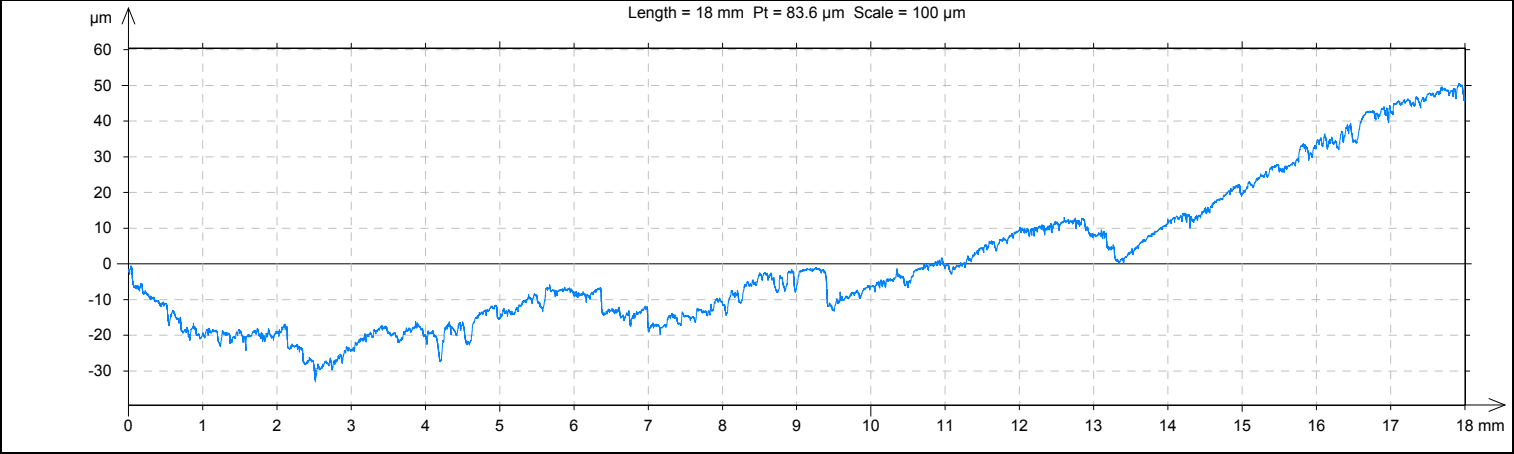
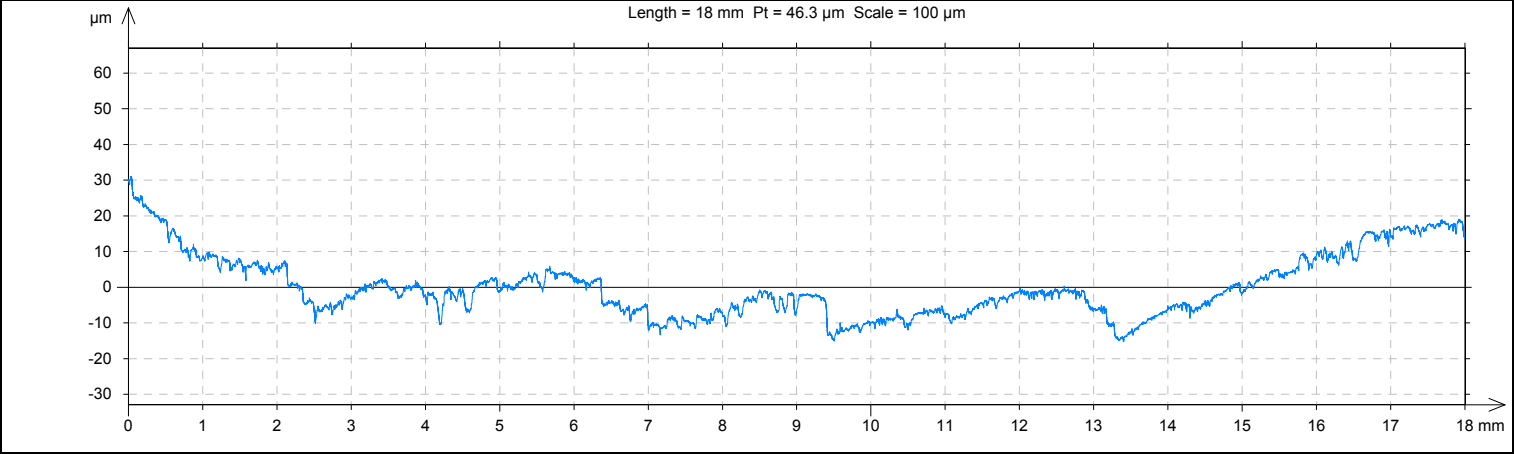


