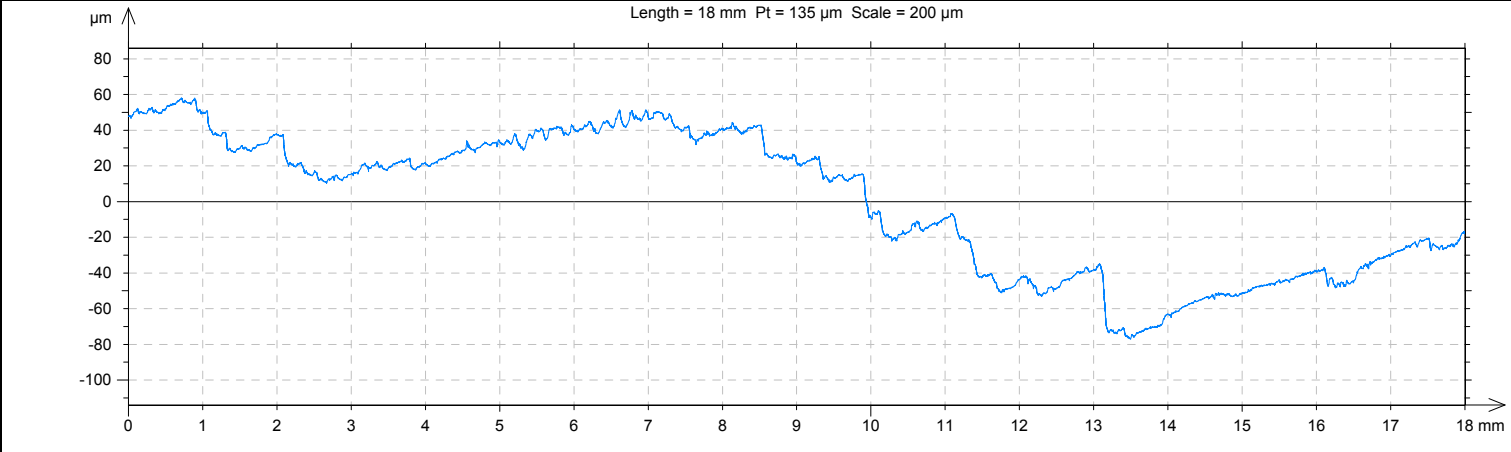
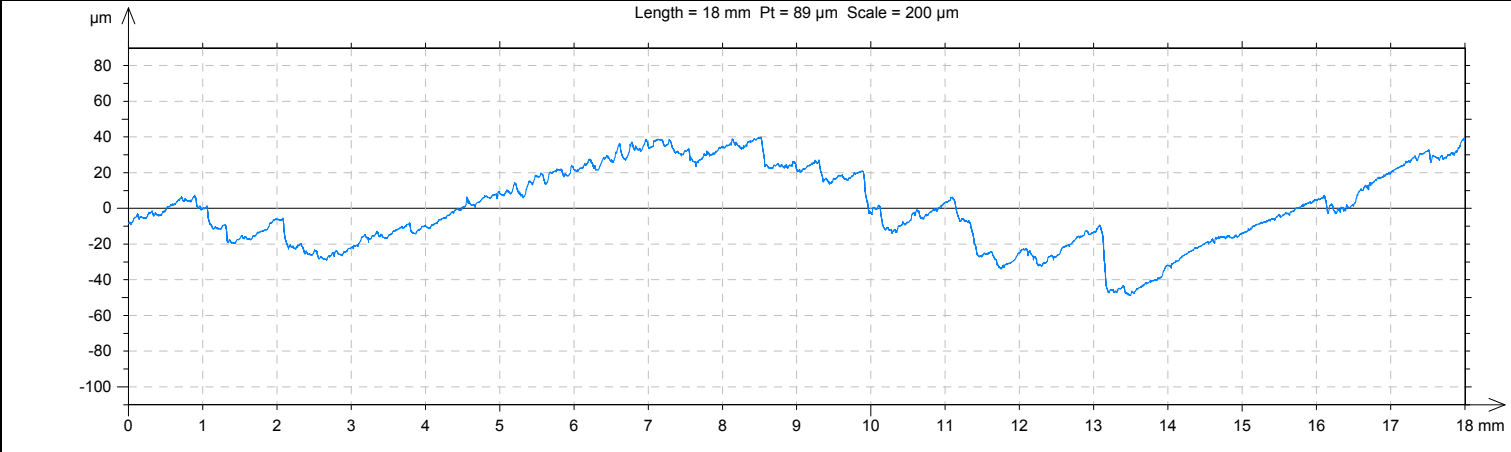


