

KELCH

Vorsprung durch Präzision und Effizienz

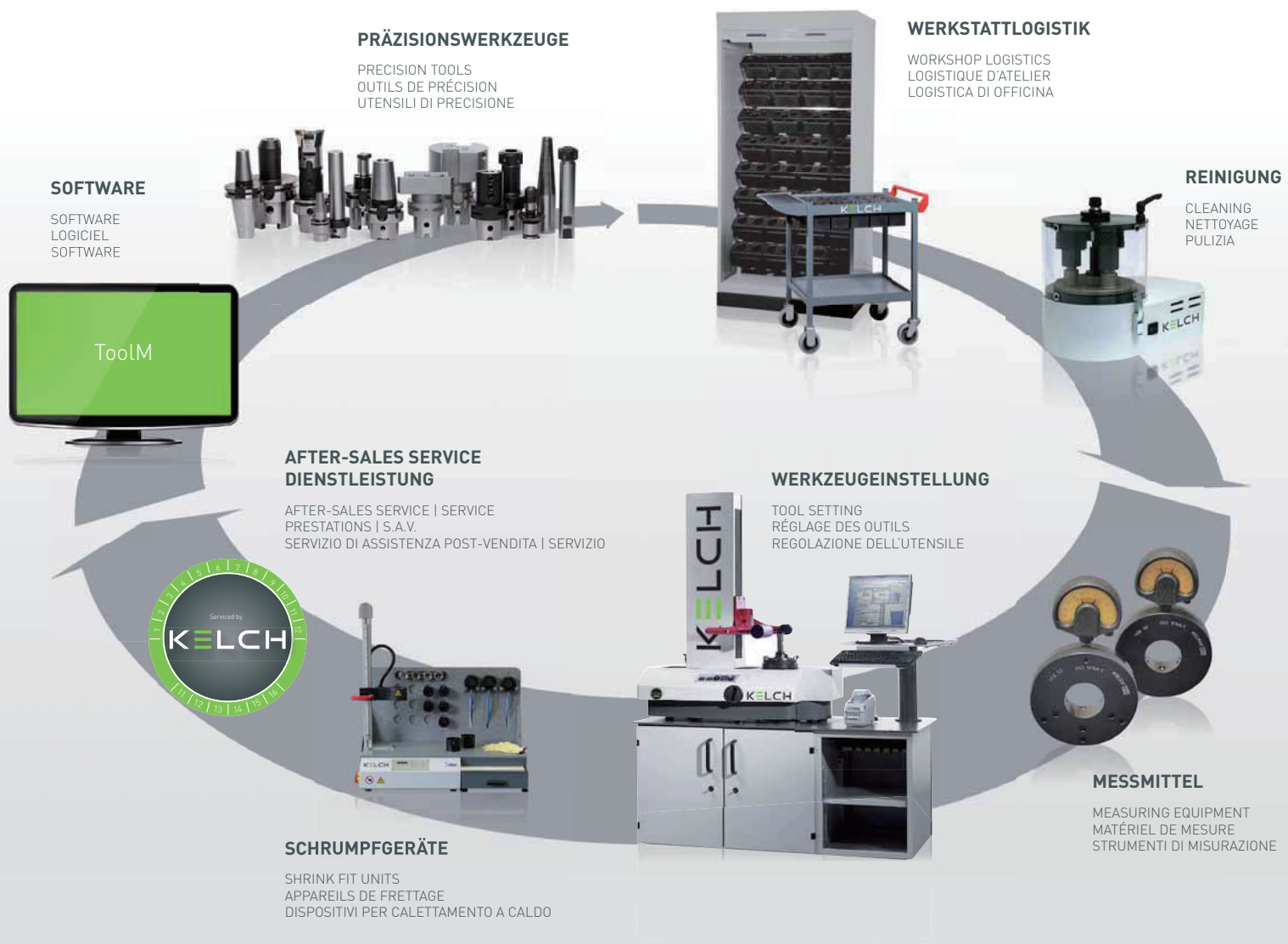
检测系统

Prüfsystem

2025

德国凯狮有限责任公司

KELCH GMBH



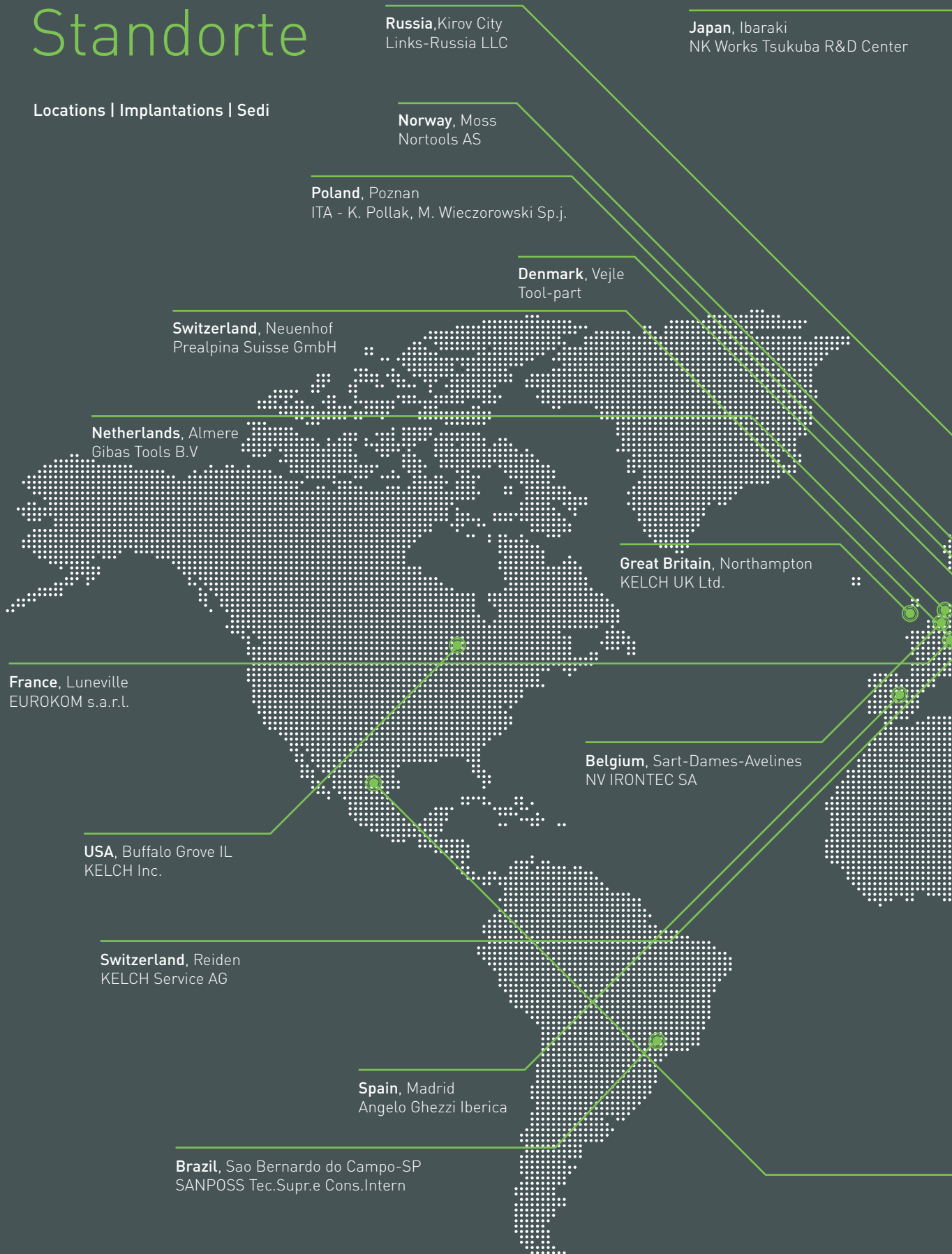
凯狮公司成立于1942年，公司坐落于德国西南部的工业城镇——魏恩施塔特，是德国知名的刀具及刀具检测制造企业之一。1997年，美国凯狮公司成立；1998年凯狮AG在瑞士成立；2002年英国凯狮公司成立；2005年，经过收购兼并与整合，成立新公司“KELCH & Links GmbH”，隶属于哈量集团。2009年，哈量集团与中国通用技术集团实现了联合重组，成为其控股子公司和先进制造业中的产业平台。

凯狮公司的主营业务包括数控刀具、热缩机、对刀仪、多功能配件以及一系列高质量的售前售后服务等。凯狮产品的主要客户群体面对汽车、航空航天工业、模具工业等终端客户以及刀具行业品牌供应商。依托德国严格、健全的质量认证和检验体系，极力保证与世界排名前列的刀具制造企业完全一致的品控标准，可满足多种切削要求。

几十年以来，凯狮公司的业务体系已经逐渐地形成了一个集售前售后为一体的服务闭环——“KEC” - KELCH效率圈。我们能够为客户提供最可靠的解决方案——从单个工具到金属切割的完整外围制造。它包括的产品和服务——单独或组合——在一个封闭的系统中提供令人印象深刻的性能：从精密工具和市场领先的预设置器到我们的智能工厂服务——一个完整的具有灵活组合模块的行业解决方案。随着业务范围不断扩大、服务质量不断提升，凯狮公司始终致力于为客户提供即时且满意的服务；且在中国通用技术集团的助力下，凯狮公司不断努力研发新产品，力求将产品和配套高质量的产品服务广泛应用于多个行业分支。

Standorte

Locations | Implantations | Sedi



Russia, Kirov City
Links-Russia LLC

Japan, Ibaraki
NK Works Tsukuba R&D Center

Norway, Moss
Nortools AS

Poland, Poznan
ITA - K. Pollak, M. Wieczorowski Sp.j.

Denmark, Vejle
Tool-part

Switzerland, Neuenhof
Prealpina Suisse GmbH

Netherlands, Almere
Gibas Tools B.V.

Great Britain, Northampton
KELCH UK Ltd.

France, Luneville
EUROKOM s.a.r.l.

Belgium, Sart-Dames-Avelines
NV IRONTEC SA

USA, Buffalo Grove IL
KELCH Inc.