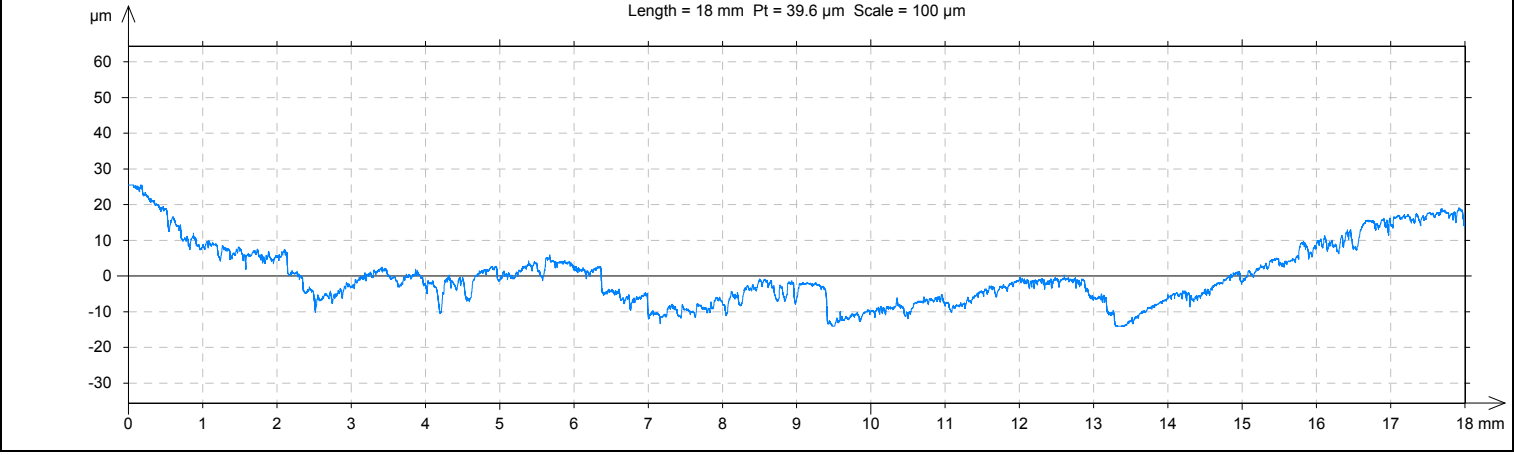
**Změřený profil**



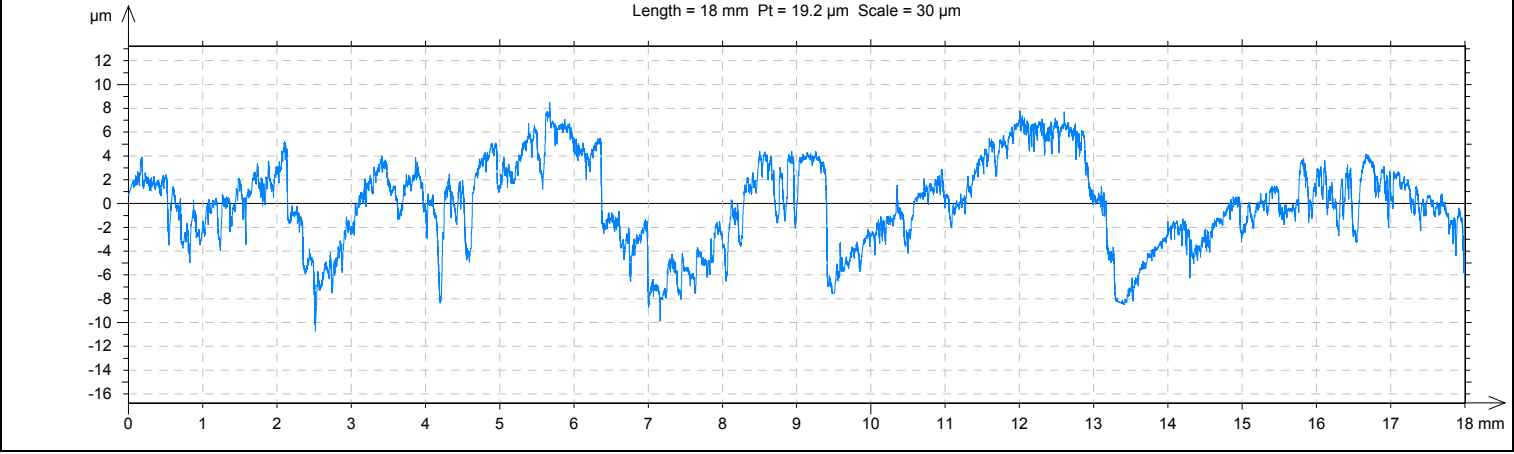