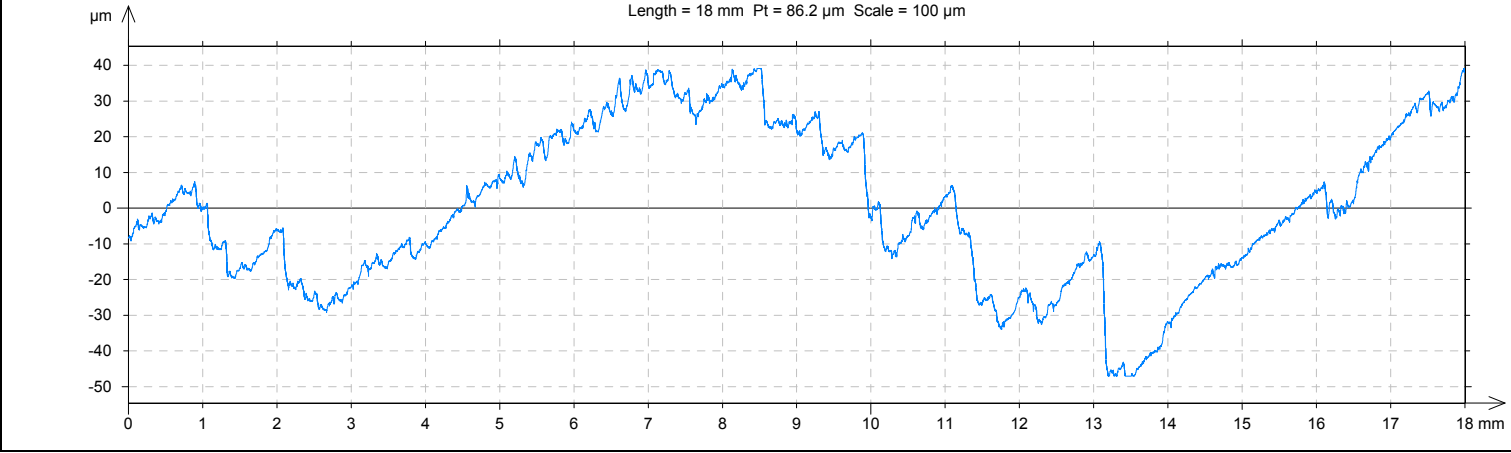
**Změřený profil**



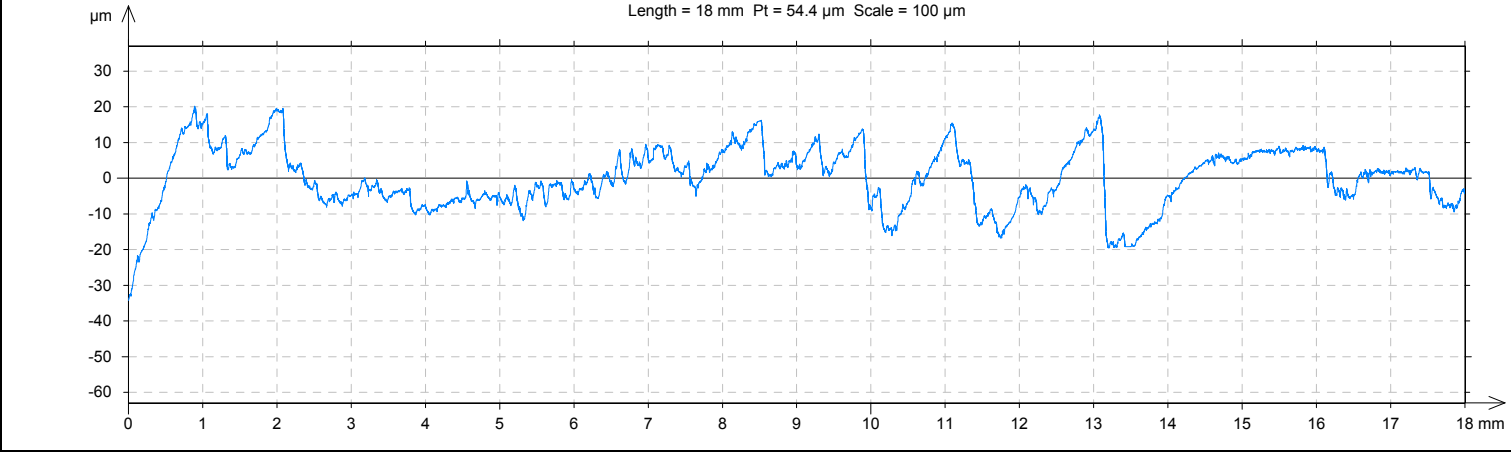
**Vyrovnaný profil**