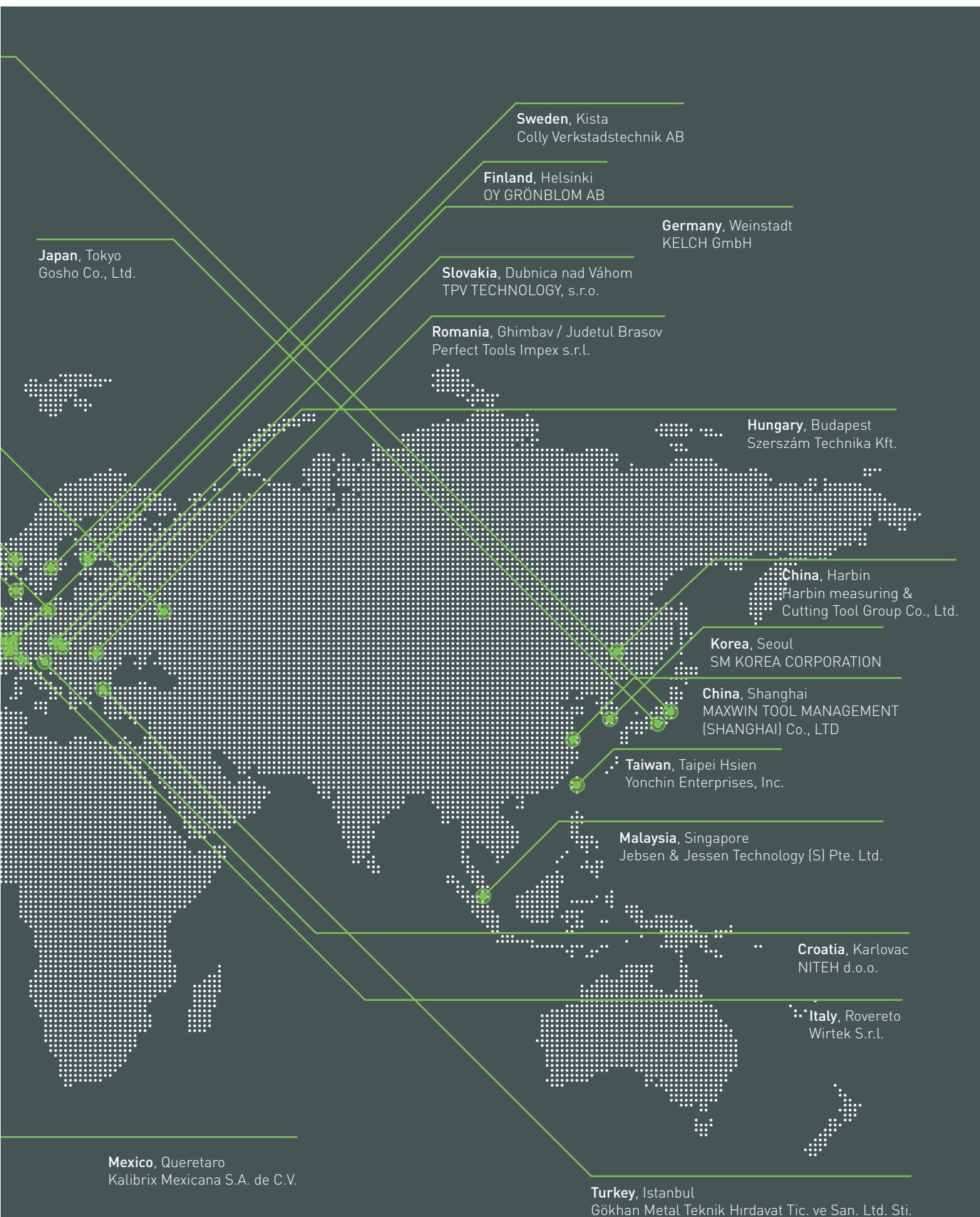
Switzerland, Reiden
KELCH Service AG

Spain, Madrid
Angelo Ghezzi Iberica

Brazil, Sao Bernardo do Campo-SP
SANPOSS Tec.Supr.e Cons.Intern

Viele schreiben Service groß – wir leben Service vor, denn KELCH ist dort, wo Sie sind. Unsere Stützpunkte und Partner finden Sie weltweit. Ein echtes Plus in Sachen Service.

Many companies talk about service - we practice it, KELCH is wherever you are. We have support offices and partners around the world. A real advantage in terms of service.



Certains parlent beaucoup de S.A.V., nous le vivons, car KELCH est là où vous êtes. Vous trouverez dans le monde entier des centres d'assistance KELCH. Un véritable «plus» en matière de S.A.V.

Molti scrivono assistenza in grande; noi viviamo per l'assistenza, perché KELCH è dove siete voi. Troverete i nostri punti di assistenza in tutto il mondo. Un vero valore aggiunto in materia di assistenza.

检具系列 Measuring Gauges



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主轴拉力计套装
Safecontrol 4.0 Set



No.	Model	Size
309.300	拉力计主柄	Safecontrol 4.0 Base unit
309.301	转换套套装	SK 40/50
		HSK 50/63/100
		PSC 50/63/80
309.302	转换套套装	SK 30
		HSK 25/32/40/80
		PSC 32/40/100
309.304	转换套套装	HSK 25 bis 100
309.305	转换套套装	PSC 32 bis 100
309.306	转换套套装	SK 45/60 HSK125

- 备注:
- 此套装只有一个基础测量棒，并可以适配多种类型的主轴 (HSK,PSC,SK等)
 - 显示器带有重力感应
 - 测量范围宽 (0-100 KN)
 - 出色的测量精度(上限范围值的0.5%)
 - 仅基础设备需要重新校准
 - 屏幕显示测量值,手柄集成位置方向
 - 基本单元和适配器相互兼容且可互换
 - 校准和维修服务

用途:
数字测量系统,用于测量机床主轴以及加长杆、减速器和零点夹紧系统的拉力

功能:
通过精密力度感应杆和电阻丝应变仪实现检测目的。将其插入机床主轴并利用机床自身的夹紧系统后拉。实际后拉力由检测装置的读数器显示。

- Note:
- Only one Base unit for all tool holder types (HSK, PSC, SK etc.)
 - Display has 3D Sensor for rotating the display content
 - Big measuring range (1-100kN)
 - Excellent measuring accuracy(0.5 % of the upper range value)
 - Only the base device requires recalibration
 - Measured values appear on a display with position orientation integrated in the handle
 - The base unit and adapters are compatible with each other and interchangeable
 - Calibration and repair service

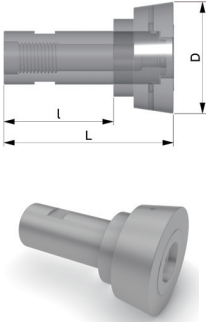
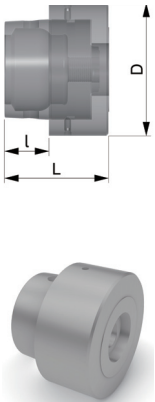
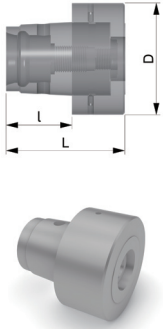
Use
Digital measuring system to measure the pull force of machine tool spindles as well as extensions,reducers and zero point clamping systems

Function
A precision force sensing bar with wire strain gauges does the measuring.It is inserted into the machine spindle and pulled back by the machine's clamping system.The actual pull-back power can be read directly from the read-out device.

主轴拉力计转换套

Safecontrol 4.0 Adapters

1

Sketch Map	NO.	Size	D	L	l
	309.311	SK 30	63	89	22
	309.312	SK 40	63	98	48
	309.315	BT 40	63	111	62
	309.316	SK 45	63	111.8	62.7
	309.313	SK 50	69.85	105.6	61.4
	309.314	SK 60	108	166	107
	309.331	HSK 25	63	57	7.6
	309.332	HSK 32	63	59	9.1
	309.333	HSK 40	63	53.75	13.5
	309.334	HSK 50	63	58.75	16.5
	309.335	HSK 63	63	63.75	21.5
	309.336	HSK 80	80	71	27
	309.337	HSK 100	100	78	33
	309.338	HSK 125	125	91.15	42.4
	309.322	PSC 32	63	61	18
	309.323	PSC 40	63	67	23
	309.324	PSC 50	63	73	29
	309.325	PSC 63	63	84	36
	309.326	PSC 80	80	85	47
	309.327	PSC 100	100	107	59

备注:

- 此套装只有一个基础测量棒,并可以适配多种类型的主轴(HSK,PSC,SK等)
- 显示器带有重力感应
- 测量范围宽(0-100 KN)
- 出色的测量精度(上限范围值的0.5%)
- 仅基础设备需要重新校准
- 屏幕显示测量值,手柄集成位置方向
- 基本单元和适配器相互兼容且可互换
- 校准和维修服务

用途:

数字测量系统,用于测量机床主轴以及加长杆、减速器和零点夹紧系统的拉力

功能:

通过精密力度感应杆和电阻丝应变仪实现检测目的。将其插入机床主轴并利用机床自身的夹紧系统后拉。实际后拉力由检测装置的读数器显示。

Note:

- Only one Base unit for all tool holder types (HSK, PSC, SK etc.)
- Display has 3D Sensor for rotating the display content
- Big measuring range (1-100kN)
- Excellent measuring accuracy(0.5 % of the upper range value)
- Only the base device requires recalibration
- Measured values appear on a display with position orientation integrated in the handle
- The base unit and adapters are compatible with each other and interchangeable
- Calibration and repair service

Use

Digital measuring system to measure the pull force of machine tool spindles as well as extensions, reducers and zero point clamping systems

Function

A precision force sensing bar with wire strain gauges does the measuring. It is inserted into the machine spindle and pulled back by the machine's clamping system. The actual pull-back power can be read directly from the read-out device.

2.1 通用精度检验棒

008

DIN 228型莫氏锥度检验棒

008

DIN 69893-1型HSK-A检验棒

009

DIN 69893-1型HSK-C检验棒

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DIN 69893-3型HSK-T检验棒

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ISO 26623-1型PSC检验棒

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ISO 7388型SK检验棒

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DIN 69871型JT检验棒（带法兰）

014

JIS B 6339型BT检验棒（带法兰）

015

Double contact JIS B 6339 型BT-FC检验棒

016

ISO 26622型UTS检验棒

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2.2 高精度检验棒

018

DIN 69893-1型HSK-A检验棒（十字键槽）

018

DIN 69893-3型HSK-T检验棒

019

ISO 26623-1型PSC检验棒

020

Double Contact JIS B 6339型BT-FC检验棒

021

ISO 26622型UTS检验棒

022

2.3 行程轴检验棒

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轴承内环式

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027

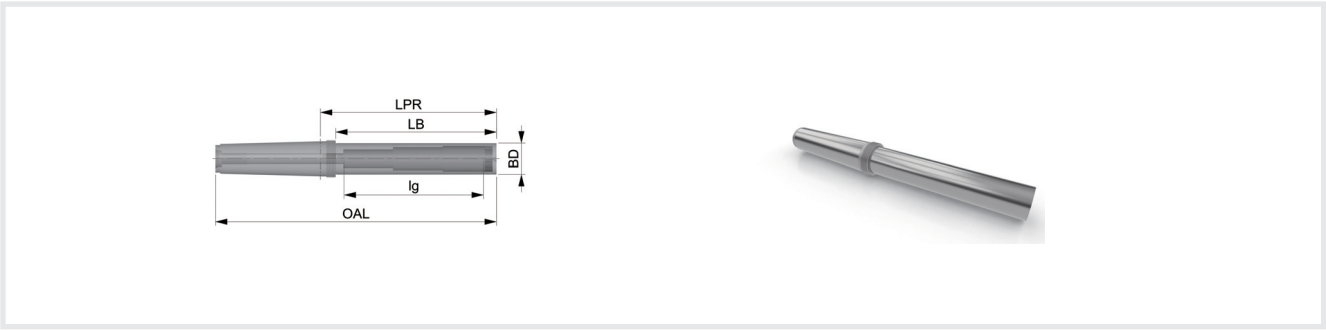
Gauge Bars

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通用精度检验棒
General Accuracy Gauge Bar

DIN 228型莫氏锥度检验棒
DIN 228 Morse Taper Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL
440.0001.170	MK2-BG24-150A2	2	24	150	175	154.3	239
440.0002.170	MK3-BG32-200A2	3	32	200	235	213.5	315.5
440.0003.170	MK4-BG40-300A2	4	40	300	335	312.7	437.7
440.0004.170	MK5-BG40-300A2	5	40	300	335	311.7	464.7
440.0005.170	MK6-BG63-300A2	6	63	300	335	310.1	516.1
440.0006.170	MK80-BG63-300A2	80	63	300	335	308.5	531

用途:
依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:
立式放置的木架。

备注:
1.lg=有效测量长度。
2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
3.可根据客户需求进行定制。
4.圆柱度公差值为0.003mm。

Use:
For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:
With wooden stand for vertical storage.