**Vyrovnaný profil**



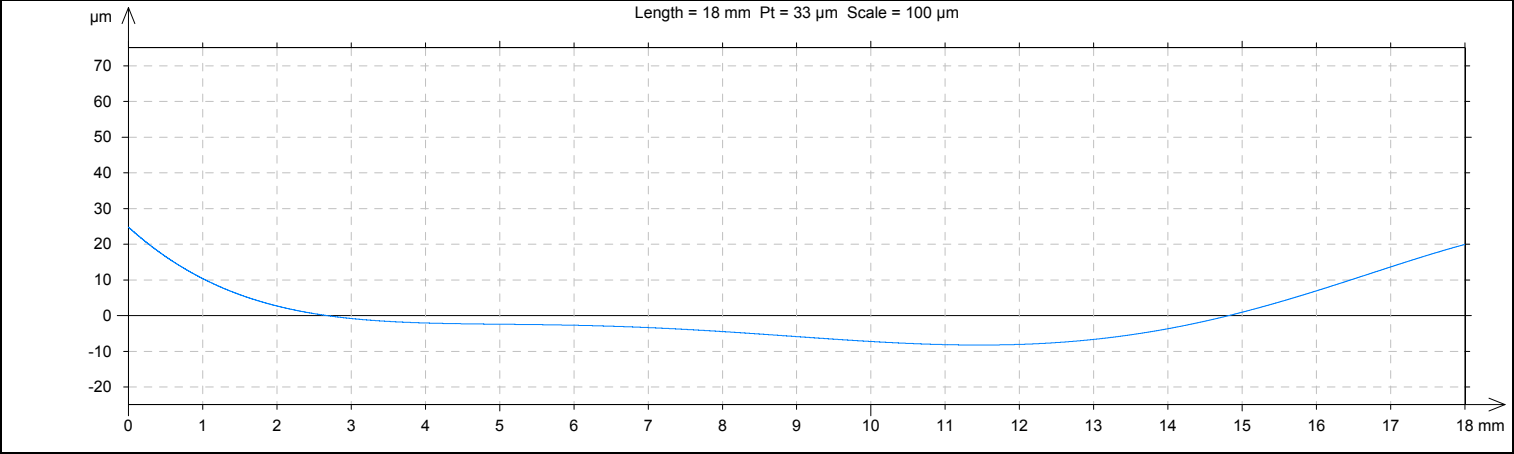