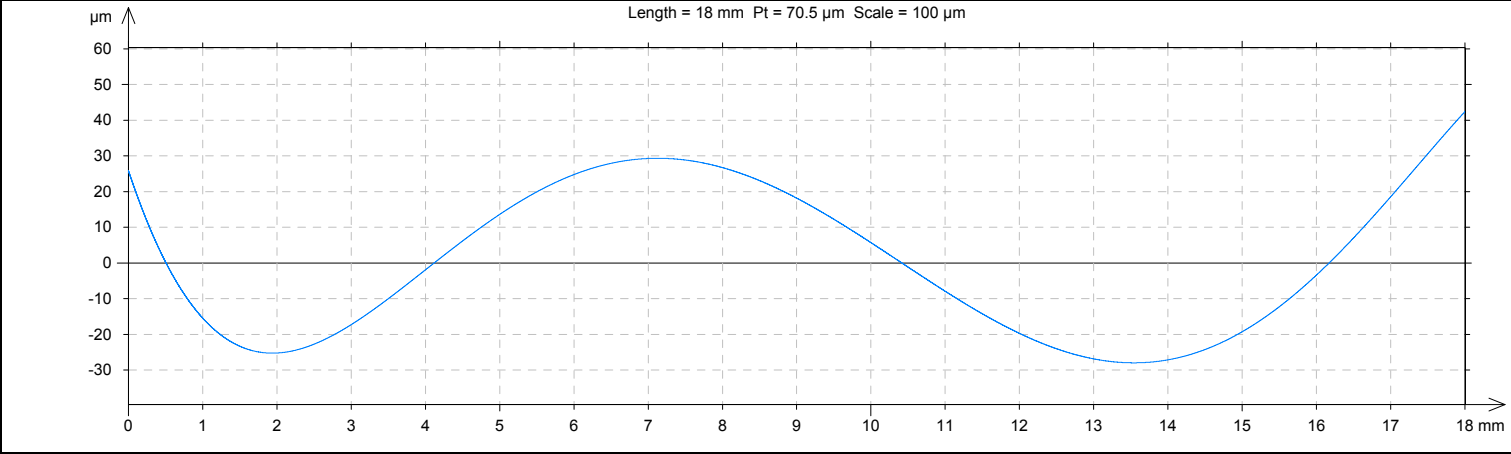
**Thresholding**



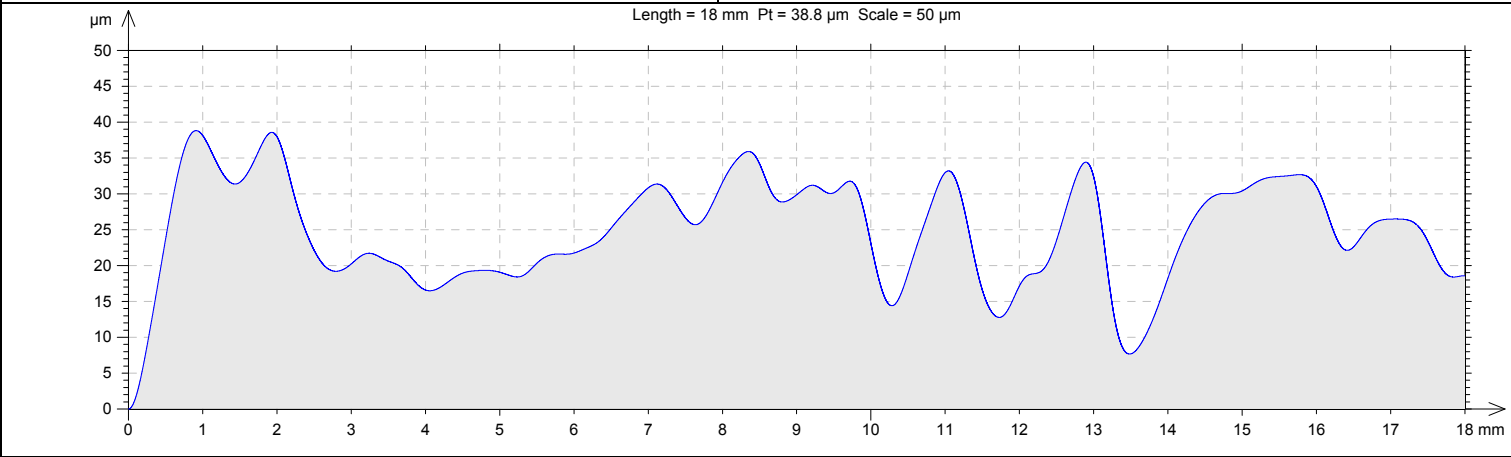
**Odstranění tvaru - polynomem 5. řádu**



