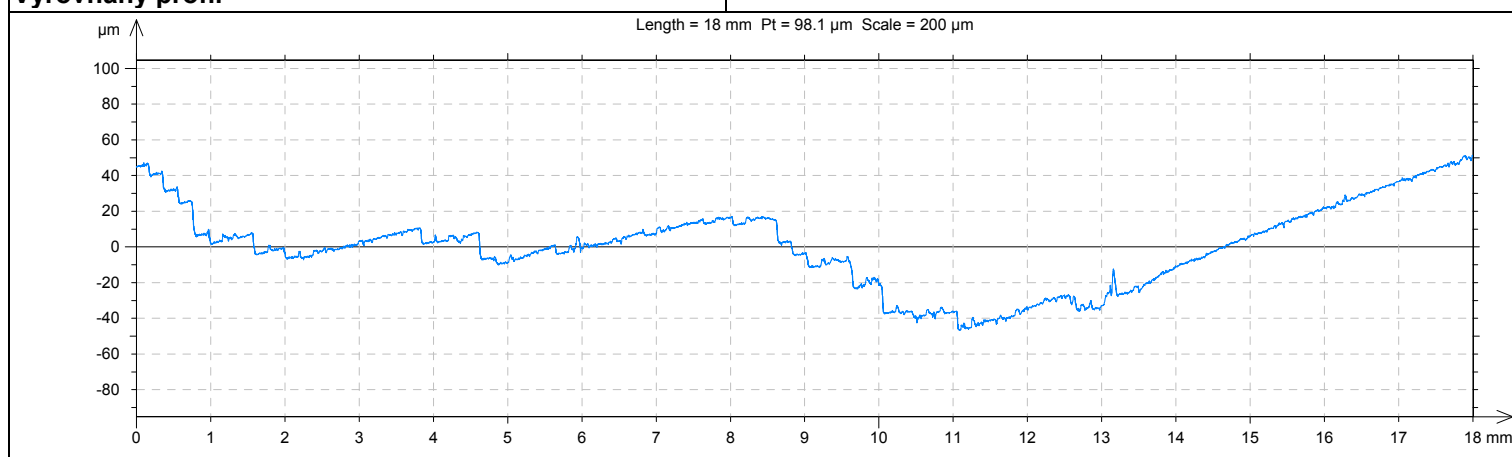


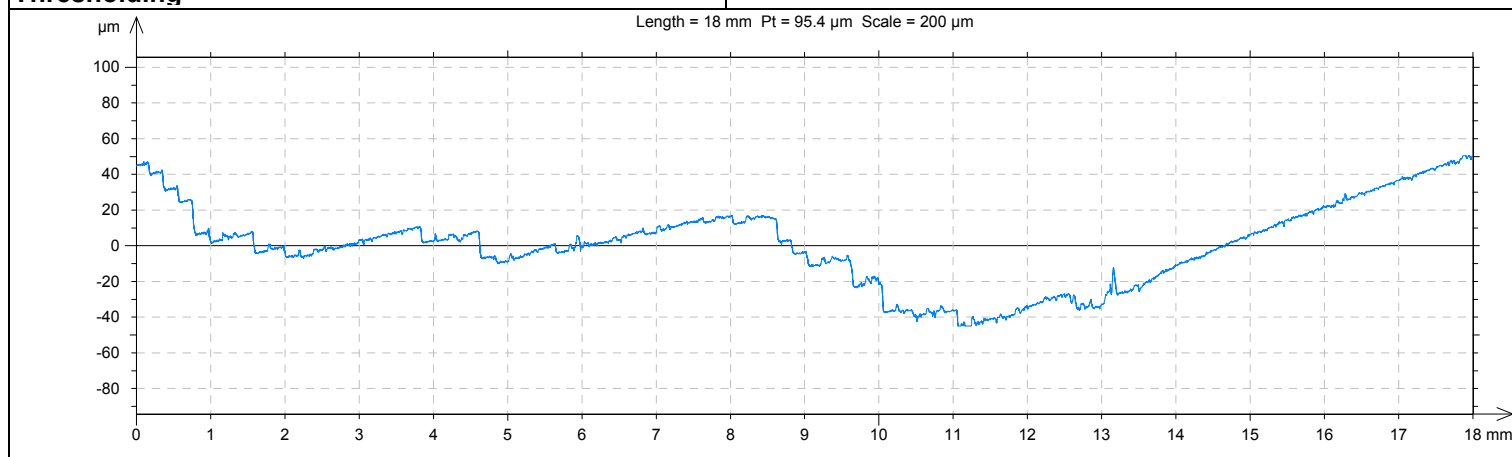
## Změřený profil



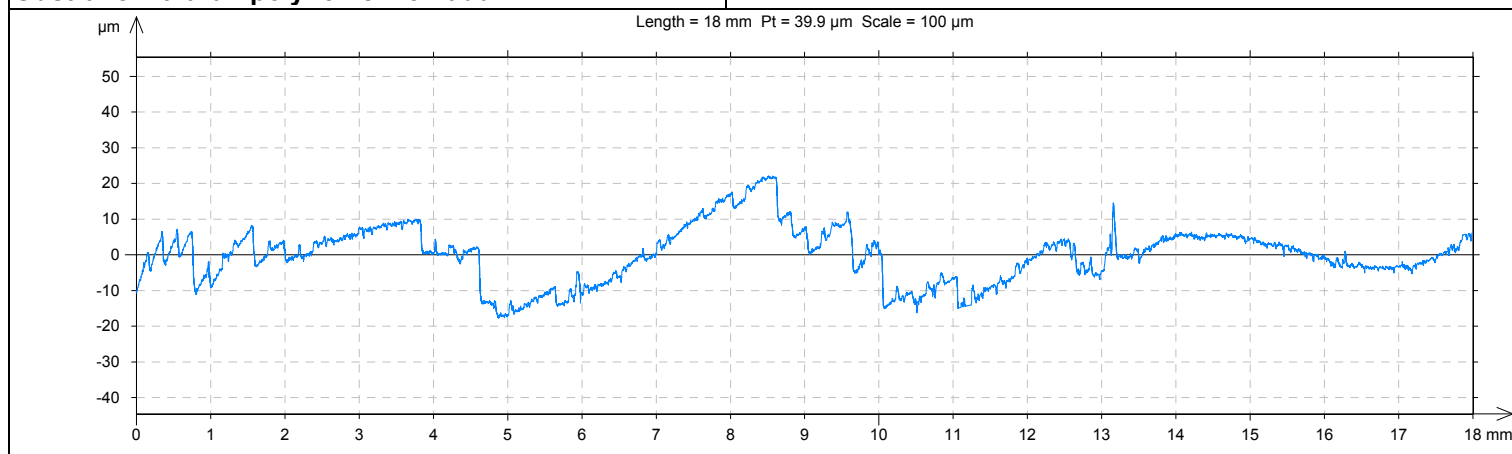
## Vyrovnaný profil



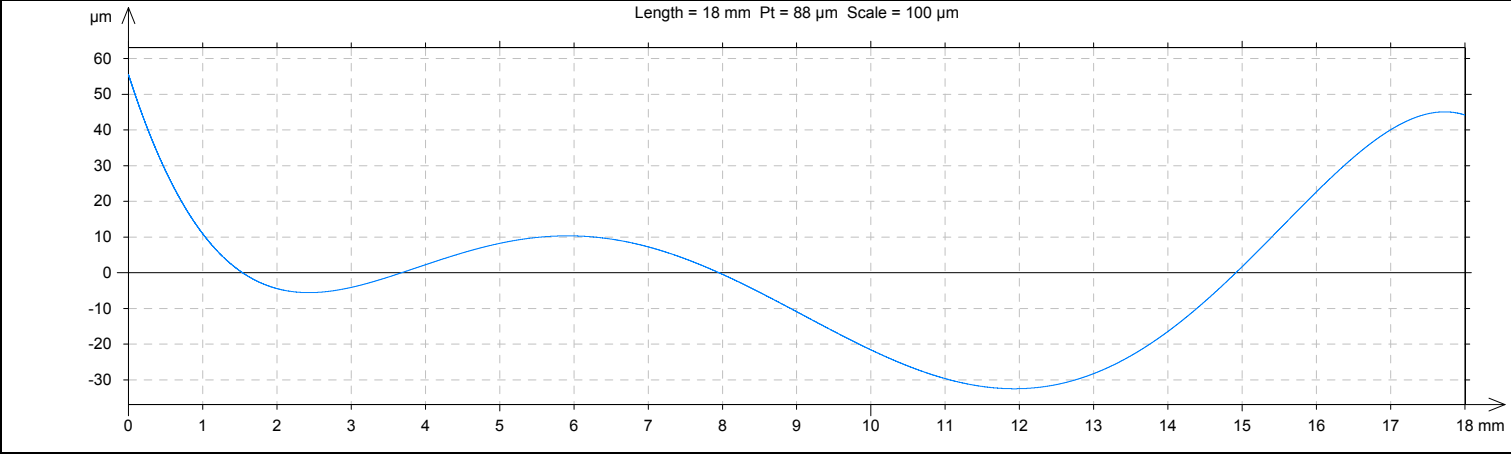