Note:
1.lg = effective measuring length.
2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
3.Can be customized according to customer needs.
4.The tolerance value for cylindricity is 0.003mm.

DIN 69893-1型HSK-A检验棒

DIN 69893-1 HSK-A Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
418.0001.319	HSK-A32-BG25-150	32	25	150	176	160	192	32
418.0001.320	HSK-A40-BG25-150	40	25	150	180	160	200	40
418.0001.321	HSK-A50-BG32-200	50	32	200	236	210	261	50
418.0001.322	HSK-A63-BG40-300	63	40	300	346	320	378	63
418.0001.323	HSK-A80-BG40-300	80	40	300	346	320	386	80
418.0001.324	HSK-A100-BG40-300	100	40	300	349	320	399	100
418.0001.325	HSK-A125-BG40-300	125	40	300	349	320	412	125
418.0001.326	HSK-A160-BG40-300	160	40	300	400	369	480	160

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空, 以保证检测结果不受重量影响。
- 3.检测棒也用于DIN 69893标准的E和F型柄。
- 4.可根据客户需求进行定制。
- 5.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

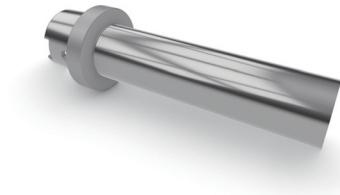
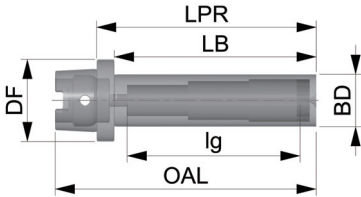
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.The test arbors can also be usedfor DIN 69 893 type E and F.
- 4.Can be customized according to customer needs.
- 5.The tolerance value for cylindricity is 0.003mm.

DIN 69893-1型HSK-C检验棒

DIN 69893-1 HSK-C Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
418.0001.340	HSK-C32-BG25-150	32	25	150	176	160	192	32
418.0001.341	HSK-C40-BG25-150	40	25	150	180	160	200	40
418.0001.342	HSK-C50-BG32-200	50	32	200	236	210	261	50
418.0001.343	HSK-C63-BG40-300	63	40	300	346	320	378	63
418.0001.344	HSK-C80-BG40-300	80	40	300	346	320	386	80
418.0001.345	HSK-C100-BG40-300	100	40	300	349	320	399	100
440.0007.170	HSK-C125-BG40-300	125	40	300	349	320	412	125
440.0008.170	HSK-C160-BG40-300	160	40	300	400	369	480	160

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
- 3.检测棒也用于DIN 69893标准的E和F型柄。
- 4.可根据客户需求进行定制。
- 5.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

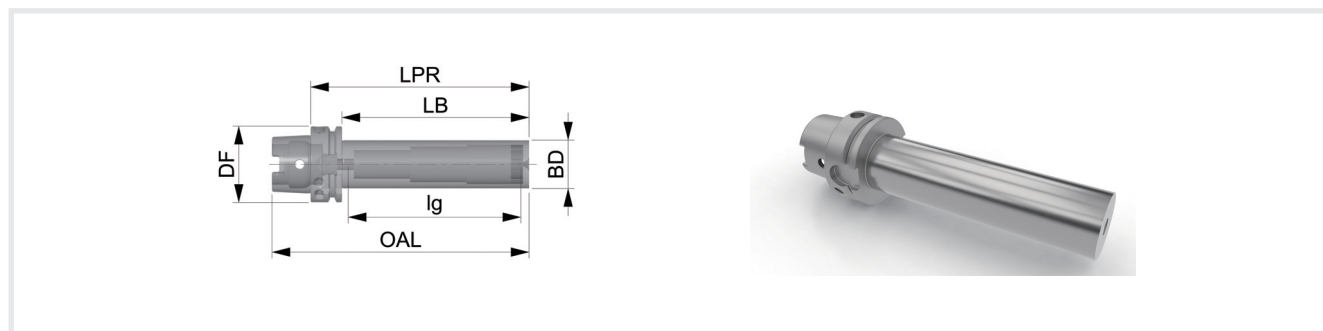
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.The test arbors can also be usedfor DIN 69 893 type E and F.
- 4.Can be customized according to customer needs.
- 5.The tolerance value for cylindricity is 0.003mm.

DIN 69893-3型HSK-T检验棒

DIN 69893-3 HSK-T Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0009.170	GGBDIN69893TNF32150M	32	25	150	176	160	192	32
440.0010.170	GGBDIN69893TNF40150M	40	25	150	180	160	200	40
440.0011.170	GGBDIN69893TNF50200M	50	32	200	236	210	261	50
440.0012.170	GGBDIN69893TNF63300M	63	40	300	346	320	378	63
440.0013.170	GGBDIN69893TNF80300M	80	40	300	346	320	386	80
440.0014.170	GGBDIN69893TNF100300M	100	40	300	349	320	399	100
440.0015.170	GGBDIN69893TNF125300M	125	40	300	349	320	412	125
440.0016.170	GGBDIN69893TNF160300M	160	40	300	400	369	480	160

用途:

依据ISO标准推荐的R230方法用于车铣复合机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
- 3.相较于A型,拥有更高的键槽定位精度。
- 4.可根据客户需求进行定制。
- 5.圆柱度公差值为0.003mm。

Use:

For the acceptance test of turn-milling compound machine tools in accordance with the ISO recommendation R 230.

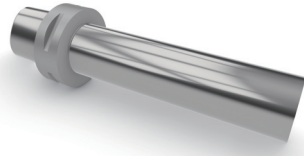
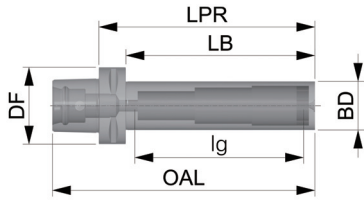
Standard Specification:

With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Compared with type A, it has higher keyway positioning accuracy.
- 4.Can be customized according to customer needs.
- 5.The tolerance value for cylindricity is 0.003mm.

ISO 26623-1型PSC检验棒
ISO 26623-1 PSC Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
418.0001.381	GGBISO26623NF32150M	32	25	150	175	160	194	32
418.0001.382	GGBISO26623NF40150M	40	25	150	180	160	204	40
418.0001.383	GGBISO26623NF50200M	50	32	205	235	215	265	50
418.0001.384	GGBISO26623NF63300M	63	40	290	322	300	360	63
418.0001.385	GGBISO26623NF80300M	80	40	290	330	300	300	80

2

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
- 3.可根据客户需求进行定制。
- 4.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

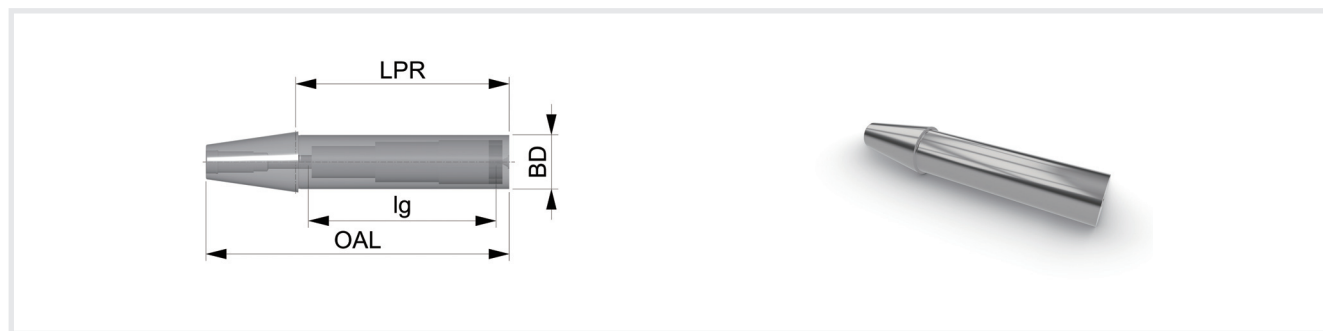
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Can be customized according to customer needs.
- 4.The tolerance value for cylindricity is 0.003mm.

ISO 7388型SK检验棒

ISO 7388 SK Gauge Bars with Flange



NO.	Model	Size	BD	lg	LPR	OAL
018.114	-	30	32	200	210	259
018.115*	-	40	40	300	320	389
018.117	-	50	40	300	320	422
440.0080.170	GGBISO73883NF60400M	60	80	400	437	600

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空, 以保证检测结果不受重量影响。
- 3.该检验棒也能用于JIS B6339标准。
- 4.*SK 40检验棒按DIN 69871标准规定的柄部长度(l1=68.4)生产。为配合MAS-BT SK 40刀柄(l1=65.4)使用该检测棒拉钉长度需比正常短3mm。该附件也可向凯狮订购。
- 5.可根据客户需求进行定制。
- 6.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

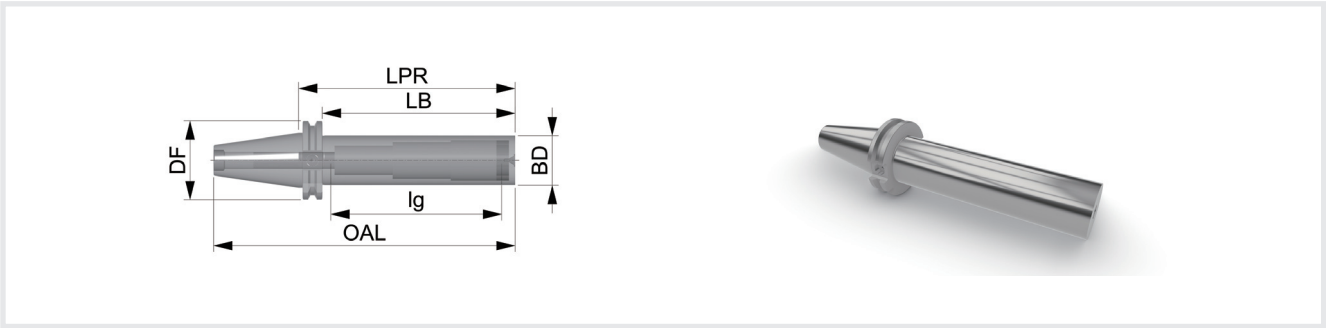
Standard Specification:

With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.The test arbors can also be used for JIS B 6339.
- 4.* The test arbor SK 40 is manufactured according to the taper length of DIN 69871 (l1=68.4).In order to also be able to use this test arbor for the MAS-BT SK 40 taper length (l1=65.4),a pull stud shortened by 3 mm is required. This can also be ordered from KELCH.
- 5.Can be customized according to customer needs.
- 6.The tolerance value for cylindricity is 0.003mm.