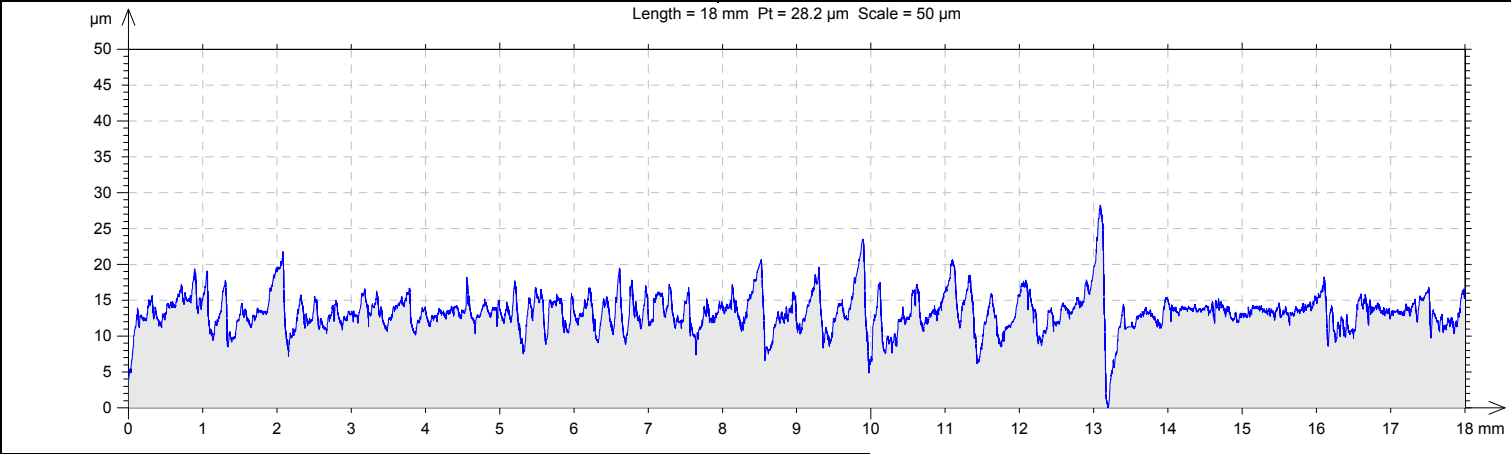
Samotný tvar



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

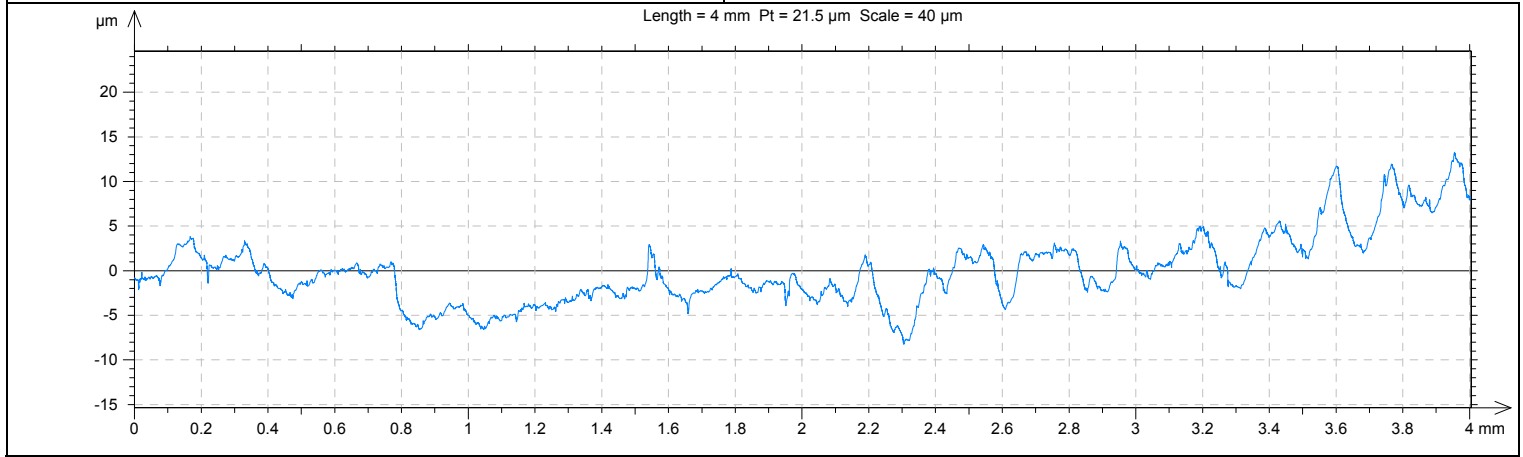
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 1.5  $\mu\text{m}$   
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 10  $\mu\text{m}$   
Rz: Maximum Height of roughness profile.  
RSm = 0.166 mm  
RSm: Mean Width of the roughness profile elements.

