

# Mitutoyo

Mitutoyo Quality

## SURFTEST SJ-310 SERIES

PORTABLE SURFACE ROUGHNESS TESTER

FORM MEASUREMENT



Bulletin No. 2141(2)

## The Surftest SJ-310 is a compact, portable, easy-to-use surface roughness measurement instrument equipped with extensive measurement and analysis features.



### Easy to use

#### Large color graphic LCD

The color touch-screen provides excellent readability and an intuitive display that is easy to negotiate. The LCD also includes a backlight for improved visibility in dark environments. The integrated printer allows you to print measurement results on the spot.

### Highly functional

#### Internal memory

Up to 10 measurement conditions and one measured profile can be stored in the internal memory.

#### Optional memory card

The optional memory card can be used as an extended memory to store large quantities of measured profiles and conditions and adds the convenience of automatically saving data from the 10 most recent measurements (Trace 10).

#### Password protection

Access to each feature can be password-protected, which prevents unintended operations and allows protection of your settings.

#### Multilingual support

The display interface supports 16 languages, which can be freely switched.

#### Stylus alarm (patent pending in Japan, U.S.A., EU)

An alarm warns you when the cumulative measurement distance exceeds a preset limit.

### Extensive analysis and display features

#### Complies with many industry standards

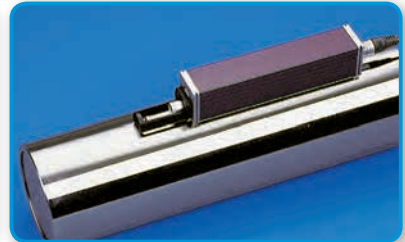
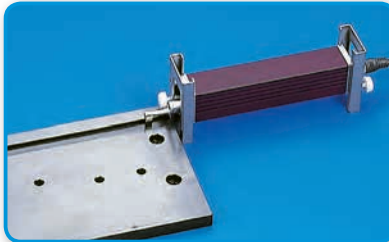
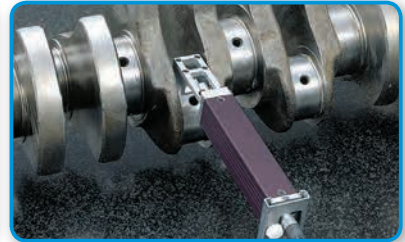
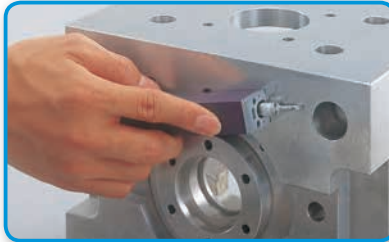
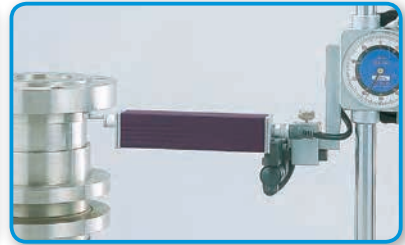
The Surftest SJ-310 complies with the following standards: JIS (JIS-B0601-2001, JIS-B0601-1994, JIS-B0601-1982), VDA, ISO-1997, and ANSI.

#### Displays assessed profiles and graphical data

In addition to calculation results, the Surftest SJ-310 can display sectional calculation results and assessed profiles, load curves, and amplitude distribution curves.

### Enhanced power for making measurements on site

Despite its reduced charging time — approximately 1/4 that required for conventional models, the Surftest SJ-310 is capable of making approximately 2.5 times the number of measurements when fully charged. The detector supports a variety of measurement orientations and can make measurements up against a wall surface or while facing upward. When combined with optional accessories such as a height gauge adapter, the detector can make measurements in various orientations and settings.



## User friendly, high-functionality display unit with integrated high-speed printer

The large 5.7-inch color graphic touch-screen LCD provides excellent readability. Furthermore, selecting icons from the touch panel display\*1 provides intuitive and easy operation. The integrated high-speed printer also allows the user to perform the entire process from making measurements to printing the results with the push of a single button (START button). \*1 Text display can also be selected.

**Printer**  
BAC and ADC curves can be printed in addition to calculation results (including pass/fail results) and assessed profiles. The printer offers an easy-to-understand layout and can also print horizontally to match the content displayed on the LCD. Furthermore, printing speed is approximately 50% faster than conventional models.

**5.7-inch color graphic LCD with touch screen**  
Measurement Result Measured profile ↔ One-touch switching BAC curve ADC curve

**Key-sheet buttons**  
Frequently used functions, such as the measurement start button, are provided as rugged sheet buttons with excellent durability.

**Built-in battery**  
With drastically enhanced power compared to conventional models, the Surftest SJ-310 can make 1,500 continuous measurements on a full charge achieved in 4 hours.

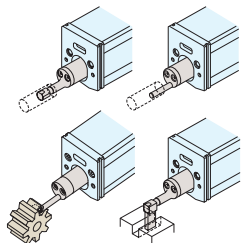
## Highly functional detectors and drive units

### Detector supplied as standard

One of two types may be selected:

- Measuring force: 0.75mN  
Stylus form: Tip radius 2µm  
Tip angle 60°
- Measuring force: 4mN  
Stylus form: Tip radius 5µm  
Tip angle 90°

A wide range of optional detectors is available, including detectors for small holes, extra small holes, gear tooth surfaces, and deep grooves.