DIN 69871型JT检验棒(带法兰)
DIN 69871 JT Gauge Bars with Flange



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0017.170	GGBDIN69871WF30200M	30	32	200	229.1	210	276.9	50
440.0018.170	GGBDIN69871WF40300M	40	40	300	339.1	320	407.5	63
440.0019.170	GGBDIN69871WF50300M	50	63	300	339.1	320	440.9	97.5

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
- 3.可根据客户需求进行定制。
- 4.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

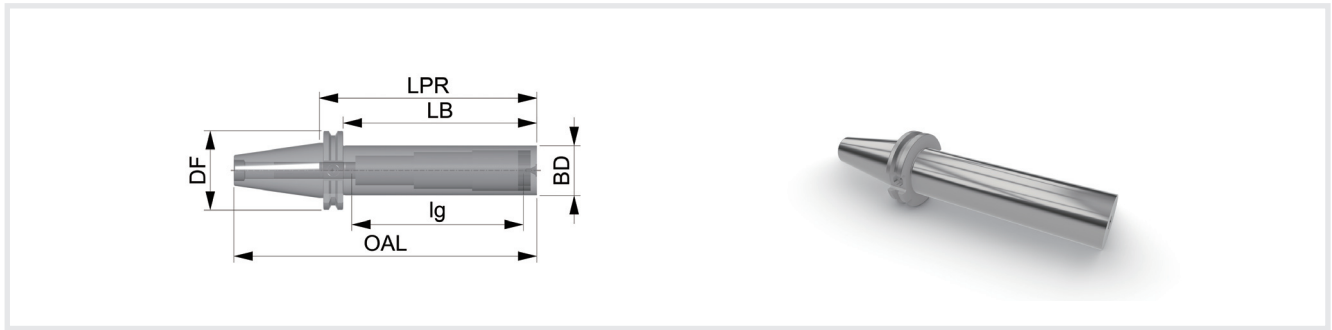
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Can be customized according to customer needs.
- 4.The tolerance value for cylindricity is 0.003mm.

JIS B 6339型BT检验棒(带法兰)

JIS B 6339 BT Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0020.170	GGBJISB6339WF30200M	30	32	200	232	210	280.4	46
440.0021.170	GGBJISB6339WF40300M	40	40	300	347	320	412.4	63
440.0022.170	GGBJISB6339WF50300M	50	63	300	358	320	459.8	100

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空, 以保证检测结果不受重量影响。
- 3.可根据客户需求进行定制。
- 4.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

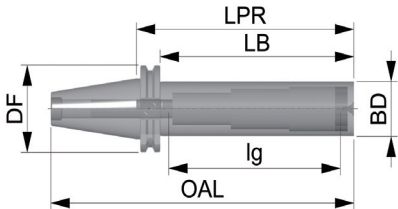
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Can be customized according to customer needs.
- 4.The tolerance value for cylindricity is 0.003mm.

DC JIS B 6339 型BT-FC检验棒

double contact JIS B 6339 BT-FC Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0023.170	GGBJISB6339N30200M	30	32	200	231	210	280.4	46
440.0024.170	GGBJISB6339N40300M	40	40	300	346	320	412.4	63
440.0025.170	GGBJISB6339N50300M	50	63	300	356.5	320	459.8	100

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
- 3.刀柄端面 and 主轴端面紧密接触,更好的定位精度。
- 4.可根据客户需求进行定制。
- 5.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

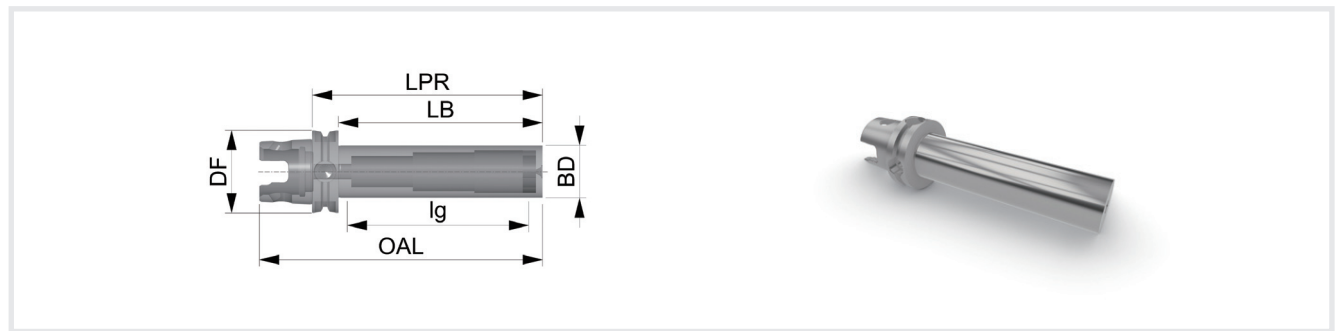
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.The tight contact between the shank end face of the tool holder and the spindle end face ensures better positioning accuracy.
- 4.Can be customized according to customer needs.
- 5.The tolerance value for cylindricity is 0.003mm.

ISO 26622型UTS检验棒

ISO 26622 UTS Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0026.170	GGBISO26622NF32150M	32	25	150	170	160	190	32
440.0027.170	GGBISO26622NF40150M	40	25	150	172	160	197	40
440.0028.170	GGBISO26622NF50200M	50	32	200	228	210	260	50
440.0029.170	GGBISO26622NF63300M	63	40	300	340	320	380	63
440.0030.170	GGBISO26622NF80300M	80	40	300	342	320	387	80
440.0031.170	GGBISO26622NF100300M	100	40	300	342	320	392	100

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空, 以保证检测结果不受重量影响。
- 3.可根据客户需求进行定制。
- 4.圆柱度公差值为0.003mm。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

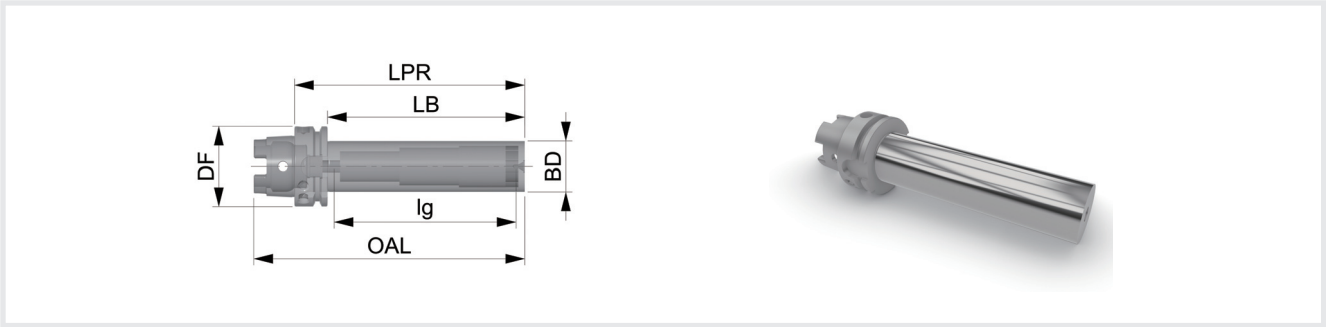
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Can be customized according to customer needs.
- 4.圆柱度公差值为0.003mm。

高精度检验棒
High Accuracy Gauge Bars

DIN 69893-1型HSK-A检验棒(十字键槽)
DIN 69893-1 HSK-A Precision Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0032.170	PGBDIN69893ANF32150M	32	25	150	176	160	192	32
440.0033.170	PGBDIN69893ANF40150M	40	25	150	180	160	200	40
440.0034.170	PGBDIN69893ANF50200M	50	32	200	236	210	261	50
440.0035.170	PGBDIN69893ANF63300M	63	40	300	346	320	378	63
440.0036.170	PGBDIN69893ANF80300M	80	40	300	346	320	386	80
440.0037.170	PGBDIN69893ANF100300M	100	40	300	349	320	399	100
440.0038.170	PGBDIN69893ANF125300M	125	40	300	349	320	412	125
440.0039.170	PGBDIN69893ANF160300M	160	40	300	400	369	480	160

用途:
依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:
立式放置的木架。

备注:
1.lg=有效测量长度。
2.十字键槽,可90°换方向检测。
3.大规格检测棒中心钻空,以保证检测结果不受重量影响。
4.可根据客户需求进行定制。

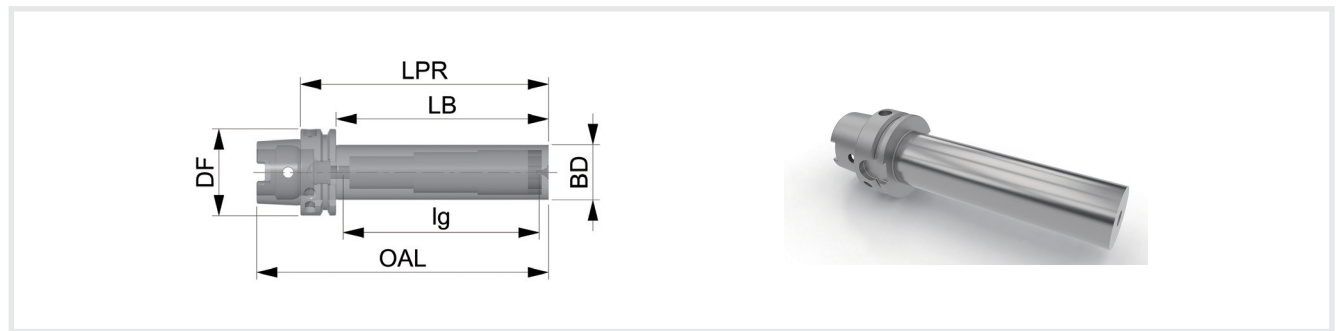
Use:
For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:
With wooden stand for vertical storage.

Note:
1.lg= effective measuring length.
2.Cross keyway, 90° direction change detection.
3.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
4.Can be customized according to customer needs.