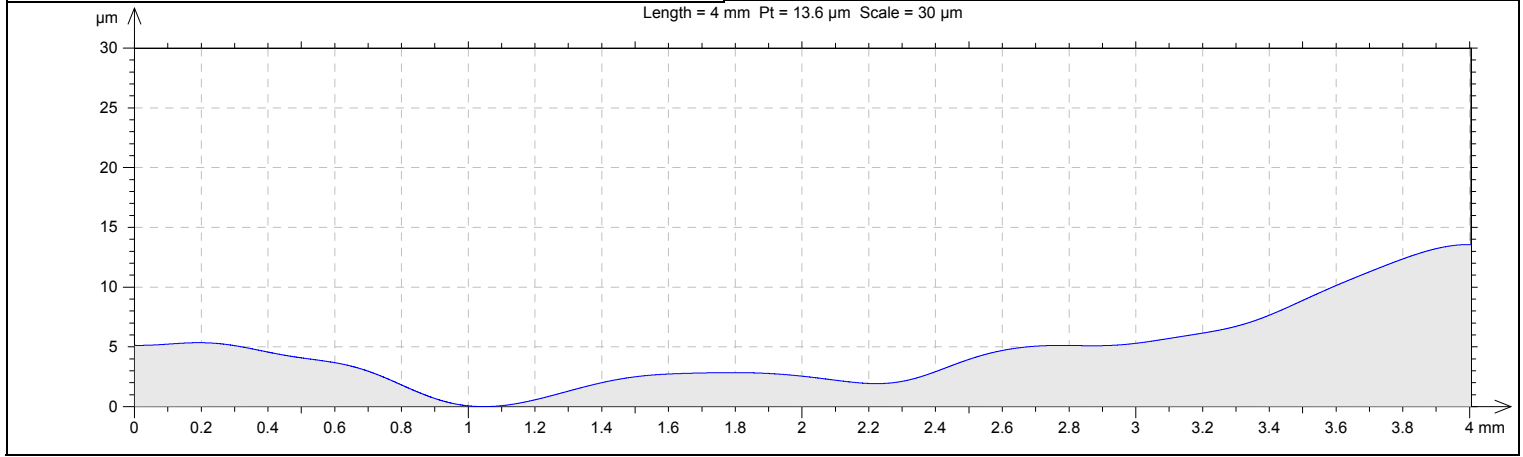
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.678  $\mu\text{m}$   
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 2.06  $\mu\text{m}$   
Wz: Maximum Height of waviness profile.  
WSm = 1.15 mm  
WSm: Mean Width of the waviness profile elements.