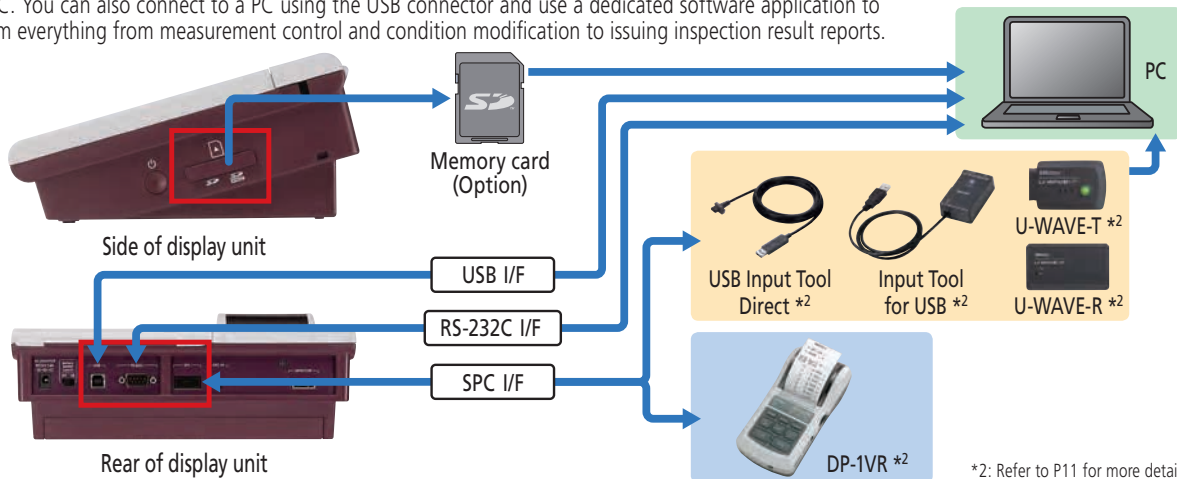
### Drive units

- **Standard drive unit**
  - Popular standard drive unit
- **Transverse tracing drive unit**
  - Best suited for measurement of narrow, shrouded workpiece features such as crankshaft bearings, EDM parts, etc. (Patent Registered in Japan)
- **Retractable drive unit**
  - The detector is in the retracted position at rest so it is immune from damage when inserted into a feature whose shape cannot be easily seen, such as a blind hole, etc.



## Links to a wide variety of external instruments

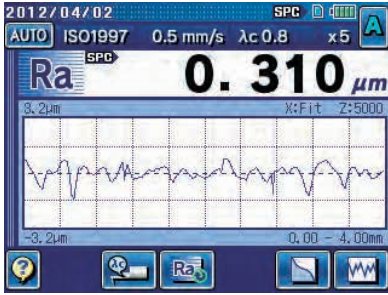
You can save parameter recalculations and measurement results in text format on a memory card and import into commercial spreadsheet software on a PC. You can also connect to a PC using the USB connector and use a dedicated software application to perform everything from measurement control and condition modification to issuing inspection result reports.



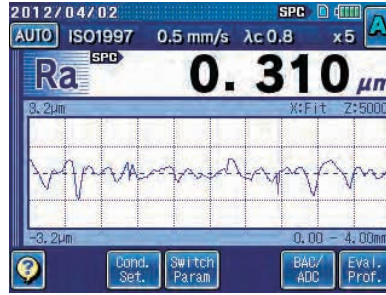
# Measurement assistance and analysis features offering the ultimate in ease of use

## Switches between icon and text display

The display can be switched between icon and text, providing easy, user-friendly operation. Additionally, the guidance feature provides detailed explanations of touch-screen buttons.



Icon

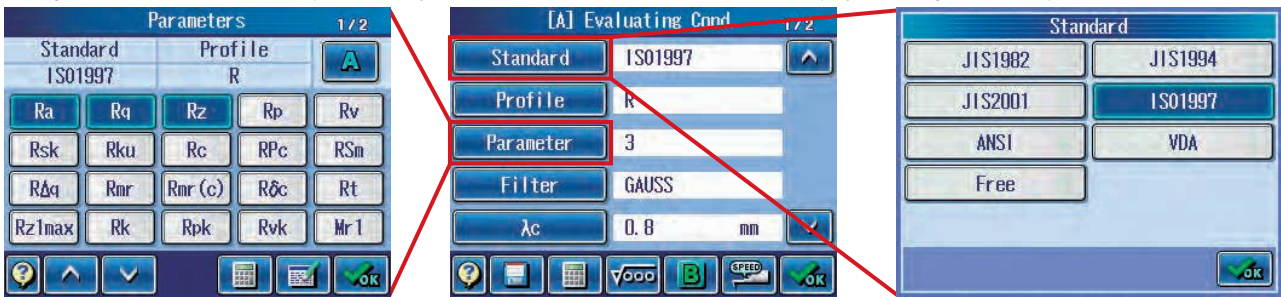


Text

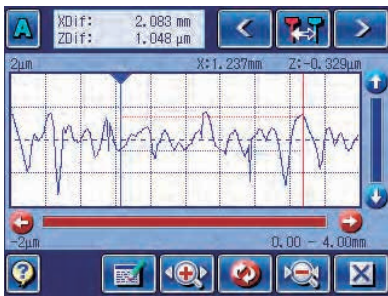


## Easy specification of assessment conditions from a list

Setting assessment conditions is simple because you can select the desired condition from a displayed list (e.g., standard, parameter).