## Thresholding



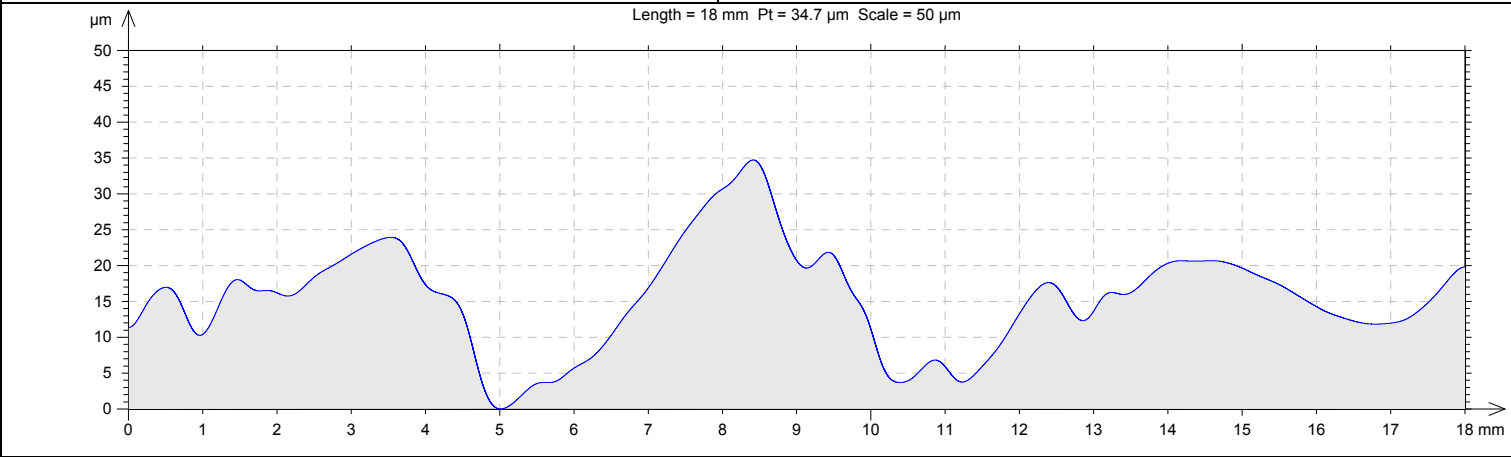
## Odstranění tvaru - polynomem 5. řádu



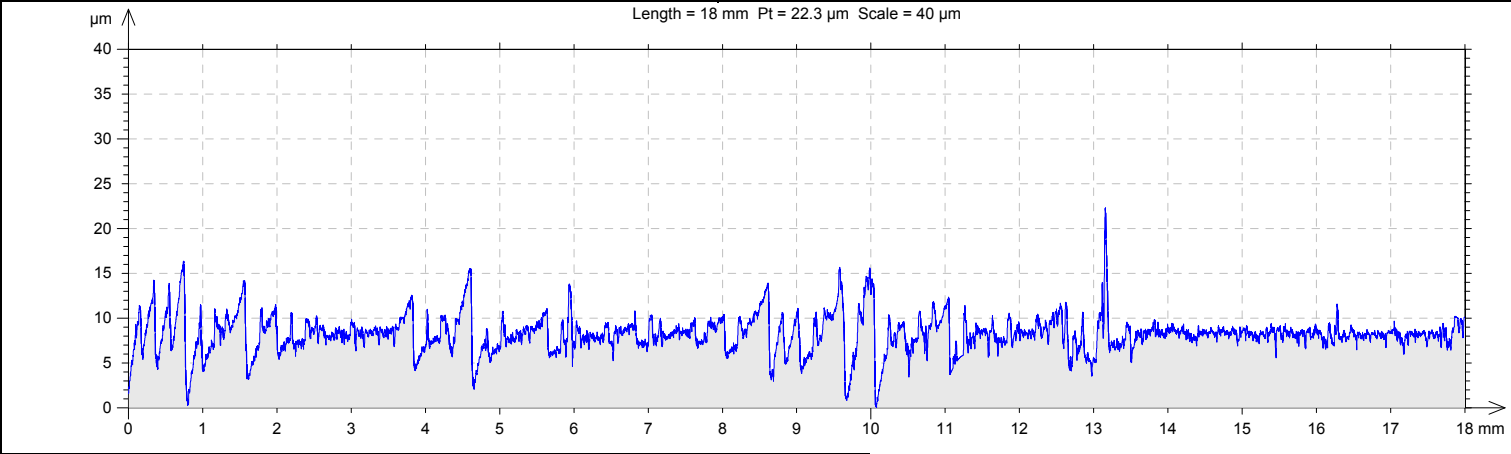
Samotný tvar



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 