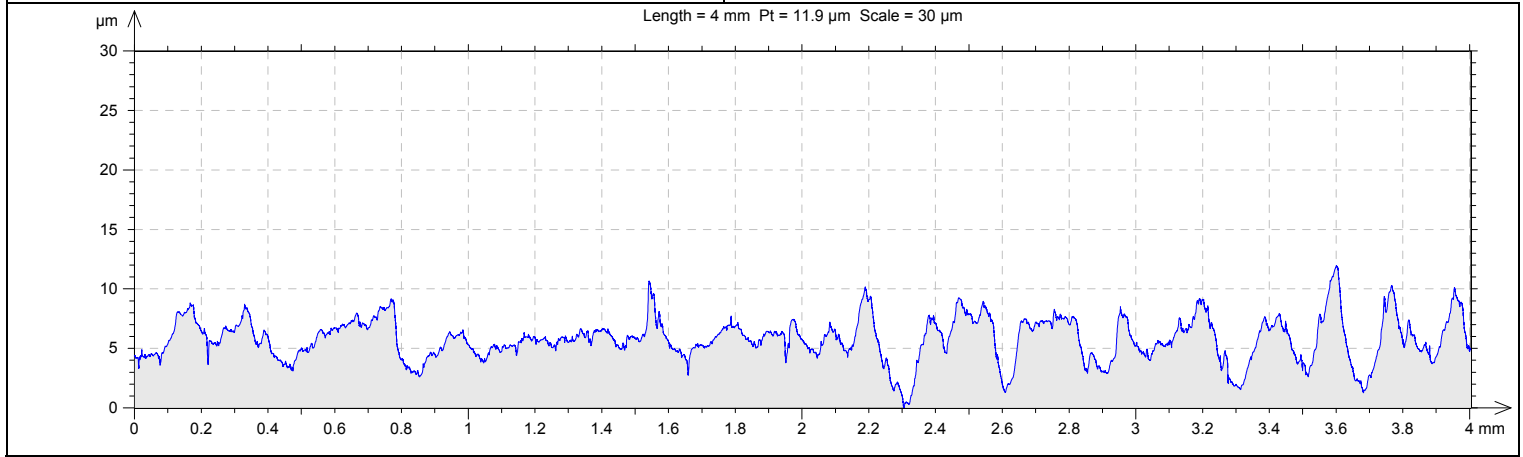
### Samotná drsnost\_výjezd vrtáku



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

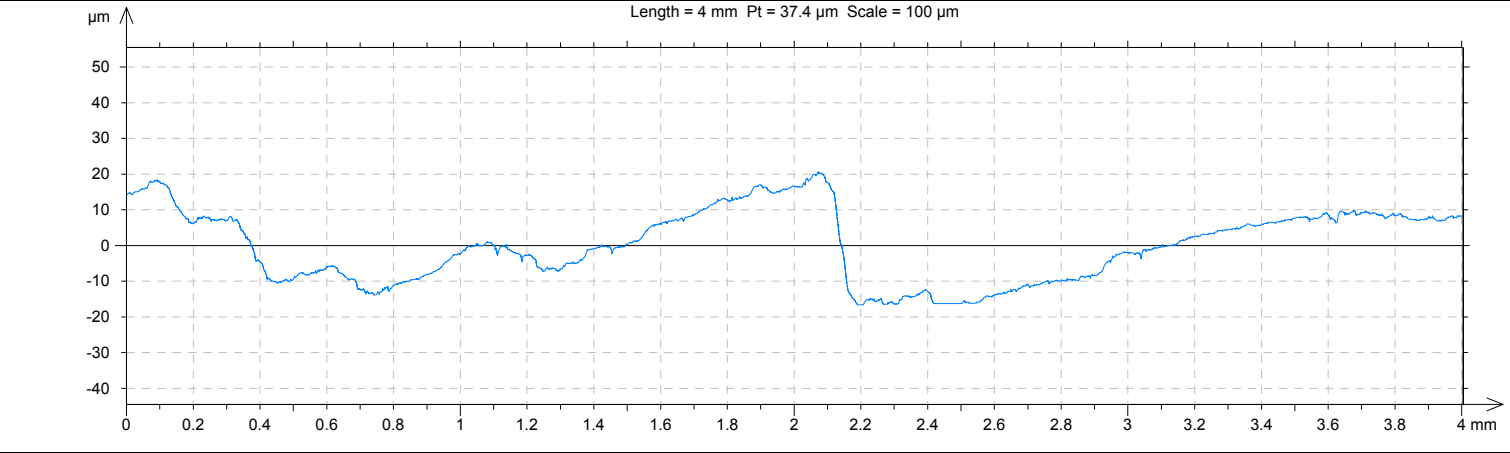
Roughness Parameters, Gaussian filter, 0.8 mm

Ra = 1.31  $\mu\text{m}$   
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 8.52  $\mu\text{m}$   
Rz: Maximum Height of roughness profile.  