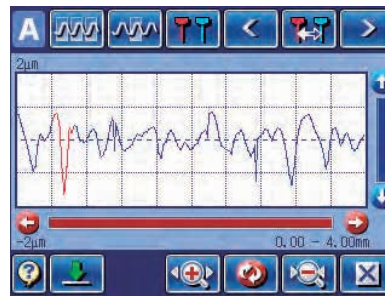


## Zooming waveforms and analyzing coordinate differences



You can not only magnify or shrink waveforms, but also calculate the coordinate difference between two points using a ruler operation. You can quickly check the irregularity status without waiting for a printout.

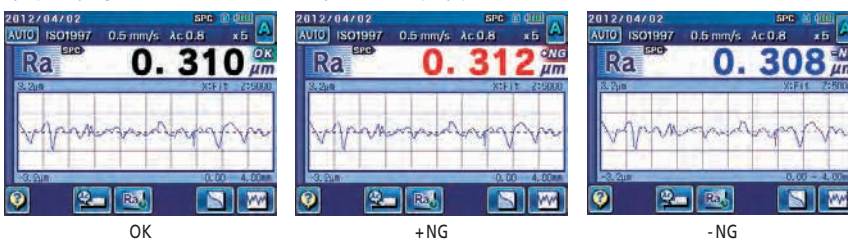
## Deleting unnecessary data



With the Surftest SJ-310, you can delete portions of measurement data. This feature allows you to make new calculations by deleting data that should not be included in parameter calculation, such as data on a scratch.

## Displaying pass/fail results

By specifying a tolerance in advance, you can display pass/fail results in color.



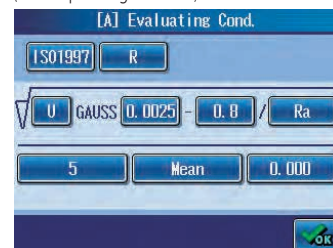
OK

+NG

-NG

## Surface texture symbol entry

You can enter assessment conditions using ISO/JIS surface texture symbols. (Patent registered in Japan, U.S.A., Germany, UK, France) (Patent pending in China)

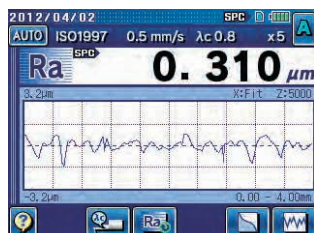


## Measurement results can be displayed in several ways

Measurement results can be presented in the form of a 1-parameter, profile, 4-parameter or trace display.



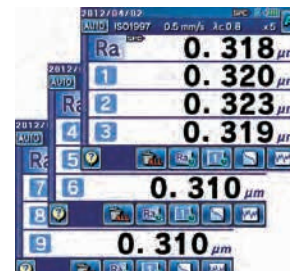
1-parameter display: one parameter measurement result



Profile display: one parameter measurement result and the measured profile



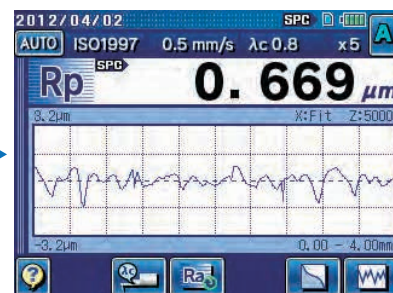
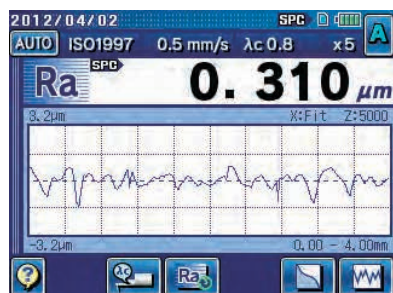
4-parameter display: four parameter measurement results



Trace display: the ten latest measurement results using the same parameter

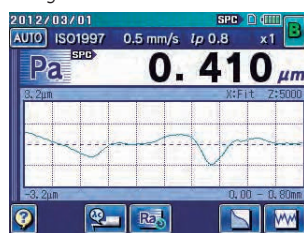
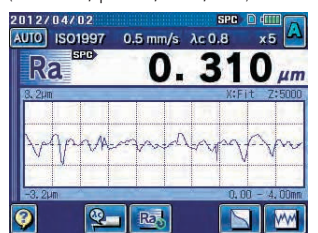
## Recalculation function

After completing measurement, you can modify the assessment conditions (standard, profile, and parameter) and easily recalculate the results using the new condition.\* \*Not possible with all measurement conditions.



