MESSTECHNIK

ENGINEERING
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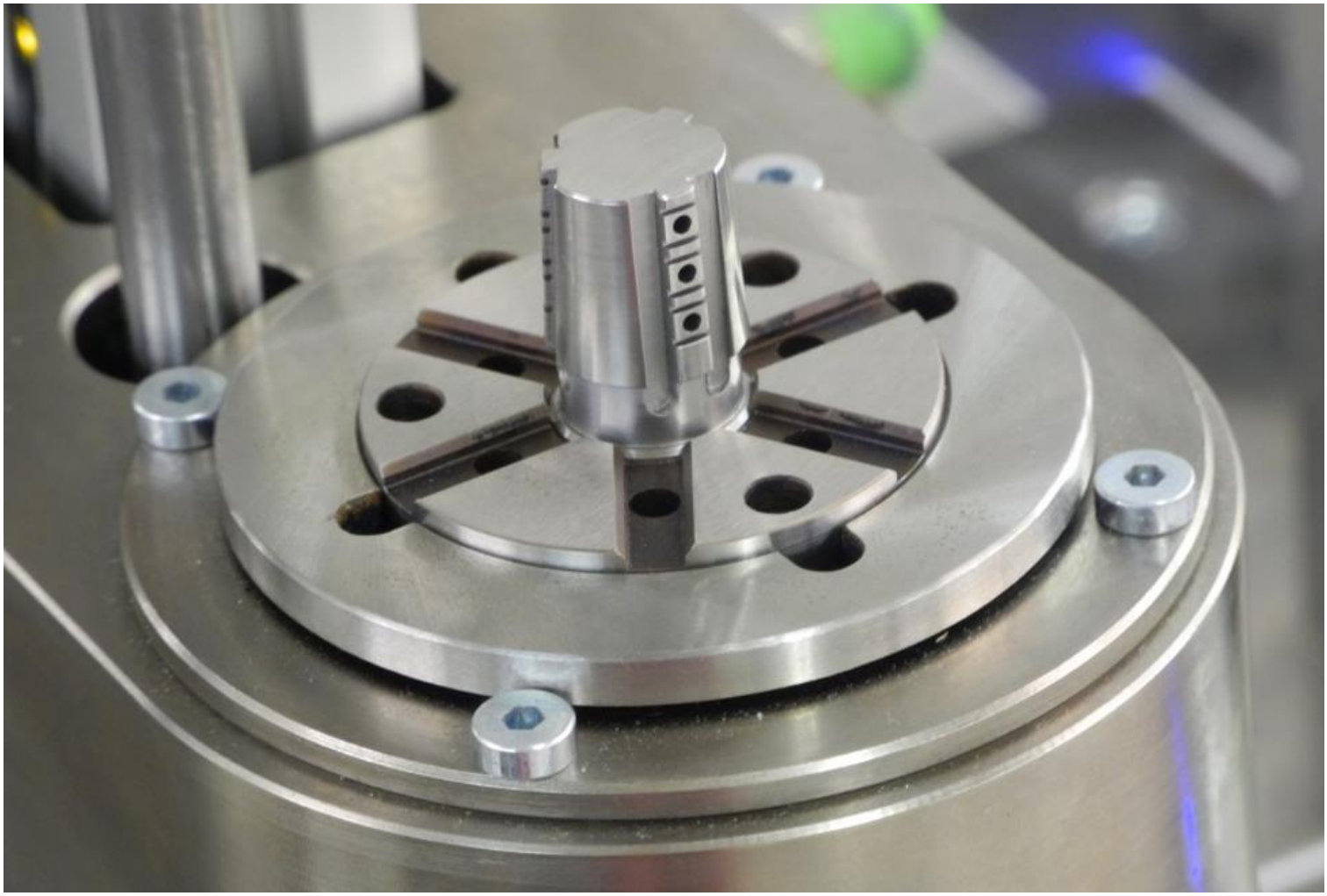
Measuring device for inner - cone

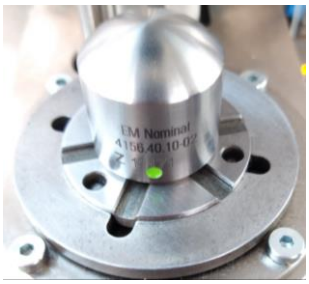


The universal inner cone measuring station

The use of air measurement technology in combination with VARIOsoft offers a universally applicable measuring device for a variety of different inner cones.

