

Spis treści

1. Introduction	7
2. Fundamental information	8
2.1. Two dimensional (2-D) profile analysis	8
2.2. Three dimensional (3-D) analysis	15
3. Measurement techniques	21
3.1. Introduction	21
3.2. Stylus instruments	22
3.2.1. 2-D measurements	22
3.2.2. 3-D measurements	27
3.2.3. Recent trends in tactile measurement	34
3.2.4. Disadvantages of the stylus technique	36
3.2.5. Other profiling techniques	37
3.2.5.1. Scanning microscopes	37
3.2.5.2. Scanning Probe Microscopes	37
3.2.5.3. Applications of scanning electron microscopy (SEM) ..	40
3.3. Optical methods	41
3.4. Comparison of various techniques	52
3.5. The importance of surface topography parameters	53
3.5.1. Basic information	53
3.5.2. Amplitude parameters	54
3.5.3. The spatial parameters	57
3.5.4. The hybrid parameters	59
3.5.5. Parameters connected with the material ratio curve	59
4. Computer generation of a random surface topography	62
4.1. Literature review	62
4.2. Simulation of random Gaussian surfaces	64
4.3. Simulation of surfaces after two processes	66
4.3.1. Profile simulation	66
4.3.2. Simulation of a 3-D surface	68
4.3.3. Case studies	69
4.4. Conclusions	70

5.	Typical stylus measurement errors.....	71
5.1.	The effect of mechanical filtering by the stylus tip	
	on measurement errors.....	71
5.1.1.	Literature review.....	71
5.1.2.	Simulation of mechanical filtering.....	73
5.1.3.	Deterministic surfaces.....	73
5.1.4.	Random profiles.....	77
5.1.5.	3-D random surfaces.....	79
5.1.6.	One-process surfaces.....	79
5.1.6.1.	Isotropic surfaces.....	79
5.1.6.2.	Anisotropic surfaces.....	80
5.1.6.3.	Stratified surfaces.....	81
5.1.7.	Surface reconstruction.....	82
5.1.8.	Conclusions.....	84
5.2.	The influence of the skid on the measurement uncertainty.....	85
5.2.1.	Introduction.....	85
5.2.2.	Deterministic surfaces.....	86
5.2.3.	Random surfaces.....	88
5.2.4.	Comparison between measurements	
	with various instruments.....	92
5.2.5.	Conclusions.....	92
5.3.	The effect of stylus flight on the parameters	
	of the surface topography.....	93
5.3.1.	Introduction.....	93
5.3.2.	Modelling stylus flight.....	94
5.3.3.	Analysis of surfaces with a symmetric ordinate	
	distribution.....	98
5.3.4.	Analysis of stratified surface topographies.....	105
5.3.5.	Conclusions.....	108
5.4.	Errors caused by surface replication.....	109
5.4.1.	Introduction.....	109
5.4.2.	Replicas of deterministic surfaces.....	110
5.4.3.	Random surfaces.....	110
5.4.4.	Conclusions.....	115
5.5.	Other types of errors.....	116
6.	The influence of quantisation errors and of changing	
	the sampling interval on surface topography parameters.....	118
6.1.	Introduction.....	118
6.2.	A literature review.....	119
6.3.	The choice of the sampling interval.....	121

6.3.1. Analysis of deterministic surfaces.....	121
6.3.2. Analysis of random surfaces	123
6.4. The influence of quantisation errors	
on surface topography parameters	134
6.4.1. Analysis of deterministic surfaces.....	134
6.4.2. Analysis of random surfaces	137
6.4.2.1. A study of random profiles.....	137
6.4.2.2. Analysis of 3-D surfaces.....	140
6.5. Conclusions	142
7. Distortion of surface topography measurements	
by signal processing errors	144
7.1. Introduction.....	144
7.2. Errors caused by establishing the reference element	144
7.2.1. The effect of digital filtering on the measurement	
uncertainty	144
7.2.2. Filtering using a Gaussian filter.....	154
7.2.3. Filtering of stratified surfaces using Gaussian,	
valley suppression and MPL (mid-point locus) filters.....	161
7.2.4. Robust filtering of the surface topography.....	167
7.2.5. Noise elimination	172
7.2.6. Conclusions	176
7.3. Other reference elements	177
8. Errors in computing parameters	184
8.1. Introduction.....	184
8.2. Selection and calculation of parameters.....	185
8.2.1. Description of the material ratio curve	
of two-process surfaces	185
8.2.2. Calculation of the slope	195
8.2.3. The analysis of peak parameters	203
8.3. 2-D and 3-D analyses	205
8.3.1. Comparison of the height parameters	205
8.3.2. Parameters describing the shape of the ordinate	
distribution	206
8.3.3. Comparison of slopes	207
8.3.4. Comparison of summit parameters	209
8.4. Conclusions	212
9. Other sources of distortion of the surface topography.....	214
9.1. Introduction.....	214
9.2. The effect of noise on the distortion of parameters	215

9.2.1. High frequency noise 215

9.2.2. Effect of individual scratches of spikes..... 217

9.3. The analysis of the variation of parameters 218

9.3.1. Introduction..... 218

9.3.2. Analysis of piston skirt surfaces 219

9.3.3. Cylinder surfaces..... 220

9.3.4. Random surfaces..... 221

9.4. Conclusions 228

10. The combined effects of different sources of errors on changes
in surface topography parameters 230

11. Summary 235

12. References 241