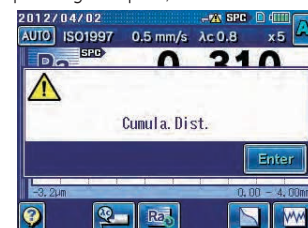
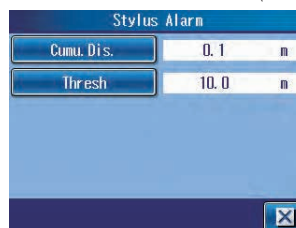
## Dual assessment of a single measurement

Using the result of a single measurement, you can make calculations or analyze assessment profiles under two different assessment conditions (standard, profile, filter, etc.) without using the recalculation feature.



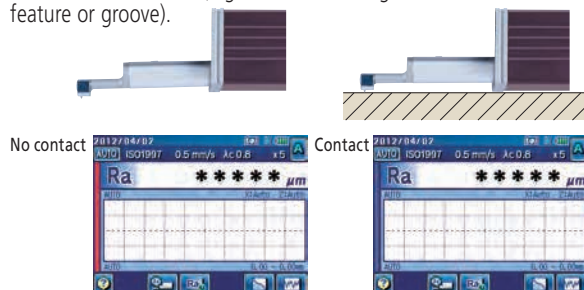
## Stylus alarm function

Displayed settings can be easily changed by pressing the left and right arrow keys under the sliding cover. For example, these keys can be used to switch the cut-off value(λc) and the number of sampling lengths (N) on the measurement screen. (Patent pending in Japan.)



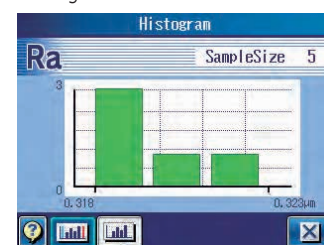
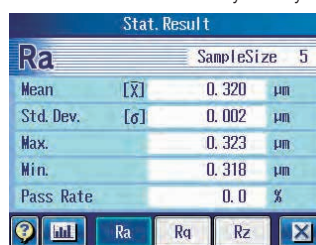
## Positive stylus contact indication

Stylus contact with the workpiece is indicated by color coding in the display. This is helpful when visibility of the surface to be measured is restricted (e.g. when measuring within a shrouded feature or groove).



## Extensive statistical processing features

You can make a maximum of 300 statistical measurements using up to three parameters to obtain averages, standard deviations, maximums, minimums, passing rates, and histograms (upper and lower limits can be displayed). This feature is ideal for day-to-day data management.