4A\_1 > ... >  
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  $\mu\text{m}$ .

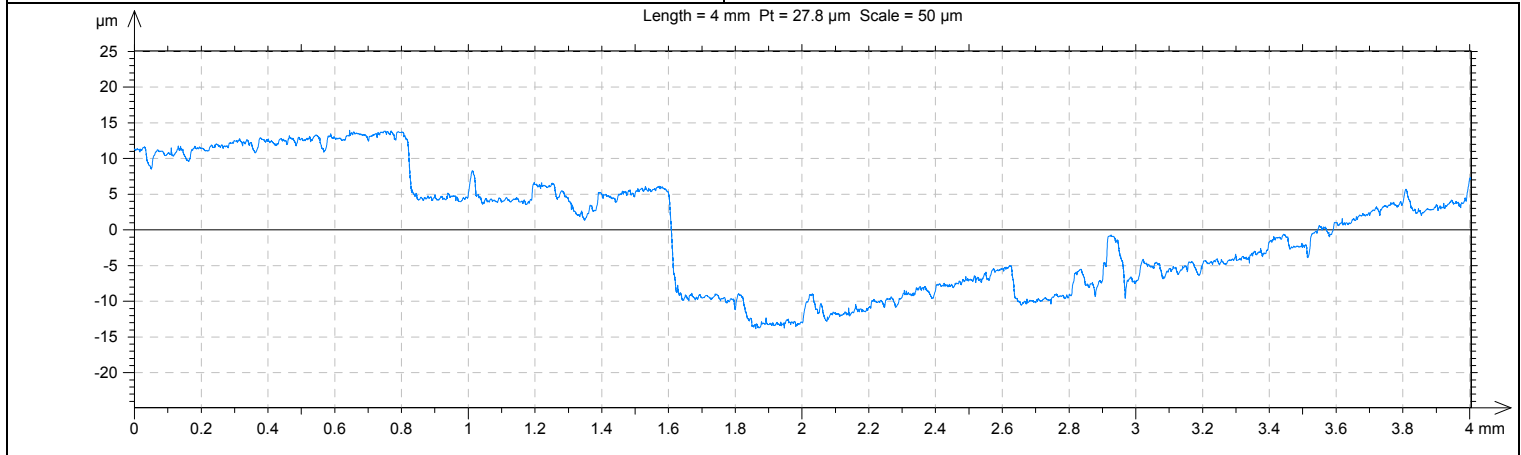
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 1.21  $\mu\text{m}$   
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 7.97  $\mu\text{m}$   
Rz: Maximum Height of roughness profile.  
RSm = 0.11 mm  
RSm: Mean Width of the roughness profile elements.