RSm = 0.178 mm  
RSm: Mean Width of the roughness profile elements.

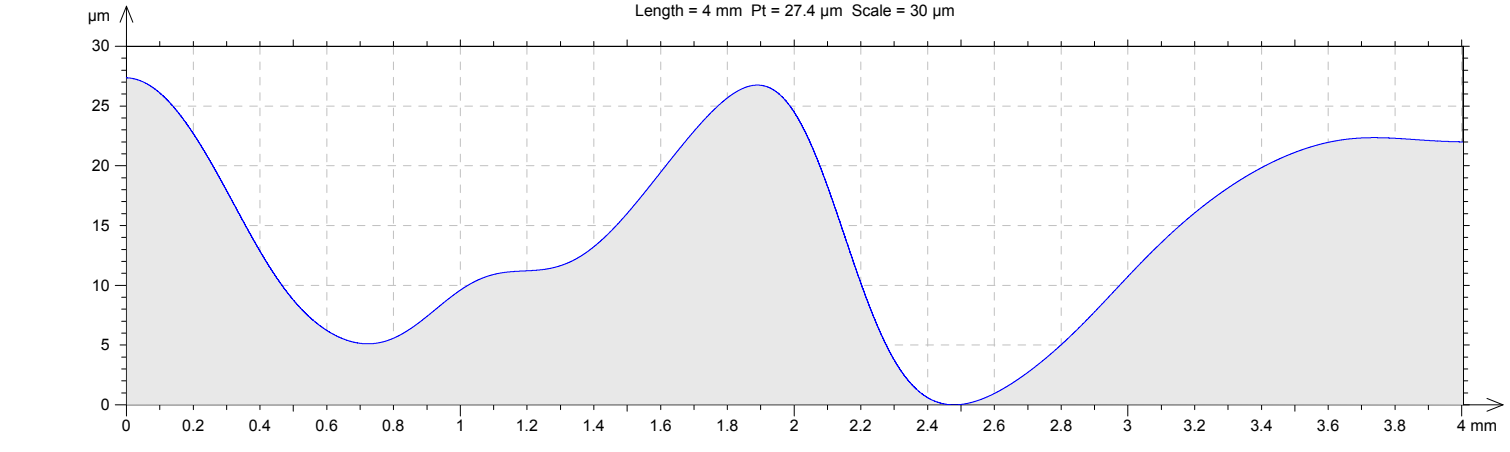
Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 0.209  $\mu\text{m}$   
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 0.643  $\mu\text{m}$   
Wz: Maximum Height of waviness profile.  
WSm = 1.05 mm  
WSm: Mean Width of the waviness profile elements.