**Thresholding**



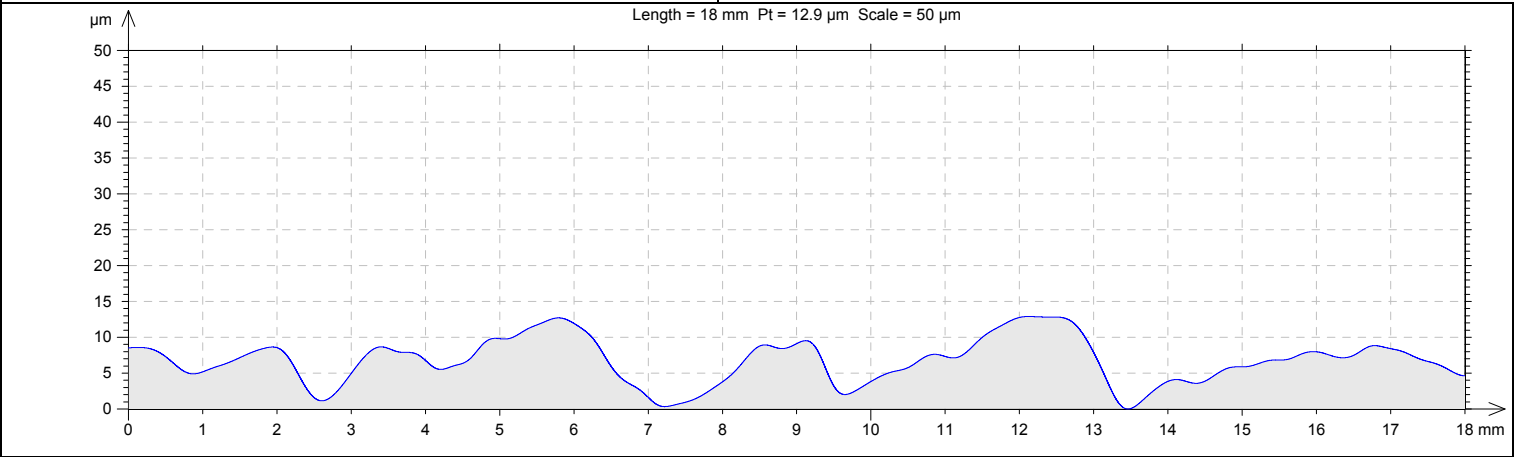
**Odstranění tvaru - polynomem 5. řádu**



