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ROUND CORRECTION FACTORS

Corrections to be added to test results in the following scales for various diameter parts

Corrections to be added to Rockwell C, A, and D values

HARDNESS READING	DIAMETERS OF CONVEX CYLINDRICAL SURFACES								
	1/4 in. (6.4 mm)	3/8 in. (10 mm)	1/2 in. (13 mm)	5/8 in. (16 mm)	3/4 in. (19 mm)	7/8 in. (22 mm)	1 in. (25 mm)	1-1/4 in. (32 mm)	1-1/2 in. (38 mm)
20	6.0	4.5	3.5	2.5	2.0	1.5	1.5	1.0	1.0
25	5.5	4.0	3.0	2.5	2.0	1.5	1.0	1.0	1.0
30	5.0	3.5	2.5	2.0	1.5	1.5	1.0	1.0	0.5
35	4.0	3.0	2.0	1.5	1.5	1.0	1.0	0.5	0.5
40	3.5	2.5	2.0	1.5	1.0	1.0	1.0	0.5	0.5
45	3.0	2.0	1.5	1.0	1.0	1.0	0.5	0.5	0.5
50	2.5	2.0	1.5	1.0	1.0	0.5	0.5	0.5	0.5
55	2.0	1.5	1.0	1.0	0.5	0.5	0.5	0.5	0
60	1.5	1.0	1.0	0.5	0.5	0.5	0.5	0	0
65	1.5	1.0	1.0	0.5	0.5	0.5	0.5	0	0
70	1.0	1.0	0.5	0.5	0.5	0.5	0.5	0	0
75	1.0	0.5	0.5	0.5	0.5	0.5	0	0	0
80	0.5	0.5	0.5	0.5	0.5	0	0	0	0
85	0.5	0.5	0.5	0	0	0	0	0	0
90	0.5	0	0	0	0	0	0	0	0

Corrections to be added to Rockwell B, F, and G values

HARDNESS READING	DIAMETERS OF CONVEX CYLINDRICAL SURFACES						
	1/4 in. (6.4 mm)	3/8 in. (10 mm)	1/2 in. (13 mm)	5/8 in. (16 mm)	3/4 in. (19 mm)	7/8 in. (22 mm)	1 in. (25 mm)
0	12.5	8.5	6.5	5.5	4.5	3.5	3.0
10	12.0	8.0	6.0	5.0	4.0	3.5	3.0
20	11.0	7.5	5.5	4.5	4.0	3.5	3.0
30	10.0	6.5	5.0	4.5	3.5	3.0	2.5
40	9.0	6.0	4.5	4.0	3.0	2.5	2.5
50	8.0	5.5	4.0	3.5	3.0	2.5	2.0
60	7.0	5.0	3.5	3.0	2.5	2.0	2.0
70	6.0	4.0	3.0	2.5	2.0	2.0	1.5
80	5.0	3.5	2.5	2.0	1.5	1.5	1.5
90	4.0	3.0	2.0	1.5	1.5	1.5	1.0
100	3.5	2.5	1.5	1.5	1.0	1.0	0.5

Corrections to be added to Superficial Rockwell 15N, 30N, and 45N values

HARDNESS READING	DIAMETERS OF CONVEX CYLINDRICAL SURFACES					
	1/8 in. (3.2 mm)	1/4 in. (6.4 mm)	3/8 in. (10 mm)	1/2 in. (13 mm)	3/4 in. (19 mm)	1 in. (25 mm)
20	6.0	3.0	2.0	1.5	1.5	1.5
25	5.5	3.0	2.0	1.5	1.5	1.0
30	5.5	3.0	2.0	1.5	1.0	1.0
35	5.0	2.5	2.0	1.5	1.0	1.0
40	4.5	2.5	1.5	1.5	1.0	1.0
45	4.0	2.0	1.5	1.0	1.0	1.0
50	3.5	2.0	1.5	1.0	1.0	0.5
55	3.5	2.0	1.5	1.0	0.5	0.5
60	3.0	1.5	1.0	1.0	0.5	0.5