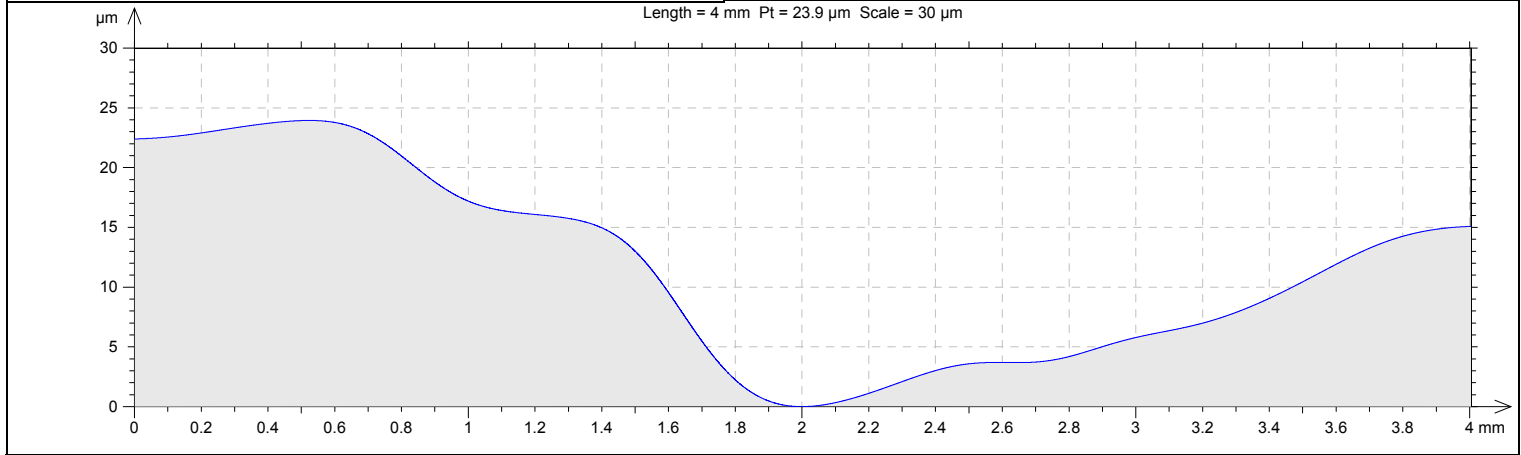
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.367  $\mu\text{m}$   
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 1.21  $\mu\text{m}$   
Wz: Maximum Height of waviness profile.  
WSm = 0.879 mm  
WSm: Mean Width of the waviness profile elements.

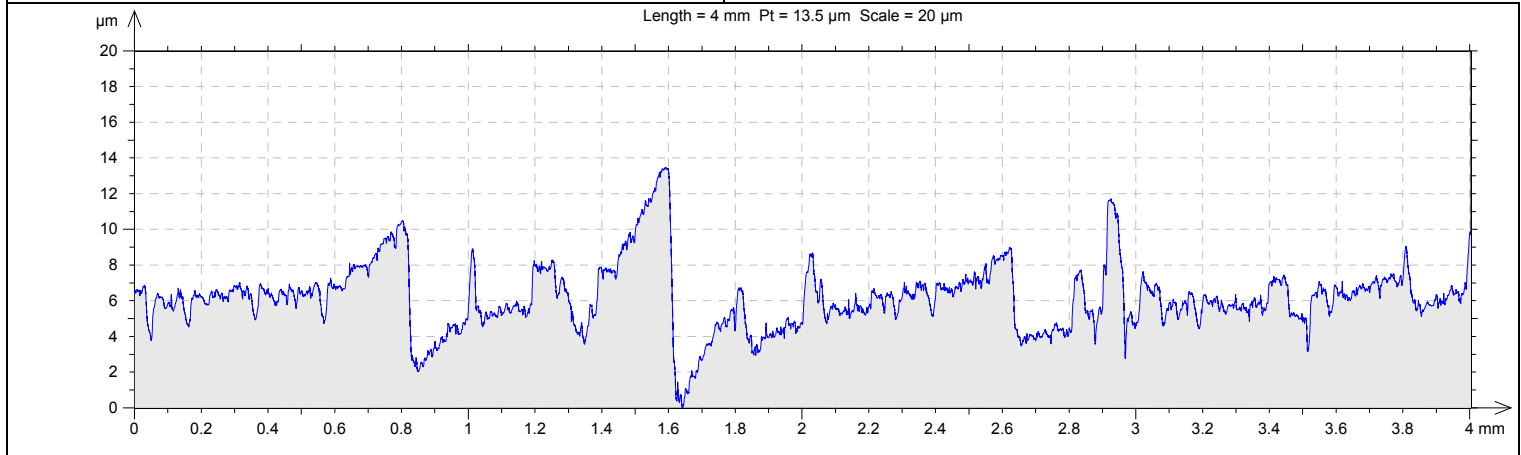
### Samotná drsnost\_výjezd vrtáku



### 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 dira 4A\_1  
> ... > 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  $\mu\text{m}$ .

