

The effect of scattered light sensor orientation on roughness measurement of curved polished surfaces

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Keywords: Surface roughness, measurement, light scattering

Abstract

Light scattering is a method for surface roughness measurements well suitable for use in a production environment thanks to its fast measurement rate, insensitivity to vibrations and to small misalignments. The method is however affected by several other factors. In this paper, the effect of angular orientation of a commercial scattered light sensor on roughness measurements of polished cylindrical surfaces with crossed surface lay is investigated to document the robustness of the method.

1. Introduction

Light scattering is an area-integrating method for non-contact measurement of surface roughness, described in ISO 25178 part 6 [1]. The method measures a representative area of the surface as a whole and provides numerical results based on area-integrating properties of the surface texture [1]. In this investigation, a commercial sensor type OS500-32 from OptoSurf GmbH was used. The instrument working principle is based on a non-coherent light beam of 0.9 mm in diameter illuminating the measured surface, reflection of the incident light from the surface slopes in spatial directions, and its acquisition within $\pm 16^\circ$ angular range with a linear detector array. From the distribution of the acquired scattered light intensity, a number of statistical parameters describing the surface texture are calculated, where the Aq parameter (variance of the scattered light distribution), is used to characterize the surface roughness [2]. Due to the area-integrating measurement principle and unidirectional sensor detector, the measurement output is sensitive to the orientation of the detector relative to the surface texture directions and form. Surfaces having unidirectional texture (e.g. turning, grinding) are properly characterized with the detector perpendicular to the surface lay [2]. A mathematical model of the sensor

measurement principle with the given restriction of unidirectional lay was derived in [3], showing the effect of surface curvature on Aq and formalizing a correction term to suppress the effect in the case of unidirectional lay. Surfaces with multidirectional lay (e.g. polishing, cross grinding) should be characterized in multiple directions, ideally with the sensor detector perpendicular to the main texture directions. In combination with the simultaneous presence of surface curvature, the optimal sensor orientation is not obvious and its effect on the measurement output is unknown.

The effect of angular orientation of the sensor detector on roughness measurements of cylindrical polished surfaces with crossed surface lay was investigated and is documented in this paper.

2. Measurement procedure and data analysis

Three surfaces with different surface roughness (see table 1) polished by Robot Assisted Polishing (RAP) on a cylindrical specimen of 38 mm in diameter were measured with the scattered light sensor and a stylus profilometer. The scattered light sensor was mounted in an indexable fixture 5 mm above the measured surface, performing the measurements in twelve angular positions with 15° intervals, where 0° refers to the detector collinear and 90° perpendicular to the specimen axis (see figure 1). Surface texture directionality was characterized using the angular spectrum analysis tool in SPIPTM software by Image Metrology on 1 mm × 1mm area topography measurement taken with a stylus profilometer Form Talysurf from Taylor Hobson. Stylus tip radius of 2 μm, resolution 0.25 μm in X tracing direction collinear to the specimen axis, 10 μm in Y, 2nd order Least Mean Square fit for form removal, λ_s 2.5 μm and λ_c 0.8 mm filtering were used prior to the analysis. Additionally, surface photographs were taken with an optical microscope to visually assess directionality of the surface texture (see figure 1).

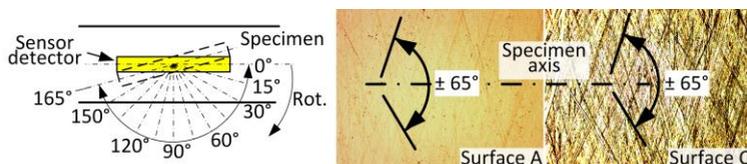


Figure 1: Orientation of sensor detector (left) and photographs of surfaces A and C.