# Specifications

Specifications		Standard drive unit type		Retractable drive unit type		Transverse tracing drive unit	
Type of detector		SJ-310 (0.75mN type)	SJ-310 (4mN type)	SJ-310 (0.75mN type)	SJ-310 (4mN type)	SJ-310 (0.75mN type)	SJ-310 (4mN type)
Model No.		178-571-01A	178-571-02A	178-573-01A	178-573-02A	178-575-01A	178-575-02A
Order No.	inch/mm	178-571-01A	178-571-02A	178-573-01A	178-573-02A	178-575-01A	178-575-02A
X axis		.7" (17.5 mm)				.22" (5.6 mm)	
Measuring range	Range	14400 μinch (-7900 μinch to +6300 μinch) [360 μm (-200 μm ~ +160 μm)]					
	Detector Range/resolution	14400 μinch / .8 μinch (360 μm / 0.02 μm) 4000 μinch / .2 μinch (100 μm / 0.006 μm) 1000 μinch / .08 μinch (25 μm / 0.002 μm)					
Measuring speed		In the measurement: .01inch/s (0.25mm/s), .02inch/s (0.5mm/s), .03inch/s (0.75mm/s), In the return: .04inch/s (1mm/s)					
Measuring force / Stylus tip		0.75mN type: 0.75mN / 2μmR 60°, 4mN type: 4mN / 5μmR 90°					
Skid force		400mN or less					
Standard		JIS'82 / JIS'94 / JIS'01 / ISO'97 / ANSI / VDA / FREE					
Measured profiles		Primary(P), Roughness(R), DF, R-Motif, W-Motif					
Parameters		Ra, Rc, Ry, Rz, Rq, Rt, Rmax*1, Rp, Rv, R3z, Rsk, Rku, Rc, Rpc, Rsm, Rz1max*2, S, HSC, RzJIS*3, Rppi, RΔa, RΔq, Rlr, Rmr, Rmr(c), Rδc, Rk, Rpk, Rvk, Mr1, Mr2, A1, A2, Vo, λa, λg, Lo, Rpm, tp*4, Htp*4, R, Rx, AR, W, AW, Wx, Wte, Possible Customize					
Graph analysis		BAC and ADC curves					
Filter		Gaussian, 2CR75, PC75					
Cut-off length	$\frac{\lambda_c}{\lambda_s^{*5}}$	.003, .01, .03, .1, .3" (0.08, 0.25, 0.8, 2.5, 8 mm)					
Sampling length		.003, .01, .03, .1, .3" (0.08, 0.25, 0.8, 2.5, 8 mm)					
Number of sampling lengths		x1, x2, x3, x4, x5, x6, x7, x8, x9, x10, Arbitrary .0118 ~ .6299" (.0001" Interval) [(0.3 ~ 16.0mm: 0.01mm Interval)]				x1, x2, x3, x4, x5, x6, x7, x8, x9, x10, Arbitrary .0118 ~ .22" (.0001" Interval) [(0.3 ~ 5.6mm: 0.01mm Interval)]	
LCD dimensions		4.64" x 3.47" (117.8 x 88.2 mm)					
Display languages		Japanese, English, German, French, Italian, Spanish, Portuguese, Korean, Traditional Chinese, Simplified Chinese, Czech, Polish, Hungarian Turkish, Swedish, Dutch					
Measurement result display		1-parameter display: one parameter measurement result 4-parameter display: four parameter measurement results Profile display: one parameter measurement result and the measured profile Trace display: The ten latest measurement results using the same parameter					
Printing function		Measurement conditions / Calculation results / GO / NG judgement result / Calculation results for each sampling length / Measurement curve / BAC / ADC / Environmental setting information					
External I/O		USB I/F, Digimatic output, RS-232C I/F, External SW I/F					
Customization		Desired parameters can be selected for calculation and display					
GO/NG judgement *6		Max rule / 16% rule / Average rule / Standard deviation (1σ, 2σ, 3σ)					
Storage of measurement condition		Save the condition at power OFF					
Storage		Internal memory: Measurement condition (10 sets) Memory card (option): 500 measurement conditions, 1000 measuring data, 10000 text data, 500 statistic data, 500 image data, 1 backup of machine setting, the last ten traces (Trace 10)					
Calibration		Saves last inputted nominal value of specimen / Average calibration with multiple measurement (MAX.12 times) is available					
Power-saving		Auto-sleep function (30-600sec) *7					
Power supply		Two-way power supply: battery (rechargeable Ni-MH battery) and AC adapter *Charging time: about 4 hours (may vary due to ambient temperature) *Endurance: about 1500 measurements (differs slightly due to use conditions / environment)					
Size (WxDxH)	Display unit	10.8" x 4.3" x 7.8" (275 x 109 x 198 mm)					
	Drive unit	4.5" x 0.9" x 8.9" (115 x 23 x 26.7 mm)					
Mass		About 1.8kg (Display unit + Drive unit + Standard detector)					
Standard accessories		12AAM475	Connecting cable *8	12AAM475	Connecting cable *8	12AAM475	Connecting cable *8
		12AAA217	Nosepiece for plane surface	12AAE643	Point-contact adapter	12AAE644	V-type adapter
	12AAA218	Nosepiece for cylinder	12BAK700	Calibration stage	12BAG834	Stylus pen	
	12AAA216	Supporting leg	12BAL402	Protection sheet	270732	Printer paper (5 pieces)	
	12BAK700	Calibration stage	12BAL400	Carrying case	178-606	Roughness Reference Specimen (Ra 0.039μin/1.0μm)	
	12BAG834	Stylus pen	357651	AC Adapter	02ZAA010	Power Cord set (UL/CSA)	
	12BAL402	Protection sheet	02ZAA010	Power Cord set (UL/CSA)			
	270732	Printer paper (5 pieces)					
	12BAL400	Carrying case					
	178-602	Roughness reference specimen (Ra 119μin/3μm)					
	357651	AC Adapter					
	02ZAA010	Power Cord set (UL/CSA)					

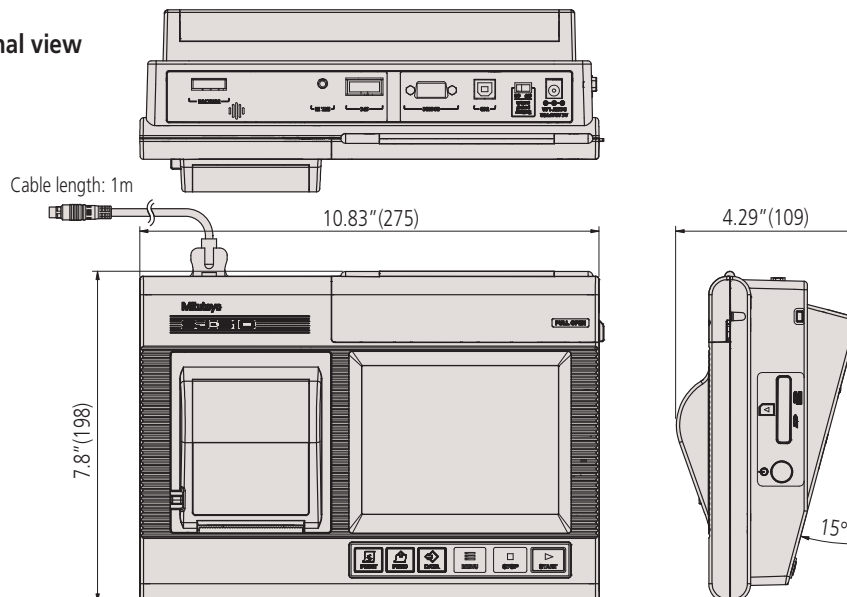
Philips screwdriver, Strap for stylus pen, Operation manual, Quick reference manual, Warranty