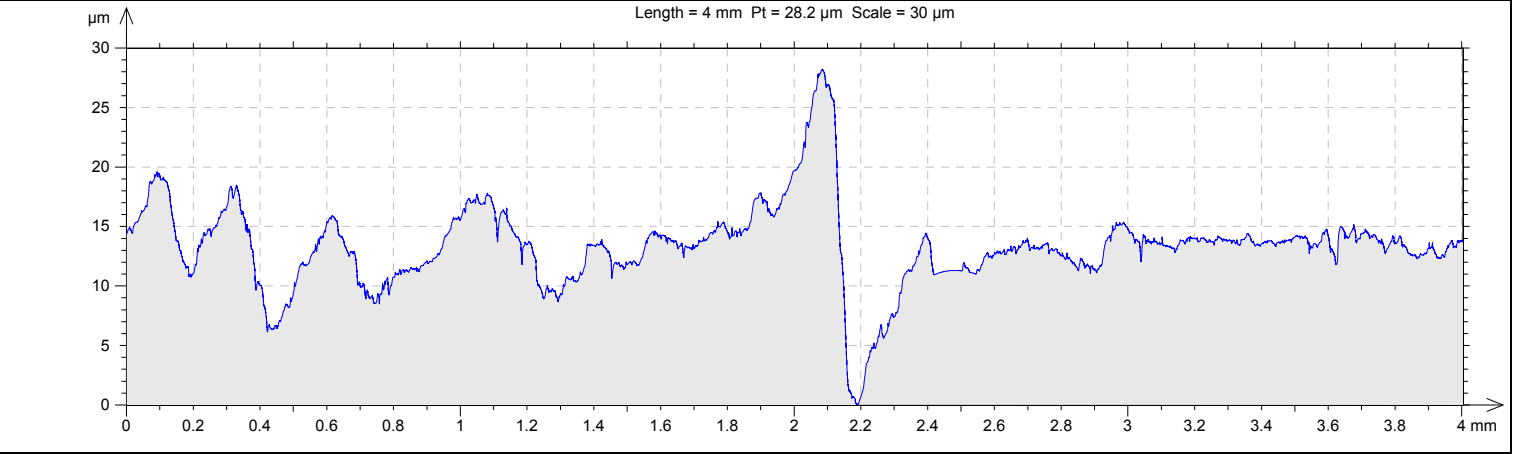
Samotná drsnost\_vjezd vrtáku



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 7\_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 = 1.78 µm  
Ra: Arithmetic Mean Deviation of the roughness profile.  
Rz = 11.7 µm  
Rz: Maximum Height of roughness profile.  
RSm = 0.176 mm  
RSm: Mean Width of the roughness profile elements.

Waviness Parameters, Gaussian filter, 0.8 mm

Wa = 1.09 µm  
Wa: Arithmetic Mean Deviation of the waviness profile.  
Wz = 3.5 µm  
Wz: Maximum Height of waviness profile.  
WSm = 0.994 mm  
WSm: Mean Width of the waviness profile elements.