DIN 69893-3型HSK-T检验棒

DIN 69893-3 HSK-T Precision Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0040.170	PGBDIN69893TNF32150M	32	25	150	176	160	192	32
440.0041.170	PGBDIN69893TNF40150M	40	25	150	180	160	200	40
440.0042.170	PGBDIN69893TNF50200M	50	32	200	236	210	261	50
440.0043.170	PGBDIN69893TNF63300M	63	40	300	346	320	378	63
440.0044.170	PGBDIN69893TNF80300M	80	40	300	346	320	386	80
440.0045.170	PGBDIN69893TNF100300M	100	40	300	349	320	399	100
440.0046.170	PGBDIN69893TNF125300M	125	40	300	349	320	412	125
440.0047.170	PGBDIN69893TNF160300M	160	40	300	400	369	480	160

用途:

依据ISO标准推荐的R230方法用于车铣复合机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
- 3.相较于A型,拥有更高的键槽定位精度。
- 4.可根据客户需求进行定制。

Use:

For the acceptance test of turn-milling compound machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

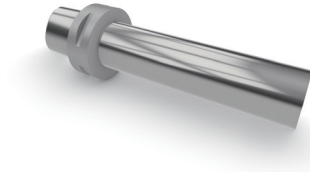
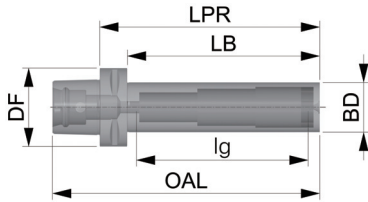
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Compared with type A, it has higher keyway positioning accuracy.
- 4.Can be customized according to customer needs.

ISO 26623-1型PSC检验棒

ISO 26623 PSC Precision Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0048.170	PGBISO26623NF32150M	32	25	150	175	160	194	32
440.0049.170	PGBISO26623NF40150M	40	25	150	180	160	204	40
440.0050.170	PGBISO26623NF50205M	50	32	205	235	215	265	50
440.0051.170	PGBISO26623NF63290M	63	40	290	322	300	360	63
440.0052.170	PGBISO26623NF80290M	80	40	290	330	300	300	80

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空, 以保证检测结果不受重量影响。
- 3.可根据客户需求进行定制。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

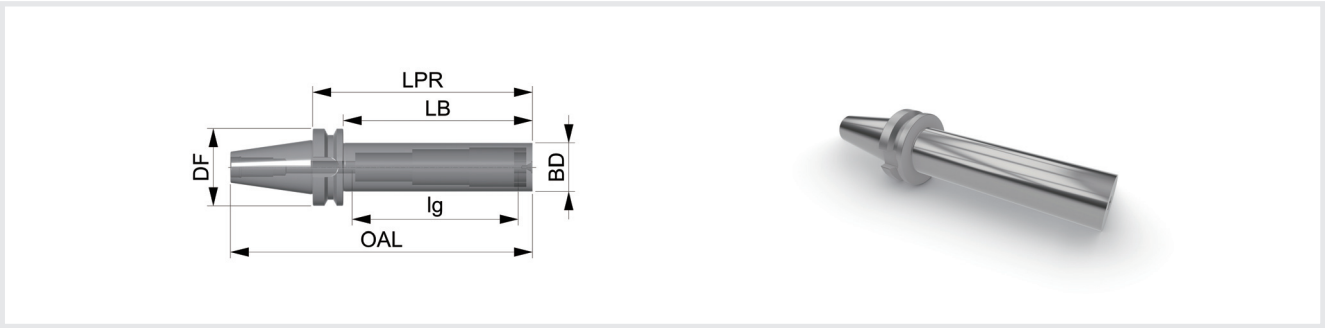
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Can be customized according to customer needs.

Double Contact JIS B 6339型BT-FC检验棒

Double Contact JIS B 6339 BT-FC Precision Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0053.170	PGBJISB6339NF30200M	30	32	200	231	210	280.4	46
440.0054.170	PGBJISB6339NF40300M	40	40	300	346	320	412.4	63
440.0055.170	PGBJISB6339NF50300M	50	63	300	356.5	320	459.8	100

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空, 以保证检测结果不受重量影响。
- 3.刀柄柄端面和主轴端面紧密接触, 更好的定位精度。
- 4.可根据客户需求进行定制。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

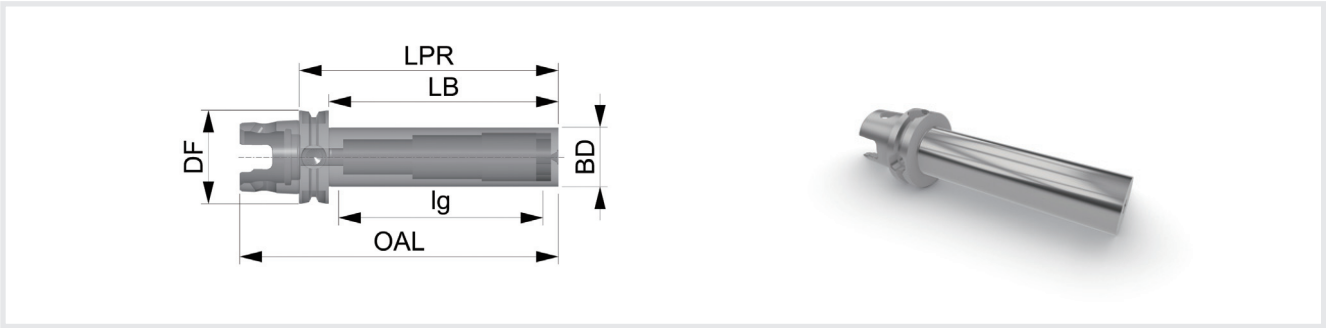
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.The tight contact between the shank end face of the tool holder and the spindle end face ensures better positioning accuracy.
- 4.Can be customized according to customer needs.

ISO 26622型UTS检验棒

ISO 26622 UTS Precision Gauge Bars



NO.	Model	Size	BD	lg	LPR	LB	OAL	DF
440.0056.170	PGBISO26622NF32150M	32	25	150	170	160	190	32
440.0057.170	PGBISO26622NF40150M	40	25	150	172	160	197	40
440.0058.170	PGBISO26622NF50200M	50	32	200	228	210	260	50
440.0059.170	PGBISO26622NF63300M	63	40	300	340	320	380	63
440.0060.170	PGBISO26622NF80300M	80	40	300	342	320	387	80
440.0061.170	PGBISO26622NF100300M	100	40	300	342	320	392	100

用途:

依据ISO标准推荐的R230方法用于机床验收检测。

标准配置:

立式放置的木架。

备注:

- 1.lg=有效测量长度。
- 2.大规格检测棒中心钻空,以保证检测结果不受重量影响。
- 3.可根据客户需求进行定制。

Use:

For the acceptance test of machine tools in accordance with the ISO recommendation R 230.

Standard Specification:

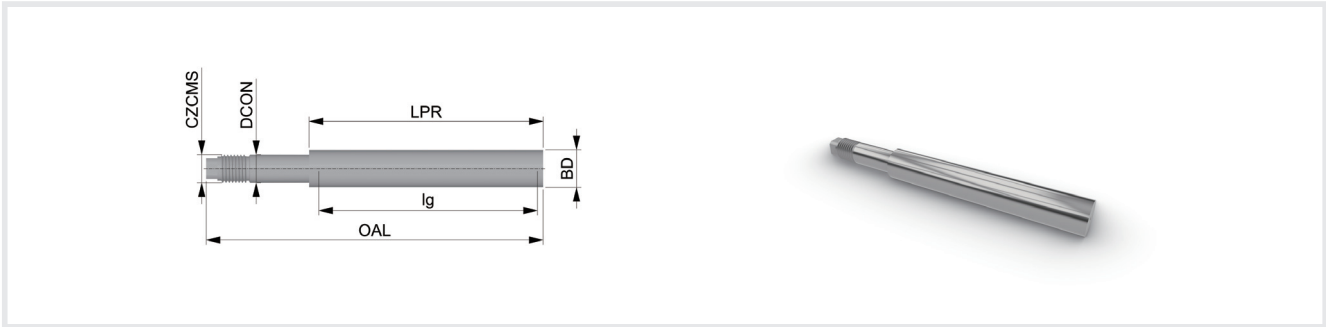
With wooden stand for vertical storage.

Note:

- 1.lg= effective measuring length.
- 2.To prevent wrong measuring results caused by their weight,the large test arbors are hollowed out with a stepped bore.
- 3.Can be customized according to customer needs.

行程轴检验棒
Runout Gauge Bars

轴承内环式检验棒
Bearing Inner Rings Gauge Bars



NO.	Model	DCON	BD	CZCMS	LPR	lg	OAL
440.0062.170	RGBFS20190M	20	32	M20×1.5	200	190	292
440.0063.170	RGBFS30240M	30	40	M30×1.5	250	240	360
440.0064.170	RGBFS35240M	35	40	M35×1.5	250	240	369
440.0065.170	RGBFS40240M	40	50	M40×1.5	250	240	378
440.0066.170	RGBFS45240M	45	63	M45×2	250	240	387
440.0067.170	RGBFS50290M	50	63	M50×2	300	290	396
440.0068.170	RGBFS55290M	55	63	M55×2	300	290	455
440.0069.170	RGBFS60290M	60	80	M60×2	300	290	464

用途:

用于校正轴承孔轴线与导轨之间的平行度。

标准配置:

立式放置的木架。

备注:

可根据客户需求进行定制。

Use:

Used to detect the coaxiality of opposing bearing seats installed on the machine tool workbench.

Standard Specification:

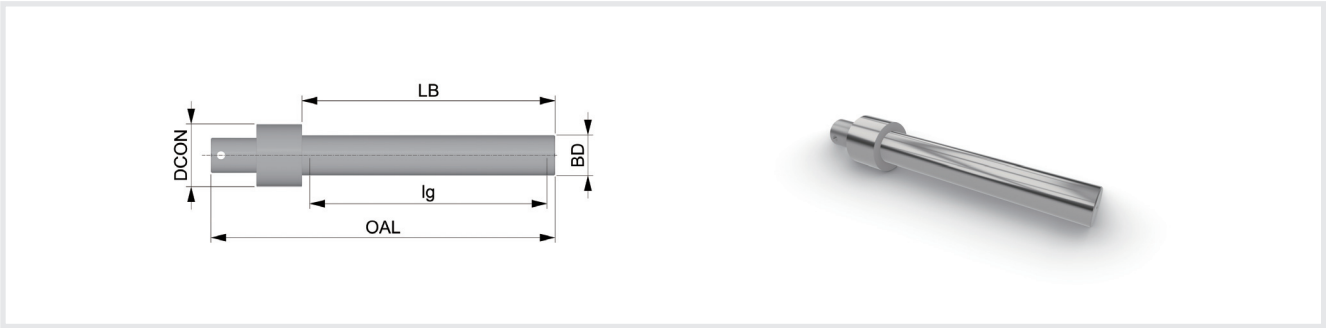
With wooden stand for vertical storage.