\*1: Only for VDA/ANSI/JIS'82 standards.  
\*2: Only for JIS'97 standard.  
\*3: Only for JIS'01 standard.  
\*4: Only for ANSI standard.  
\*5: λs may not be switchable depending on a standard selected.  
\*6: Standard deviation only can be selected in ANSI.16% rule cannot be selected in VDA.  
\*7: Auto-sleep function is invalid when AC adapter is used.  
\*8: For connecting the calculation display unit and drive unit.

# Dimensions: Display Unit and Drive Unit

Drive unit, Display unit		Unit: inch(mm)
Drive unit type	Drive unit external view	
Standard drive unit		
Retractable drive unit		
Transverse tracing drive unit		

## Display unit external view

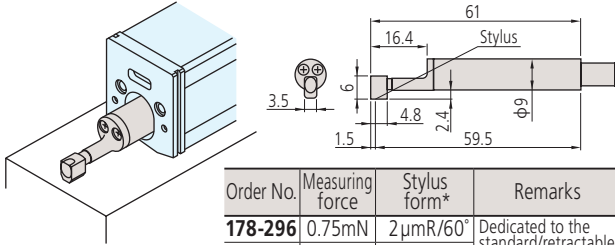


# Dimensions: Detectors

## Detectors

Unit: mm

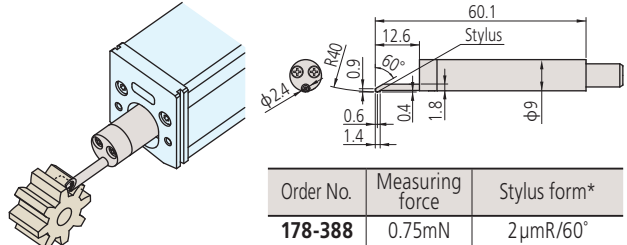
### Standard detectors



Order No.	Measuring force	Stylus form*	Remarks
<b>178-296</b>	0.75mN	2 μmR/60°	Dedicated to the standard/retractable drive unit
<b>178-390</b>	4 mN	5 μmR/90°	
<b>178-387</b>	0.75mN	2 μmR/60°	Dedicated to the transverse tracing drive unit
<b>178-386</b>	4 mN	5 μmR/90°	
<b>178-395</b>	0.75mN	2 μmR/90°	Dedicated to the standard/retractable drive unit
<b>178-391</b>	4 mN	10 μmR/90°	

\*Tip radius / Tip angle

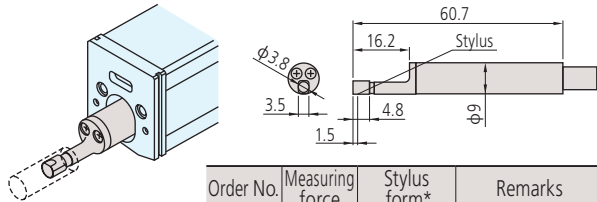
### Gear-tooth surface detectors



Order No.	Measuring force	Stylus form*
<b>178-388</b>	0.75mN	2 μmR/60°
<b>178-398</b>	4 mN	5 μmR/60°

\*Tip radius / Tip angle

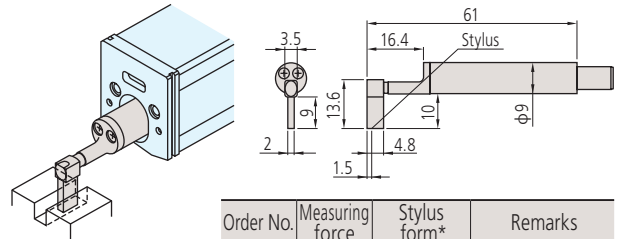
### Small hole detectors



Order No.	Measuring force	Stylus form*	Remarks
<b>178-383</b>	0.75mN	2 μmR/60°	Minimum measurable hole diameter: φ4.5mm
<b>178-392</b>	4 mN	5 μmR/90°	

\*Tip radius / Tip angle

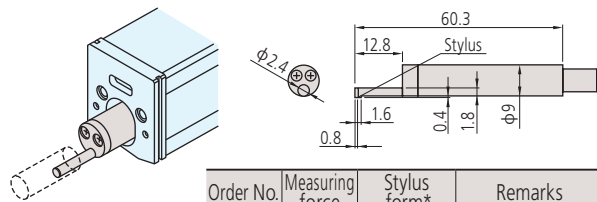
### Deep groove detectors



Order No.	Measuring force	Stylus form*	Remarks
<b>178-385</b>	0.75mN	2 μmR/60°	Not available for the transverse tracing drive unit
<b>178-394</b>	4 mN	5 μmR/90°	

\*Tip radius / Tip angle

### Extra small hole detectors



Order No.	Measuring force	Stylus form*	Remarks
<b>178-384</b>	0.75mN	2 μmR/60°	Minimum measurable hole diameter: φ2.8mm
<b>178-393</b>	4 mN	5 μmR/90°	

\*Tip radius / Tip angle



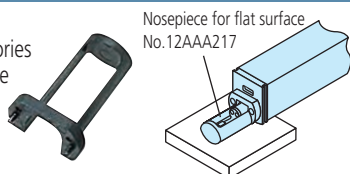
# Dimensions: Display Unit and Drive Unit

## Drive unit, Display unit

### Nosepiece for flat surfaces

#### No. 12AAA217

- SJ-310/310R standard accessories
- Not available for the transverse tracing drive unit.



