

DIN EN ISO 21920-1:2022-12 (E)

Geometrical product specifications (GPS) - Surface texture: Profile - Part 1: Indication of surface texture (ISO 21920-1:2021)

Contents	Page
European foreword	4
Foreword	5
Introduction	6
1 Scope	7
2 Normative references	7
3 Terms and definitions	7
4 Tolerance acceptance rules	7
4.1 General.....	7
4.2 Maximum tolerance acceptance rule.....	8
4.3 16 % tolerance acceptance rule.....	8
4.4 Median tolerance acceptance rule.....	8
5 Specification elements for indication of profile surface texture specifications	9
5.1 General.....	9
5.2 Mandatory indication to be explicitly specified.....	9
5.3 Optional indications to specify non-default or further requirements.....	9
6 Indication of profile surface texture	10
6.1 General.....	10
6.2 Graphical symbols.....	10
6.3 Minimal indication.....	11
6.3.1 General.....	11
6.3.2 Minimal indication for parameters with defined defaults.....	11
6.3.3 Minimal indication for parameters without defined defaults.....	11
6.4 Complete indication.....	12
6.4.1 General.....	12
6.4.2 Complete indication for evaluation length R-parameters.....	13
6.4.3 Complete indication for section length R-parameters.....	14
6.4.4 Complete indication for evaluation length P-parameters and W-parameters.....	15
6.4.5 Complete indication for section length P-parameters and W-parameters.....	16
7 Rules for indication of profile surface texture specifications	16
7.1 General.....	16
7.2 Graphical symbol for the indication of profile surface texture specifications.....	17
7.3 Profile surface texture parameter.....	17
7.4 Tolerance limit value of the profile surface texture parameter.....	17
7.5 Tolerance types.....	17
7.6 Tolerance acceptance rule.....	17
7.7 Profile S-filter type.....	17
7.8 Profile S-filter nesting index.....	17
7.9 Profile L-filter type (for R-parameter) or profile S-filter type (for W-parameter).....	18
7.10 Profile L-filter nesting index (for R-parameter) or profile S-filter nesting index (for W-parameter).....	18
7.11 Evaluation length.....	18
7.12 Section length.....	18
7.13 Number of sections.....	18
7.14 Profile F-operator association method and element.....	18
7.15 Profile F-operator nesting index.....	18
7.16 Method of profile extraction.....	19

7.17	Other requirements, OR(<i>n</i>)	19
7.18	Manufacturing process	19
7.19	Surface lay and direction of lay	19
7.20	Profile direction	19
7.21	Setting class, <i>Scn</i>	19
8	Position on technical product documentation.....	20
8.1	General.....	20
8.2	Position and orientation of the graphical symbol.....	20
9	Simplified and additional indications.....	23
9.1	Simplified indications.....	23
9.1.1	General	23
9.1.2	General tolerances	23
9.1.3	Indication by the graphical symbol combined with a letter.....	24
9.2	Restrictive specifications	25
9.3	Indication of identical specifications for a number of feature elements	26
9.4	Indication of surface lay and direction of lay	26
9.4.1	General	26
9.4.2	Indication of surface lay without a reference.....	27
9.4.3	Indication of surface lay and direction of lay relative to a workpiece feature.....	28
9.5	Indication of the profile direction.....	28
9.5.1	General	28
9.5.2	Indication of the profile direction relative to the predominant direction of the surface lay.....	29
9.5.3	Indication of the profile direction relative to a workpiece feature.....	29
9.6	Indication of bilateral surface profile tolerances	30
9.7	Indication of different requirements for several additional processes on one surface feature.....	30
	Annex A (normative) Proportions and dimensions of graphical symbols.....	32
	Annex B (normative) Filter symbols for profile surface texture.....	34
	Annex C (normative) Symbols for association methods and association elements	35
	Annex D (informative) Indications for unambiguous surface profile specification.....	36
	Annex E (normative) Inspection procedure for the 16 % tolerance acceptance rule.....	49
	Annex F (informative) Criteria for the use of the maximum tolerance acceptance rule as the default.....	50
	Annex G (informative) New issues and changes to previous documents	51
	Annex H (informative) Overview of profile and areal standards in the GPS matrix model.....	53
	Annex I (informative) Relation to the GPS matrix model.....	54
	Bibliography.....	55