Note:

Can be customized according to customer needs.

轴承外环式检验棒

Bearing Face Snap Gauge Bars



NO.	Model	DCON	BD	LB	lg	OAL
440.0070.170	RGBFS47240M	47	40	250	240	337
440.0071.170	RGBFS62240M	62	40	250	240	340
440.0072.170	RGBFS72240M	72	50	250	240	343
440.0073.170	RGBFS80240M	80	50	250	240	346
440.0074.170	RGBFS85290M	85	63	300	290	399
440.0075.170	RGBFS90290M	90	63	300	290	402
440.0076.170	RGBFS100290M	100	63	300	290	405
440.0077.170	RGBFS110290M	110	80	300	290	408

用途:

用于校正轴承孔轴线与导轨之间的平行度。

标准配置:

立式放置的木架。

备注:

可根据客户需求进行定制。

Use:

Used to detect the coaxiality of opposing bearing seats installed on the machine tool workbench.

Standard Specification:

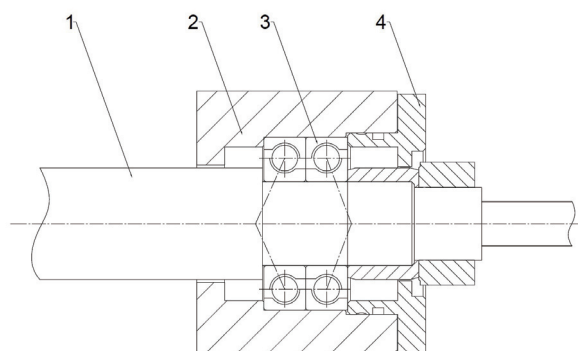
With wooden stand for vertical storage.

Note:

Can be customized according to customer needs.

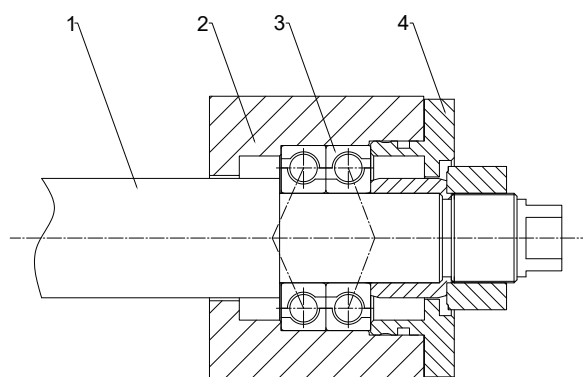
轴承内环式检验棒与轴承外环式检验棒安装示例及对比分析

Installation examples and comparative analysis of bearing inner rings gauge bars and bearing face snap gauge bars



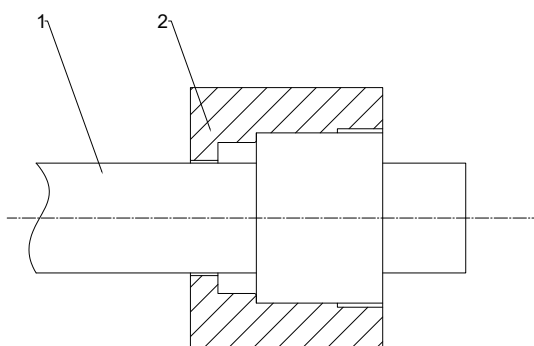
丝杠与轴承座安装示意图

1.丝杠 2.轴承座 3.轴承 4.压盖



轴承内环式检验棒与轴承座的安装结构示例

1.轴承内环式检验棒 2.轴承座 3.轴承 4.压盖



轴承外环式检验棒与轴承座的安装结构示例

1.轴承外环式检验棒 2.轴承座

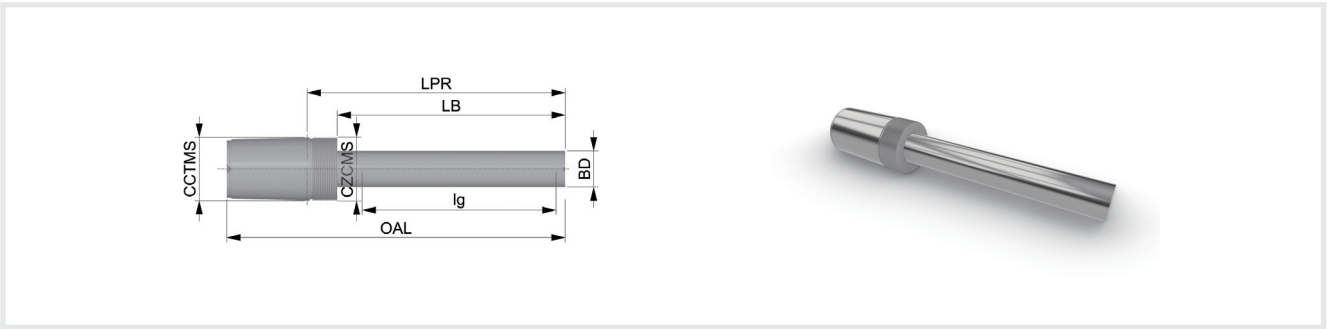
轴承内环式检验棒特点：

- 1.轴承内环式检验棒与轴承内环呈间隙配合，仅需单支订货，使用寿命较长
- 2.模拟丝杠工况，检测误差较小

轴承外环式检验棒特点：

- 1.轴承外环式检验棒与轴承孔呈过渡或过盈配合，因此要成组订货，调试时容易磕伤检棒与轴承孔，使用寿命较短
- 2.检测误差较大

1:20车床主轴检验棒套组
1:20 Lathe Gauge Bars



NO.	Model	Size	CCTMS	CZCMS	BD	LB	LPR	OAL
440.0081.170	LGBSM60340	A2-5	62	M60	40	300	340	460
440.0082.170	LGBSM80340	A2-6	79	M80	40	300	340	460
440.0083.170	LGBSM90340	A2-8	90	M90	40	300	340	460

用途:
本产品配备有相应的校准锥度塞规与锥度环规,以套装形式出售,专为机床厂家主轴验收时的锥度精确检测而设计。

标准配置:
立式放置的木架;对应锥度的锥度塞规、环规。

备注:
可根据客户需求进行定制。

Use:
This product is equipped with corresponding calibration taper plug gauge and taper ring gauge, sold as a set, and is designed for precise taper detection during spindle acceptance by machine tool manufacturers.

Standard Specification:
With wooden stand for vertical storage;Taper plug gauges and ring gauges.

Note:
Can be customized according to customer needs.



提供给制造车床主轴及提供检测服务的
厂家,用于主轴检测。



提供给制造车床主轴及提供检测服务的
厂家,用于检定锥度塞规准确性。



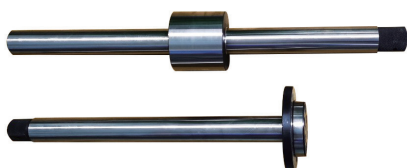
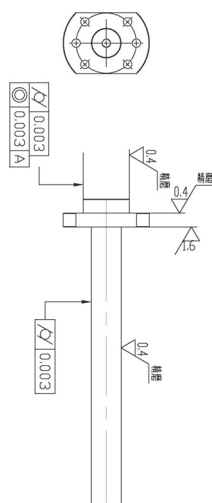
提供给制造车床主轴及提供检测服务的
厂家,用于检测、校正锥度。

非标检验棒

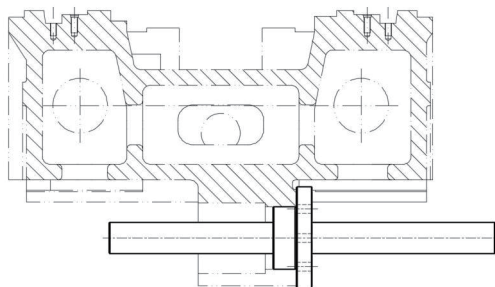
Customization Made Gauge Bars

我们的产品包括一系列测量测试设备,并且可以针对客户需求,进行非标检具定制化开发,保证生产所需的产品质量。

Our products include a range of measuring and testing equipment, and we can customize the development of non-standard gauges according to customer needs to ensure the quality of products required for production.



丝母座检验棒



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JIS B 6339 BT型	039

Tools Measuring Gauges

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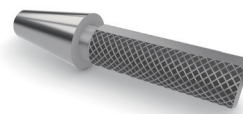
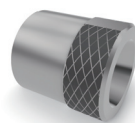
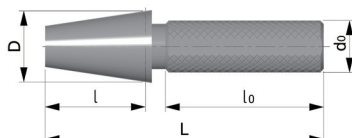
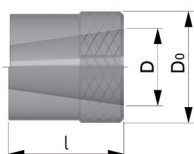
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锥度规

Tapers Measuring Shanks

DIN 228型7:24锥度规

DIN 228 Taper Shank Gauges



No.	Size	Suit	Ring Gauges Plug Gauges	D (I图)	D0	l (I图)	/	/
				D (II图)	d0	l (II图)	l0	L
A83227-030	ISO10	TSGISO10NSTMSG	TSGISO10SR36M	15.875	36	22.4	-	-
A83217-030			TSGISO10SP10M	15.875	10	22	50	85
A83227-031	ISO15	MTISO15NSTMSG	TSGISO15SR42M	19.050	42	27.4	-	-
A83217-031			TSGISO15SP15M	19.050	15	27	60	100
A83227-032	ISO20	MTISO20NSTMSG	TSGISO20SR45M	22.225	45	33.4	-	-
A83217-032			TSGISO20SP18M	22.225	18	33	80	125
A83227-033	ISO25	MTISO25NSTMSG	TSGISO25SR50M	25.400	50	40.4	-	-
A83217-033			TSGISO25SP20M	25.400	20	40	80	132
A83227-034	ISO30	MTISO30NSTMSG	TSGISO30SR58M	31.750	58	48.8	-	-
A83217-034			TSGISO30SP25M	31.750	25	48.4	90	150
A83227-035	ISO40	MTISO40NSTMSG	TSGISO40SR64M	44.450	64	65.8	-	-
A83217-035			TSGISO40SP32M	44.450	32	65.4	100	176
A83227-037	ISO50	MTISO50NSTMSG	TSGISO50SR95M	69.850	95	102.2	-	-
A83217-037			TSGISO50SP35M	69.850	35	101.8	100	210
A83227-039	ISO60	MTISO60NSTMSG	TSGISO60SR140M	107.950	140	162.2	-	-
A83217-039			TSGISO60SP40M	107.950	40	161.8	115	270
A83227-041	ISO70	MTISO70NSTMSG	TSGISO70SR204M	165.100	204	252.4	-	-
A83217-041			TSGISO70SP40M	165.100	40	252.0	115	380
A83227-043	ISO80	MTISO80NSTMSG	TSGISO80SR300M	254.000	300	394.4	-	-
A83217-043			TSGISO80SP50M	254.000	50	394.0	120	520

用途:

成套使用,用于检验7:24机床主轴孔或刀柄锥度。

备注:

- 1.符合《GB/T11854-2016 7:24工具圆锥量规 检验》标准。
- 2..可提供1, 2, 3级精度产品。
- 3.其中塞规与环规的研合接触率,采用与工作塞规配对研合,要求研合接触率达到98%以上。

Use:

Used as a set, it is intended for inspecting the taper of 7:24 machine tool spindle holes or numerical control tool shanks.