### Nosepiece for cylindrical surfaces

#### No. 12AAA218

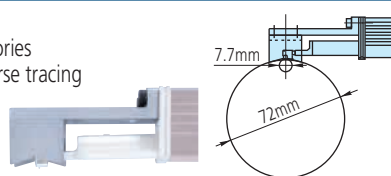
- SJ-310/310R standard accessories
- Not available for the transverse tracing drive unit.
- $\phi 30$ mm or smaller workpiece.



### V-type adapter

#### No. 12AAE644

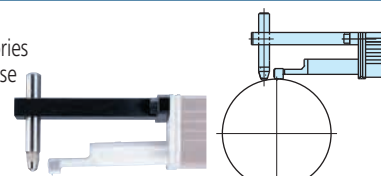
- SJ-310S standard accessories
- Dedicated to the transverse tracing drive unit.



### Point-contact adapter

#### No. 12AAE643

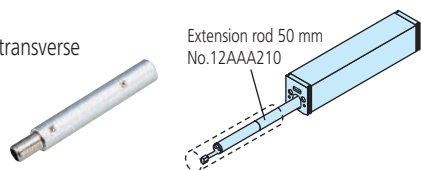
- SJ-310S standard accessories
- Dedicated to the transverse tracing drive unit.



### Extension rod (50 mm)

#### No. 12AAA210

- Not available for the transverse tracing drive unit.



### Extension cable (1 m)

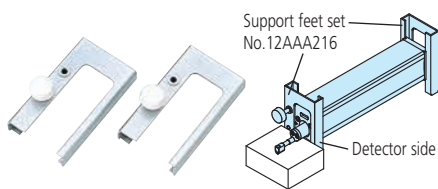
#### No. 12BAA303

- For connecting calculation display unit and drive unit.

### Support feet set

#### No. 12AAA216

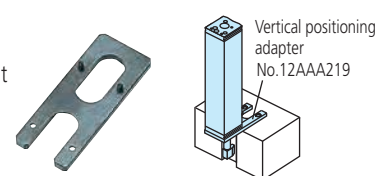
- SJ-310 standard accessory
- Not attachable to the detector side of the transverse tracing drive unit.



### Vertical positioning adapter

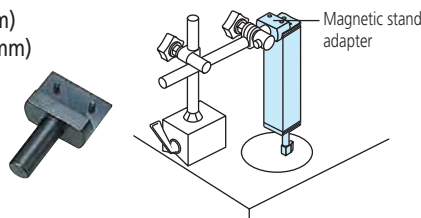
#### No. 12AAA219

- Not available for the transverse tracing drive unit



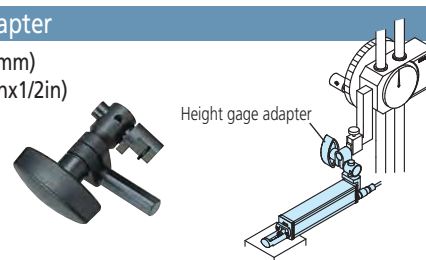
### Magnetic stand adapter

- No. 12AAA221( $\phi 8$ mm)
- No. 12AAA220( $\phi 9.5$ mm)



### Height gage adapter

- No. 12AAA222(9x9mm)
- No. 12AAA233(1/4inx1/2in)



## Setting attachments

(Note: Not available for the transverse tracing drive unit)

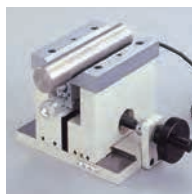
Enhances measurement efficiency by facilitating the measurement setup of multiple workpieces of the same type and of the hard-to-access sections of a workpiece.

### V-type for measuring axially

#### No. 178-033

The V-width is adjustable to the cylindrical workpiece diameter, facilitating axial measurement of a wide range workpiece sizes.

- Adjustable range:  
 $\phi 5 \sim 150$  mm



### Slider type

#### No. 178-034

This attachment is ideal for measuring a flat area of a workpiece that has an indentation or step that makes it difficult to attach the drive unit. You can further improve the ease of use by using this attachment with the magnetic installation base (option: No. 12AAA910).



### Inside diameter type

#### No. 178-035

Greatly facilitates measurement of internal wall surfaces of, for example, a cylinder block.