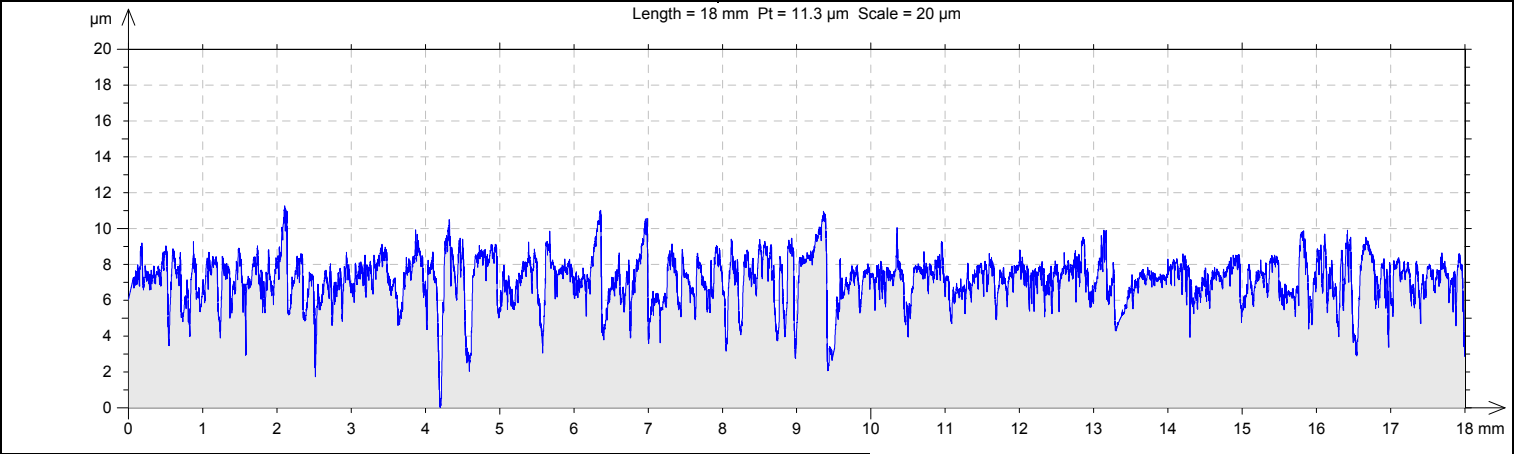
Samotný tvar



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 5\_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  $\mu\text{m}$ .

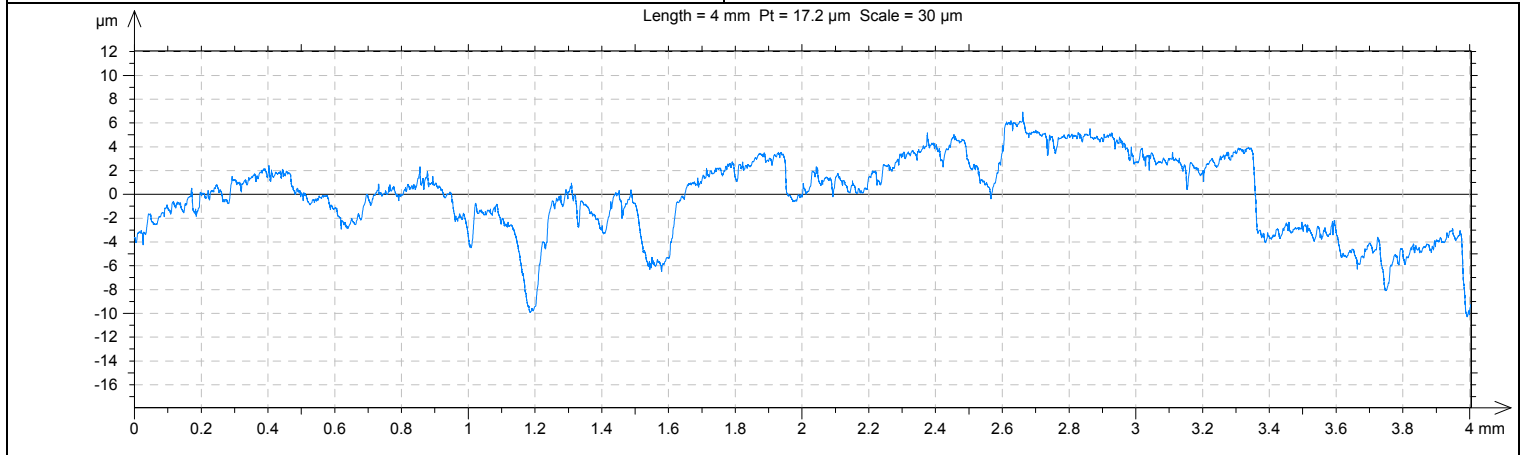
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 0.906  $\mu\text{m}$   
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 6.03  $\mu\text{m}$   
Rz: Maximum Height of roughness profile.  
RSm = 0.1 mm  
RSm: Mean Width of the roughness profile elements.