Note:

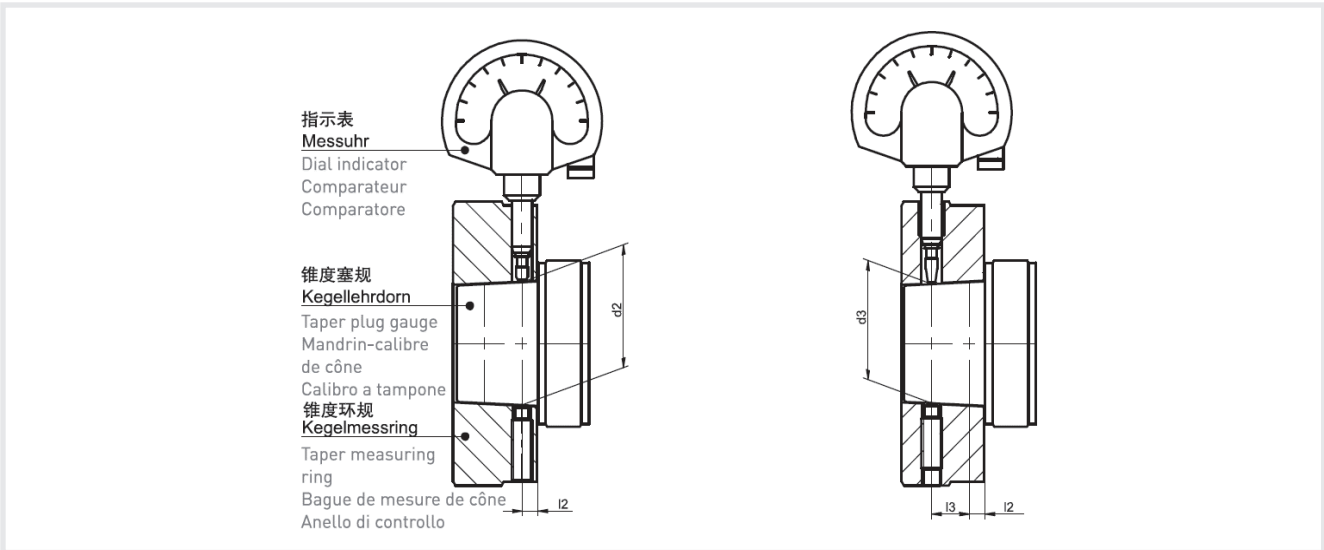
1. Comply with the standard of "GB/T11854-2016 7:24 Tool Cone Gauge Inspection".
2. Can provide 1, 2, 3 level precision products.
3. The contact ratio of the plug gauge and ring gauge during lapping is tested by pairing them with a working plug gauge, with a requirement that the contact ratio during lapping should reach over 98%.

刀柄检具

Tools Gauge Bars

机械式锥柄测量

Mechanical Taper Shank Gauges



NO.	ISO 12164-1 A/C DIN 69893 E	DIN 69893 B/D/F	d2		d3*		l2	l3
280.019	HSK25	HSK32	19.000	+0.006 +0.004	18.1500	+0.004 +0.002	2.5	8.5
280.020	HSK32	HSK40	24.007	+0.002 -0.002	23.2755	+0.002 -0.002	3.2	7.3
280.021	HSK40	HSK50	30.007	+0.002 -0.002	29.0551	+0.002 -0.002	4.0	4.5
280.022	HSK50	HSK63	38.009	+0.0025 -0.0025	36.9068	+0.0025 -0.0025	5.0	11.0
280.023	HSK63	HSK80	48.010	+0.003 -0.003	46.5370	+0.003 -0.003	6.3	14.7
280.024	HSK80	HSK100	60.012	+0.004 -0.004	58.1082	+0.004 -0.004	8.0	19.0
280.025	HSK100	HSK125	75.013	+0.004 -0.004	72.6082	+0.004 -0.004	10.0	24.0
280.026	HSK125	HSK160	95.016	+0.005 -0.005	91.9600	+0.005 -0.005	12.5	30.5
280.027	HSK160	-	120.016	+0.005 -0.005	116.0080	+0.005 -0.005	16.0	40.0

用途:

用来定期对HSK刀柄柄部进行测量,直接比对测量结果使用HSK系统时能取得最佳效果。

标准配置:

成套检具装在木箱内,包括锥度塞规、检测名义锥柄直径d2的锥度环规,配千分表(分度值0.001mm)、测量点直径d3的锥度测量环,配千分表(分度值0.001mm)和合格证。

功能:

两件检具用校准过的锥度塞规调至零位。比较测量HSK刀柄时,可以直接从指示表读出锥柄名义直径d2和测量点直径d3的偏差值。

Use:

For periodically direct comparison tests of HSK tool shanks. To obtain optimal benefits when using the HSK system.

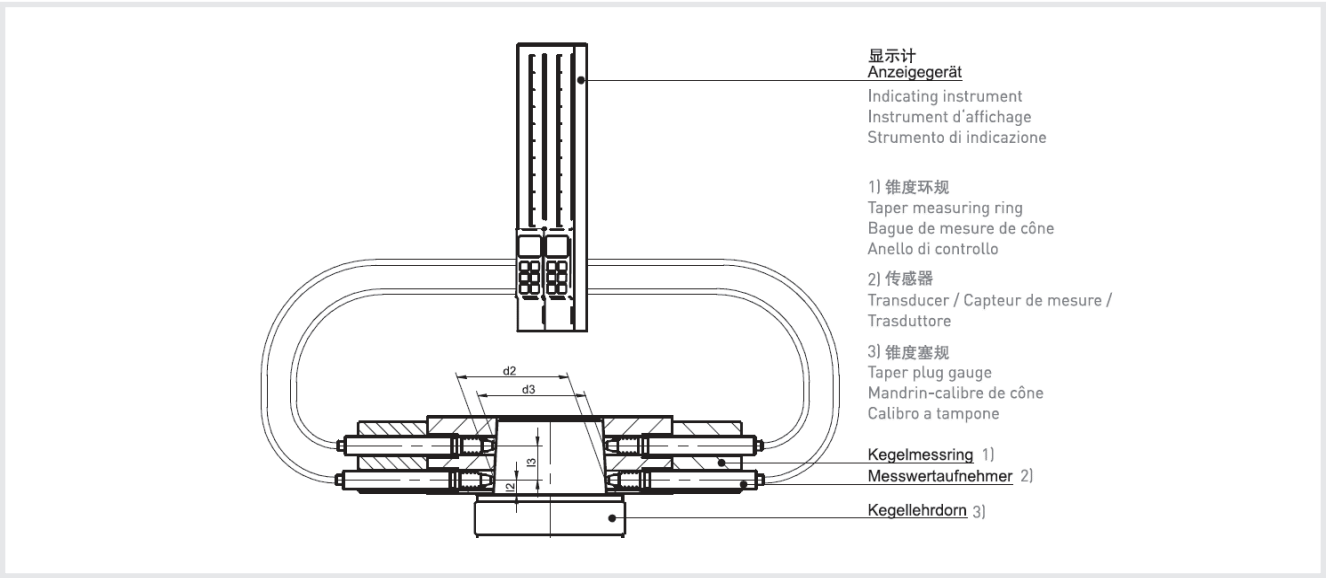
Standard Specification:

Measuring gauge set in wooden box including taper plug gauge, taper measuring ring for nominal taper diameter d2 with dial indicator (scale value 0.001 mm), taper measuring ring for measuring point diameter d3 with dial indicator (scale value 0.001 mm) and certificate.

Function:

Both measuring gauges are set to zero with the calibrated taper plug gauge. At the comparison test of HSK tool shanks the deviations of the nominal taper diameter d2 or the measuring point diameter d3 are read off directly at the dial indicator.

电子式锥柄测量
Mechanical Taper Shank Gauges



NO.	ISO 12164-1 A/C DIN 69893 E	DIN 69893 B/D/F	d2		d3*		l2	l3
280.018	HSK25	HSK32	19.000	+0.006 +0.004	18.1500	+0.004 +0.002	2.5	8.5
280.01	HSK32	HSK40	24.007	+0.002 -0.002	23.2755	+0.002 -0.002	3.2	7.3
280.011	HSK40	HSK50	30.007	+0.002 -0.002	29.0551	+0.002 -0.002	4.0	4.5
280.012	HSK50	HSK63	38.009	+0.0025 -0.0025	36.9068	+0.0025 -0.0025	5.0	11.0
280.013	HSK63	HSK80	48.010	+0.003 -0.003	46.5370	+0.003 -0.003	6.3	14.7
280.014	HSK80	HSK100	60.012	+0.004 -0.004	58.1082	+0.004 -0.004	8.0	19.0
280.015	HSK100	HSK125	75.013	+0.004 -0.004	72.6082	+0.004 -0.004	10.0	24.0

用途:
该测量计用于测量刀具柄部,在与接触面成比例的测量点位置进行测量。

标准配置:
测量计套装用木盒包装,包括锥度塞规和锥度环规,4个传感器和一份合格证书。

功能:
测量环规上安装有4个电感传感器。用来对d2锥柄名义直径与l2名义距离, d3测量点直径到l3测量点距离的微分测量。与校对锥度塞规之间的测量偏差值会立即显示在测量计的双柱上。