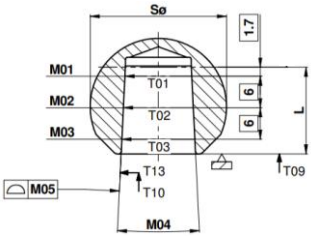
An overview of the advantages:

- Short measuring times with highest accuracy
- For 100% control directly next to the processing machine
- Automatic changeover for different workpieces
- Integrated VARIOsoft for measurement data analysis and documentation



Air gauge / Setting master

Straightness measurement



Ex. definition of characteristics

Diameter, cone angle and roundness

The workpiece is now positioned fully automatically via the support in such a way that an air gap is created and thus the part can be rotated. The air gap is searched for via a servo axis in combination with the piezo converter of the air nozzle in such a way that the air measurement takes place in the linear characteristic curve.
Measuring time: approx. 12 seconds (without workpiece handling)

The two characteristics diameter and cone angle are calibrated via the nominal master.

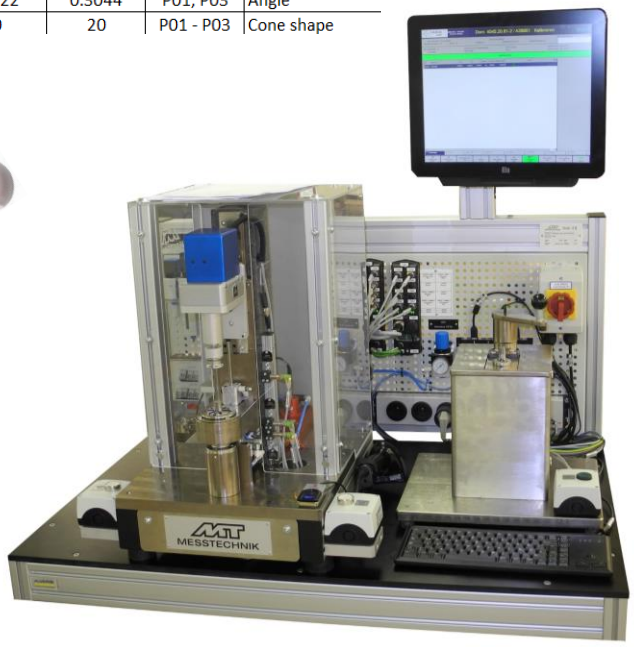
Straightness measurement

The air probe is installed slightly recessed in the mounting cone. This enables non-contact measurement of straightness. The air measuring nozzle moves vertically downwards along the cone.
Measuring time: approx. 6 seconds (without workpiece handling)

The straightness measuring device does not require calibration.

Characteristic	Nominal (mm)	UT (µm)	LT (µm)	Tol.- Field (µm)	Probe	Remarks
M01	Ø 12.87	25	-25	50	P01	Inner diameter
M02	Ø 13.46	25	-25	50	P02	Inner diameter
M03	Ø 14.06	25	-25	50	P03	Inner diameter
M04	5.7395°	0.1522	-1522	0.3044	P01, P03	Angle
M05	0	20	0	20	P01 - P03	Cone shape

Typical workpieces



Options:

Barcode scanner for order entry and selection of the respective inspection plan

User recognition with fingerprint reader. Automatic assignment of the user interface to the various programming levels in VARIOsoft.

Messtechnik AG Messinastrasse 7, 9495 Triesen, Liechtenstein
T. +423 399 2121, F. +423 399 2122, www.messtechnik.li

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