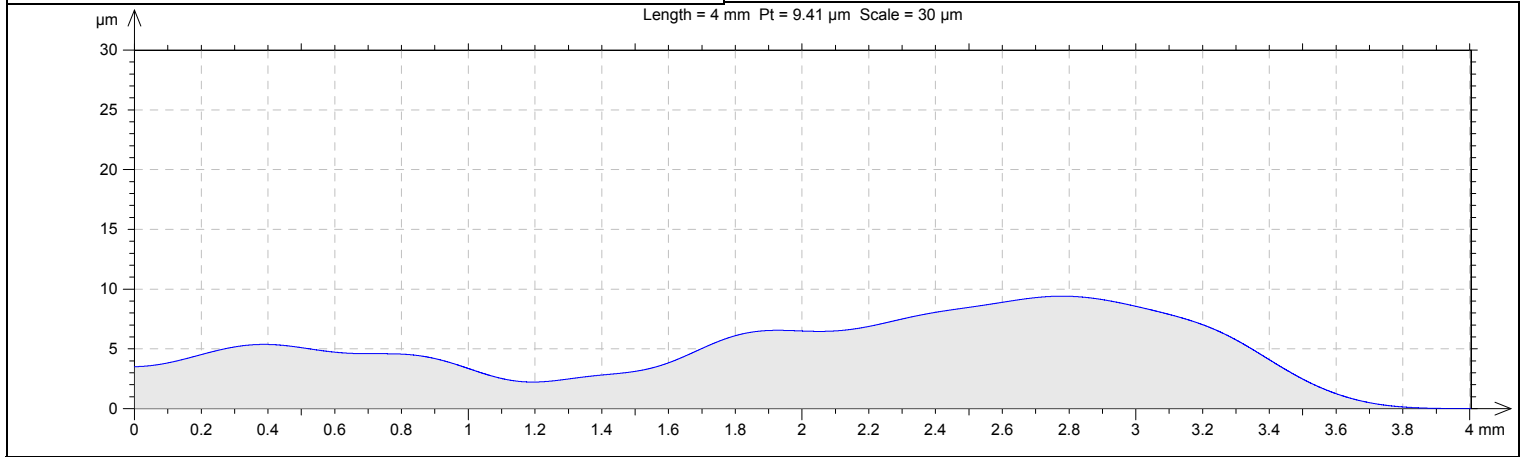
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.241  $\mu\text{m}$   
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 0.805  $\mu\text{m}$   
Wz: Maximum Height of waviness profile.  
WSm = 1.09 mm  
WSm: Mean Width of the waviness profile elements.

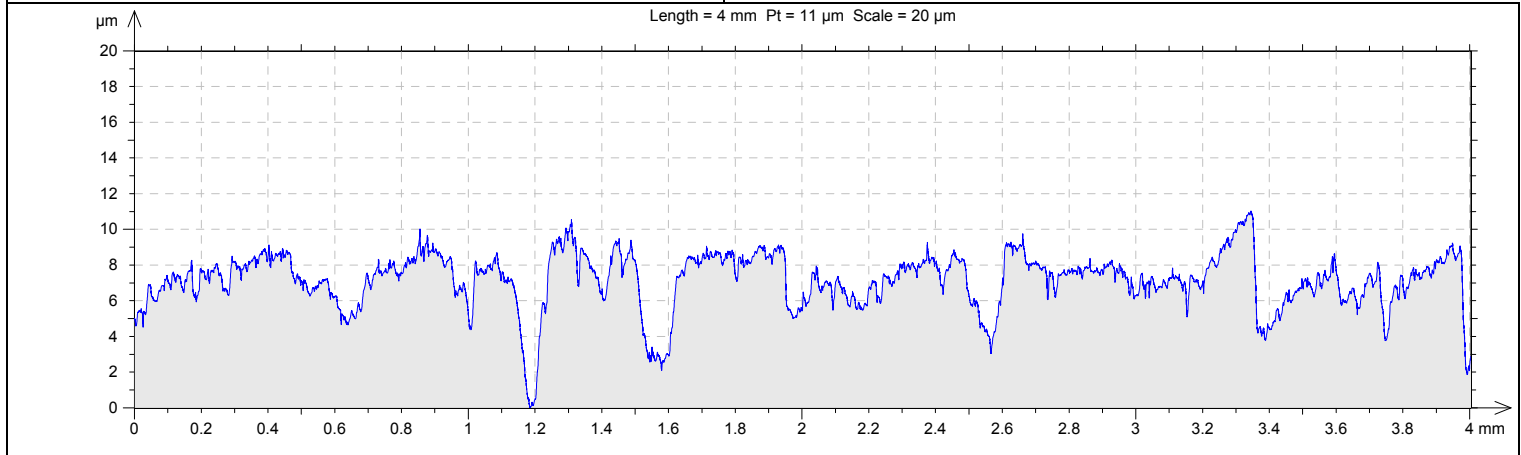
### Samotná drsnost\_výjezd vrtáku



### 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 5\_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  $\mu\text{m}$ .