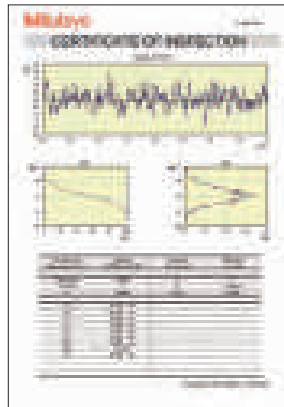
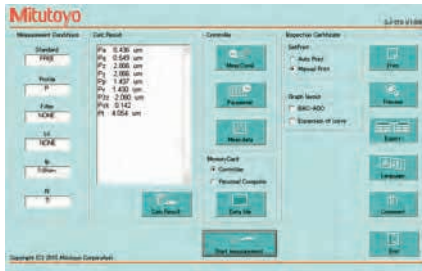
- Applicable diameter:  
 $\phi 75 \sim \phi 95$  mm
- Accessible depth:  
30 ~ 135 mm



# Optional Accessories: For External Output

## Simplified communication program for SURFTEST SJ series

The SurfTest SJ-310 series has a USB interface, enabling data to be transferred to a spreadsheet or other software. We also provide a program that lets you create inspection record tables using a Microsoft Excel\* macro.



**Required environment\*:**

- OS:
  - Windows XP-SP3
  - Windows Vista
  - Windows 7/8/10
- Spreadsheet software:
  - Microsoft Excel 2000/2002/2003/2007/2010/2013/2016

\*Windows OS and Microsoft Excel are products of Microsoft Corporation.

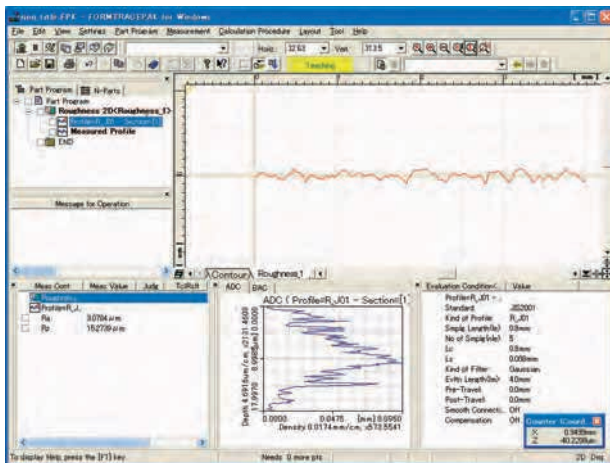
**Required environment\*:**

- USB cable for SJ-310 series  
No. 12AAD510

This program can be downloaded free of charge from the Mitutoyo website.  
<http://www.mitutoyo.com>

## Contour / Roughness analysis software FORMTRACEPAK

More advanced analysis can be performed by loading SJ-310 series measurement data to software program FORMTRACEPAK via a memory card (option) for processing back at base.



# Optional Accessories: For External Equipment

## Digimatic mini processor DP-1VA

By connecting this printer to the Surftest SJ-310's digimatic output, you can print calculation results, perform a variety of statistical analyses, draw a histogram or D chart, and also perform complicated operations for X-R control charts.



No.264-505A

SJ-310→DP-1VA Connecting cable  
 1m: No.936937  
 2m: No.965014

## Calculation results input unit INPUT TOOL

This unit allows you to load Surftest SJ-310 calculation results (SPC output) into commercial spreadsheet software on a PC via a USB connector. You can essentially use a one-touch operation to enter the calculation results (values) into the cells in the spreadsheet software.



USB Input Tool Direct  
**USB-ITN-D**  
 No.06AFM380D



USB keyboard signal conversion type\*  
**IT-012U**  
 No.264-016-10

\*Requires the optional Surftest SJ-310 connection cable.

1m: No.936937  
 2m: No.965014

## Footswitch

A footswitch is used to trigger measurement. This tool is very useful in cases where you need to measure the same workpiece multiple times using jigs and other fixtures.



No.12AAJ088

## Measurement Data Wireless Communication System U-WAVE

This unit allows you to remotely load Surftest SJ-310 calculation results (SPC output) into commercial spreadsheet software on a PC.

You can essentially use a one-touch operation to enter the calculation results (values) into the cells in the spreadsheet software.



**U-WAVE-R**  
 (Connects to the PC)  
 No.02AZD810D



**U-WAVE-T \***  
 (Connects to the SJ-310)  
 No.02AZD880G

\*Requires the optional Surftest SJ-310 connection cable.

No.02AZD790D

## Optional accessories and consumables for SJ-310

- Printer paper (5 rolls) **No.270732**
- Durable printer paper (5 rolls) **No.12AAA876**
- Touch-screen protector sheet (10 sheets) **No.12AAN040**
- Memory card (2GB) \* **No.12AAL069**
- Connecting cable (for RS-232C) **No.12AAA882**

\*micro SD card (with a conversion adapter to SD card)



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Mitutoyo supports you from start to finish.**

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Apart from the basics of calibration and repair, Mitutoyo offers product and metrology training, as well as IT support for the sophisticated software used in modern measuring technology. We can also design, build, test and deliver measuring solutions and even, if deemed cost-effective, take your critical measurement challenges in-house on a sub-contract basis.



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