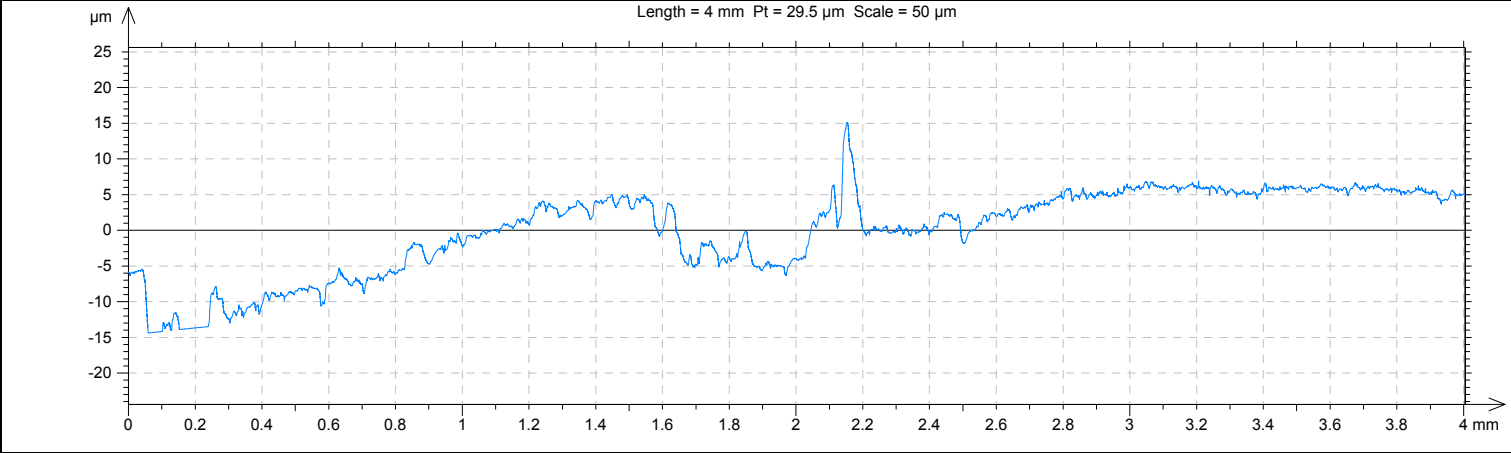
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 1.28  $\mu\text{m}$   
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 8.93  $\mu\text{m}$   
Rz: Maximum Height of roughness profile.  
RSm = 0.101 mm  
RSm: Mean Width of the roughness profile elements.