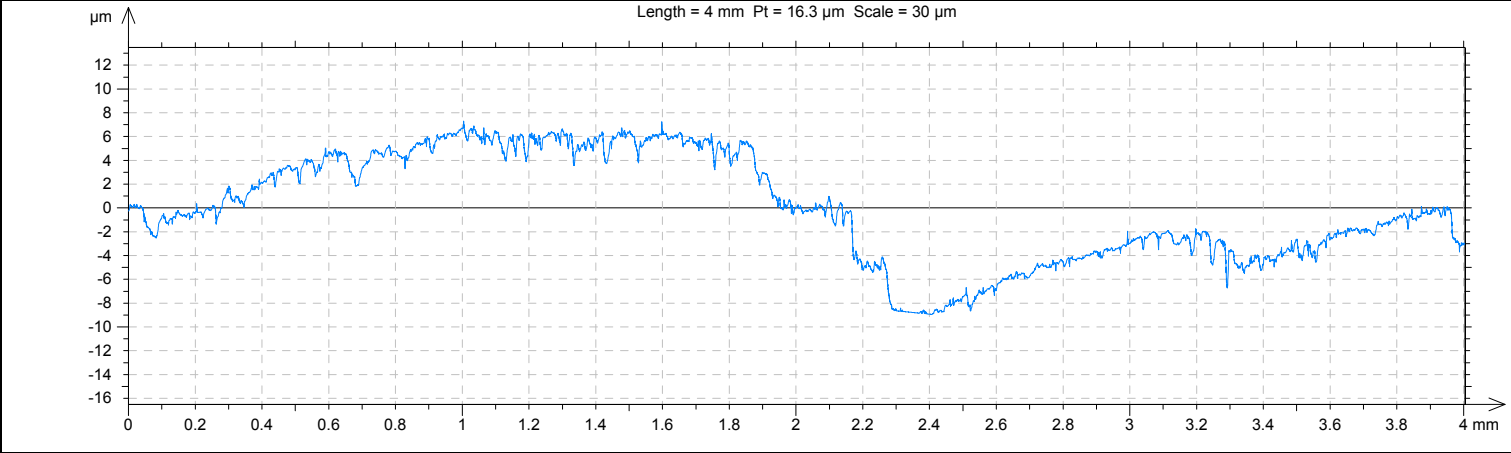
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 1.14  $\mu\text{m}$   
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 8.13  $\mu\text{m}$   
Rz: Maximum Height of roughness profile.  
RSm = 0.121 mm  
RSm: Mean Width of the roughness profile elements.