3. Results and discussion

The angular spectrum analysis revealed two dominant texture directions with constant angle of $\pm 65^\circ$ relative to the specimen axis for all three investigated surfaces, which was affirmed by the surface photographs (see figure 1). The predominant effect of surface curvature can clearly be seen in figure 2 on the measurements on the finest surface A (see table 1), where A_q

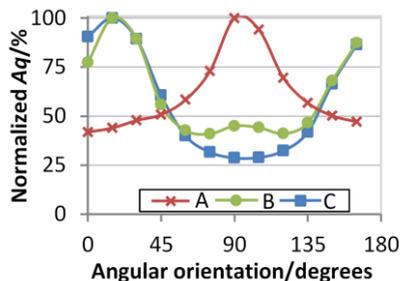


Figure 2: Normalized A_q in 12 angular sensor orientations on surfaces A, B, C. Normalized $A_q = [(A_q/A_{q,max}) \cdot 100]$.

increases by 139 % from 0° to 90° of the sensor orientation. This is caused by the additional slope due to the surface curvature widening the scattered light distribution (see figure 3), thus enlarging A_q (variance of the distribution).

In opposition to the curvature effect, texture directionality has a predominant effect on measurements of surfaces with higher roughness, causing a decrease in A_q by 42 % for surface B and 68 % for surface C for the sensor orientation from 0° to 90° (see table 1 and figure 2). This is due to the relative orientation of the unidirectional detector with respect to the spatially reflected light from the surface slopes causing a change in the distribution of the acquired light on the detector, thus affecting the A_q value (see figure 3). The reduction in intensity on surfaces with higher roughness is due to its portion scattered outside the range of the sensor ($\pm 16^\circ$). Simultaneous effect of the two factors, texture directionality and curvature, can be seen in figure 2 in the measurements on surface B. With the initial sensor displacement A_q drops due to the effect of the texture directionality, while it rises at around 90° of the sensor orientation due to the curvature with nearly constant absolute intensity I acquired.

Table1: Change in measured intensity I and A_q as the effect of sensor orientation.

Surface	$Ra/\mu\text{m}$	Change in I /%	Change in A_q /%
A	0.012 ± 0.001	20	139
B	0.032 ± 0.002	-4	-42
C	0.178 ± 0.010	-50	-68

Where change in % is calculated as the measured value at $\{[(90^\circ - 0^\circ)/0^\circ] \cdot 100\}$

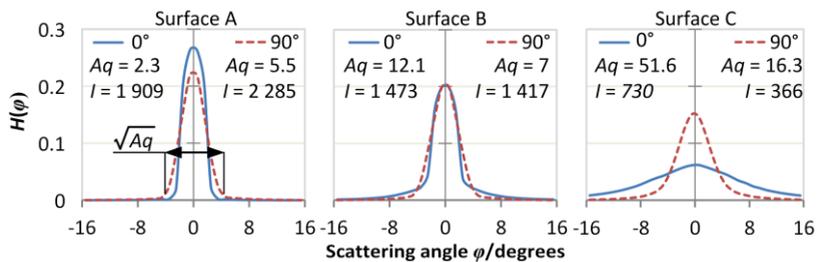


Figure 3: Normalized intensity function $H(\varphi)$ at scattering angles φ on surfaces A, B and C at 0° (collinear) and 90° (perpendicular), $Aq/a.u.$, $I/a.u.$ (a.u. is arbitrary unit).

4. Conclusions

The effect of angular orientation of a commercial scattered light sensor on roughness measurements of cylindrical polished surfaces with crossed surface lay was investigated and quantified. Surface texture directionality, curvature and roughness level are shown simultaneously affecting the measurement, and indications on proper sensor alignment are given. For the investigated surface textures, the optimal orientation of the sensor detector is collinear to the specimen axis and to the bisector of the two dominant surface lays, regardless of the roughness levels. In this way the effect of surface curvature is suppressed and the texture properly characterized.

Acknowledgements:

This work was co-funded by the EC FP7 collaborative project – “IFaCOM” (Project no. NMP-FoF 285489). The authors wish to thank Miriam Gambula from the University of Naples Federico II for performing part of the measurements.

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