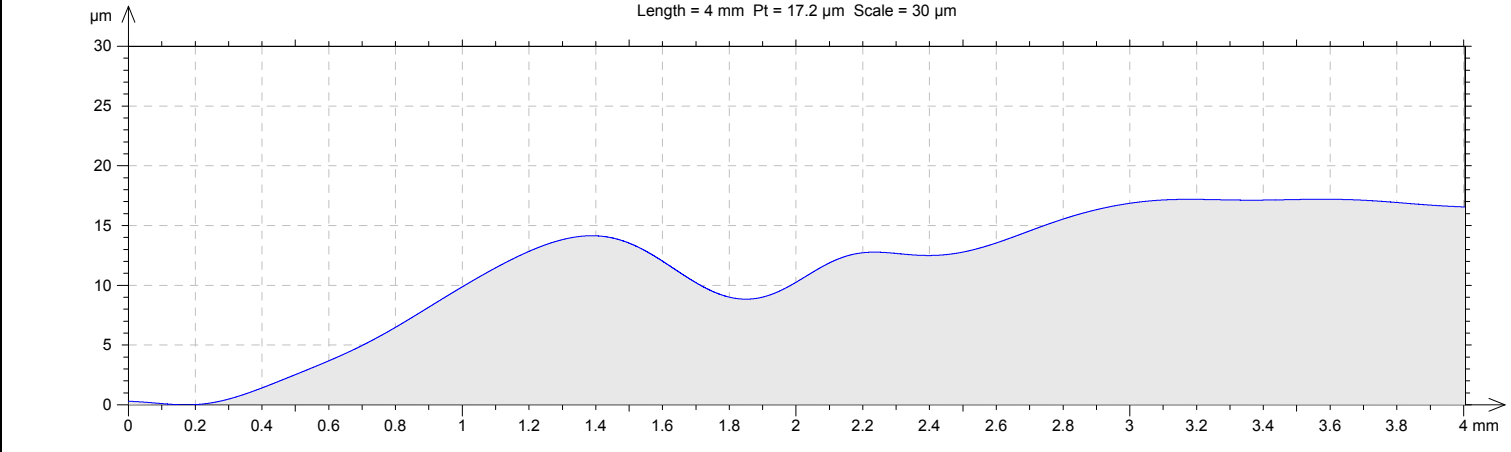
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.444  $\mu\text{m}$   
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 1.43  $\mu\text{m}$   
Wz: Maximum Height of waviness profile.  
WSm = 0.787 mm  
WSm: Mean Width of the waviness profile elements.

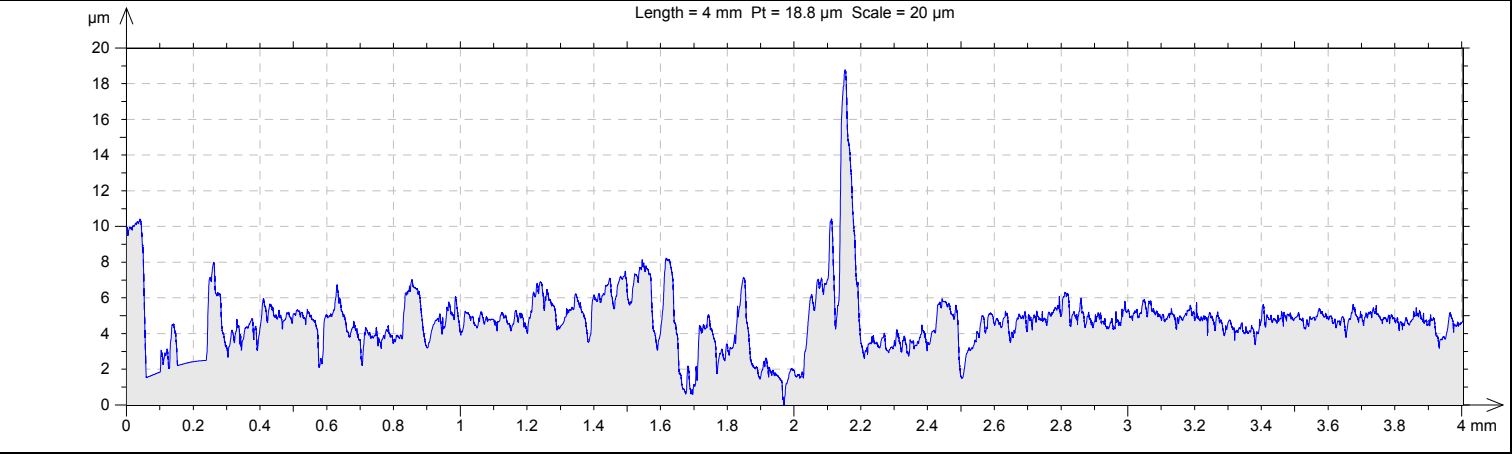
Samotná drsnost\_vjezd vrtáku



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 4A\_1  
> ... > 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 = 0.966 µm  
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 7.93 µm  
Rz: Maximum Height of roughness profile.  
RSm = 0.0816 mm  
RSm: Mean Width of the roughness profile elements.

Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.327 µm  
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 1.04 µm  
Wz: Maximum Height of waviness profile.  
WSm = 0.771 mm  
WSm: Mean Width of the waviness profile elements.