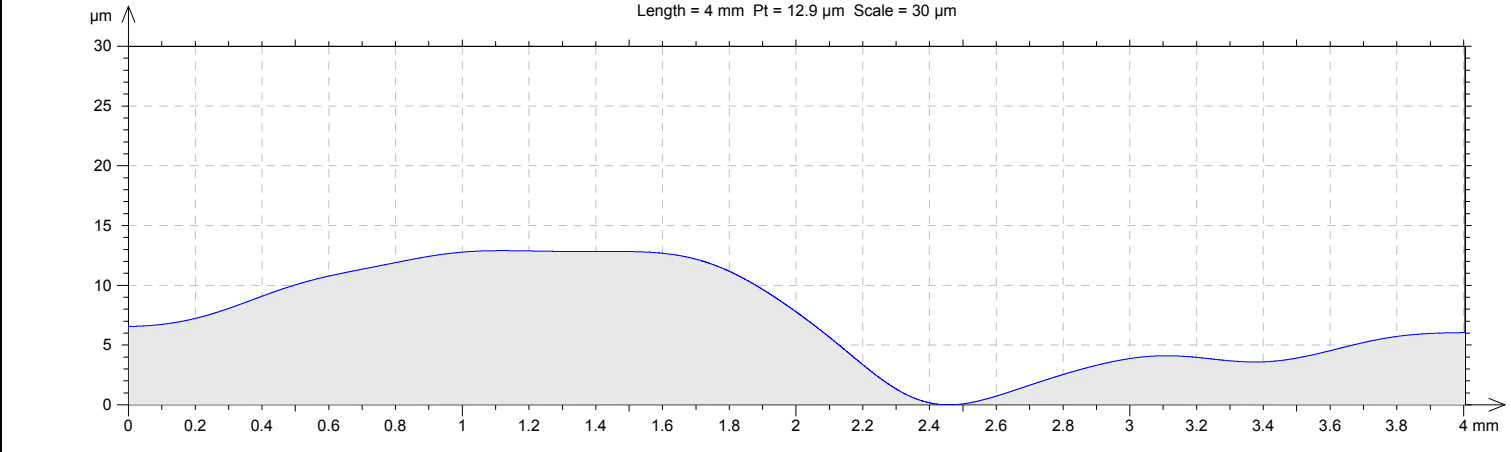
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.225  $\mu\text{m}$   
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 0.798  $\mu\text{m}$   
Wz: Maximum Height of waviness profile.  
WSm = 0.636 mm  
WSm: Mean Width of the waviness profile elements.

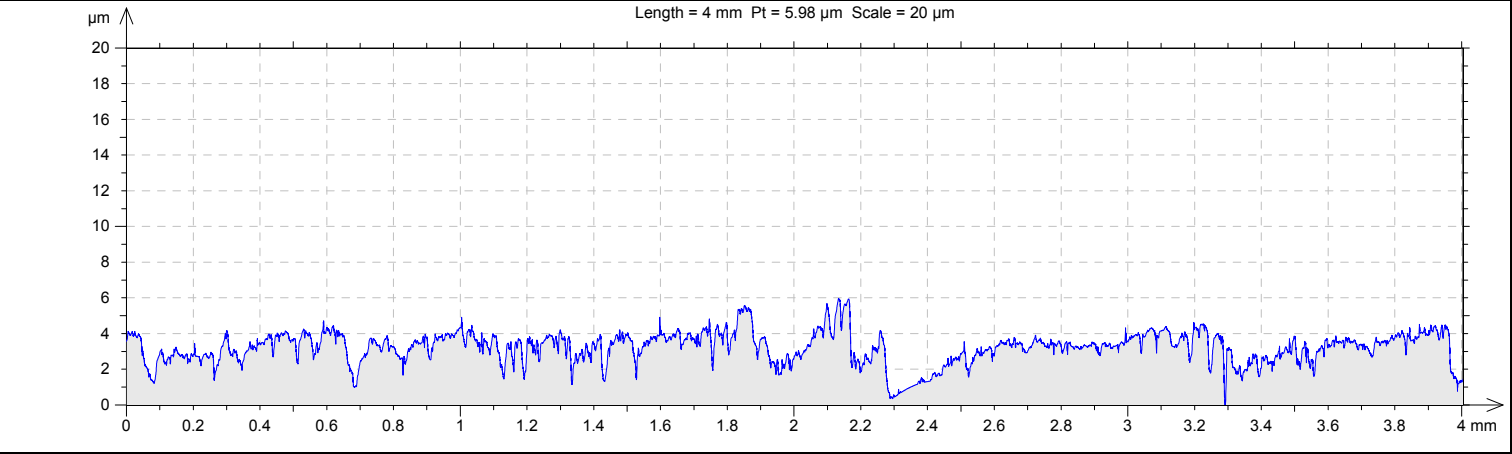
Samotná drsnost\_vjezd vrtáku



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 5\_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 = 0.563 µm  
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 4.27 µm  
Rz: Maximum Height of roughness profile.  
RSm = 0.0511 mm  
RSm: Mean Width of the roughness profile elements.

Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.268 µm  
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 0.651 µm  
Wz: Maximum Height of waviness profile.  
WSm = 2.33 mm  
WSm: Mean Width of the waviness profile elements.