备注:
将显示计与电脑连接,可以保存、评估测量值。该软件需另外订购。

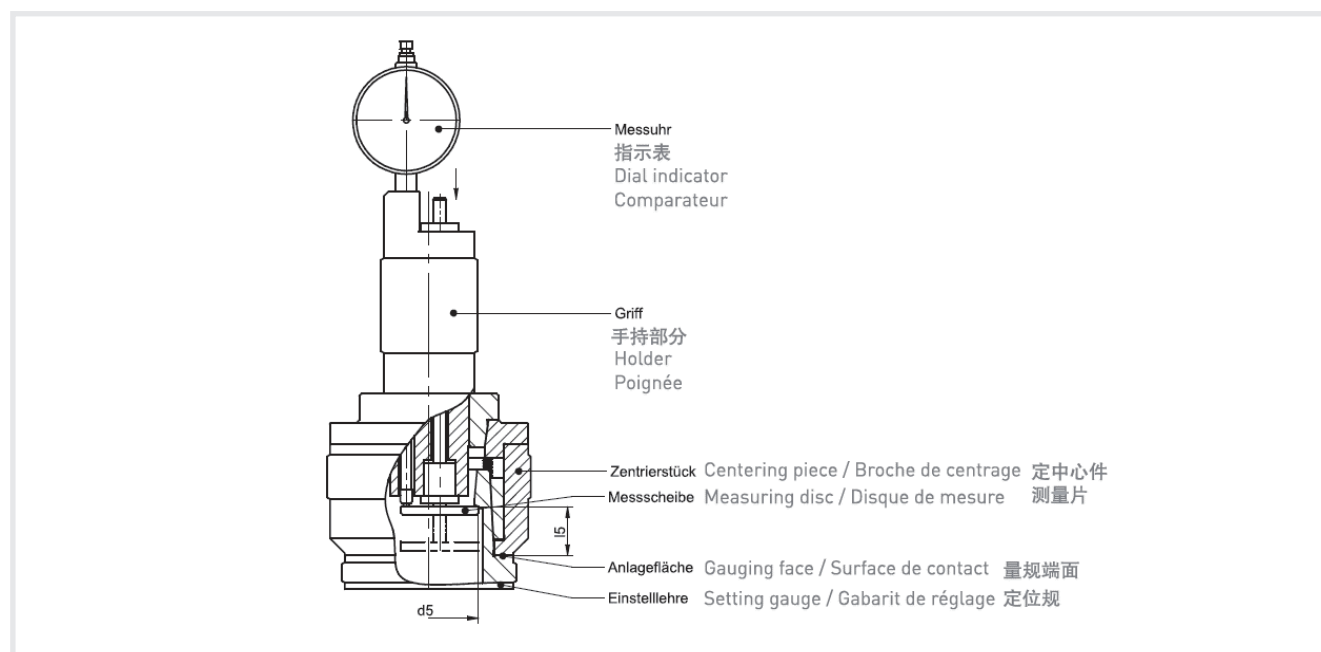
Use:
Gauges to measure tool shanks at determined measuring points in ratio to the contact face.

Standard Specification:
Measuring gauge set in wooden box with taper plug gauge and taper measuring ring with 4 transducers and certificate.

Function:
The measuring ring is provided with 4 inductive transducers. These are used for a differential measurement of the nominal taper diameter d2 to the nominal taper distance l2 and the measuring point diameter d3 to the measuring point distance l3. Deviations to the measurements of the calibrated taper plug gauge are simultaneously indicated on the twin indicator columns.

Note:
By connecting the indicating device to a PC,the measuring results can be saved and evaluated. This software must be ordered separately.

30°拉紧斜面检测 30°Taper Shank Gauges



NO.	ISO 12164-1 A/C DIN69893 E	DIN 69893 B/D/F	l5(J510)	d5
281.008	HSK25	HSK32	7.21	15
281.000	HSK32	HSK40	8.92	19
281.001	HSK40	HSK50	11.42	23
281.002	HSK50	HSK63	14.13	29
281.003	HSK63	HSK80	18.13	37
281.004	HSK80	HSK100	22.85	46
281.005	HSK100	HSK125	28.56	58
281.006	HSK125	HSK160	36.27	73
281.007	HSK160	-	45.98	92

用途:

用于测量30°拉紧斜面上理论拉紧点的检具。

Use:

Gauge to measure the theoretical clamping shoulder measuring point at the 30° clamping slope.

标准配置:

装于木盒内, 内含指示表手持部分, 指示表(分度值0.01mm), 定中心件和定位规。

Standard Specification:

Measuring gauge set in wooden box with dial indicator holder, dial indicator (scale value 0.01mm), centering piece and setting gauge.

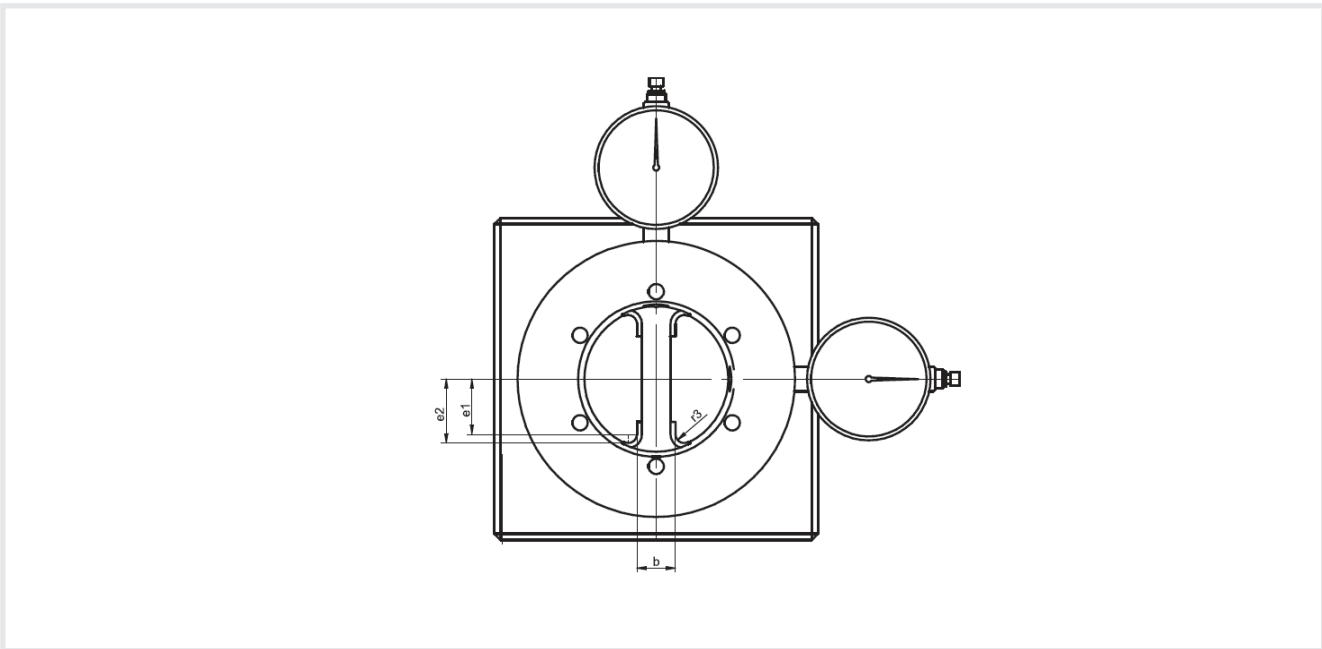
功能:

用校正的定位规调整指示表手持部位的l5拉紧距离。需将定中心件放在检具的锥部上, 然后将指示表手持部分插入锥柄柄部, 从指示表上可以读出偏差值。

Function:

With a calibrated setting gauge the distance of the clamping point l5 is to be adjusted at the dial indicator holder. In order to read off the deviation on the dial indicator, the centering piece has to be put onto the tool taper and the dial indicator holder has to be inserted into the taper shank.

传动键槽检测
Drive-keys Gauges



NO.	ISO 12164-1 A/C	b (±0.04)	e1	e2(-0.05)	r3(±0.05)
283.021	HSK32	7.05	8.82	10.20	1.38
283.022	HSK40	8.05	11.00	12.88	1.88
283.023	HSK50	10.54	13.88	16.26	2.38
283.024	HSK63	12.54	17.399	20.87	2.88
283.025	HSK80	16.04	21.94	25.82	3.88
283.026	HSK100	20.02	27.37	32.25	4.88
283.027	HSK125	25.02	35.37	41.25	5.88

用途:
用来测量传动槽宽度的偏心度, 以及传动槽相对于空心柄半径的位置和形状。可用于检测带加工余量的锥柄和精加工后的锥柄。

标准配置:
成套检具装在木盒内, 含带指示表环规 (指示表分度值0.001mm)

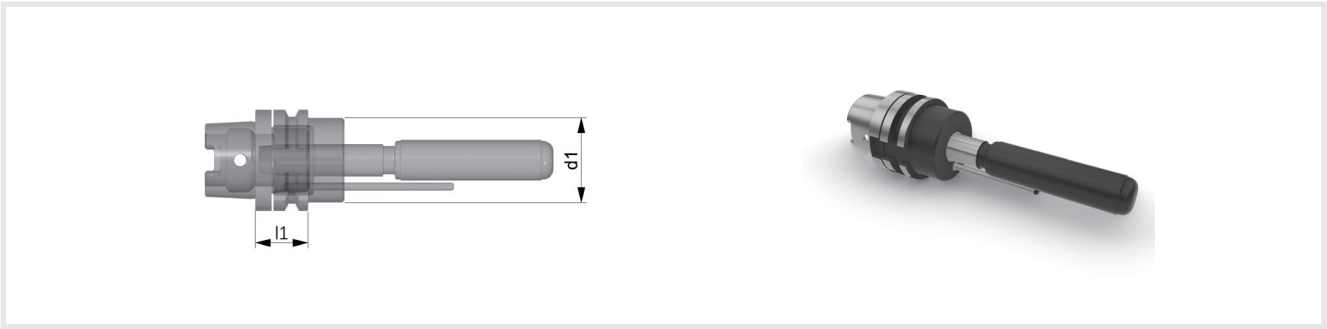
Use:
Gauge to measure the eccentricity of the driving groove width as well as the position and form of the groove with the radius to the hollow shank. For tool shanks with allowance as well as with finished dimensions.

Standard Specification:
Measuring gauge set in wooden box including measuring ring with dial indicator (scale value 0.001 mm).

刀爪槽校正工具
Tools Glaw Adjustment Gauge

DIN 69893型HSK刀爪槽校正工具

DIN 69893 HSK Tools Adjustment Gauges



NO.	Size	l1	d1	kg
680.0010.321	50	26	42	1.6
680.0010.322	63	26	53	2.1
680.0010.323	80	26	67	3.1
680.0010.324	100	29	85	4.8

用途:
用于检查和校正刀具夹爪相对于刀库和机床主轴的工作位置。

Use:
For inspection and alignment of the position of the tool gripper to the magazine and machine spindle.

ISO 26623-1 PSC型

ISO 26623-1 PSC Tools Adjustment Gauges



NO.	Size	l1	d1	kg
680.0010.383	50	20	50	1.1
680.0010.384	63	22	60	1.4
680.0010.385	80	30	78	2.7

用途:

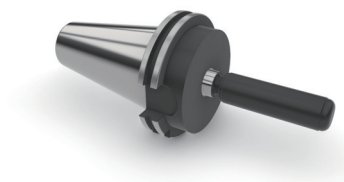
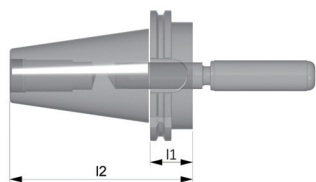
用于检查和校正刀具夹爪相对于刀库和机床主轴的工作位置。

Use:

For inspection and alignment of the position of the tool gripper to the magazine and machine spindle.

DIN 69871 JT型

DIN 69871 JT Tools Adjustment Gaues



NO.	Size	l1	l2
440.0084.170	40	32	103.6
440.0085.170	50	32	137

用途:

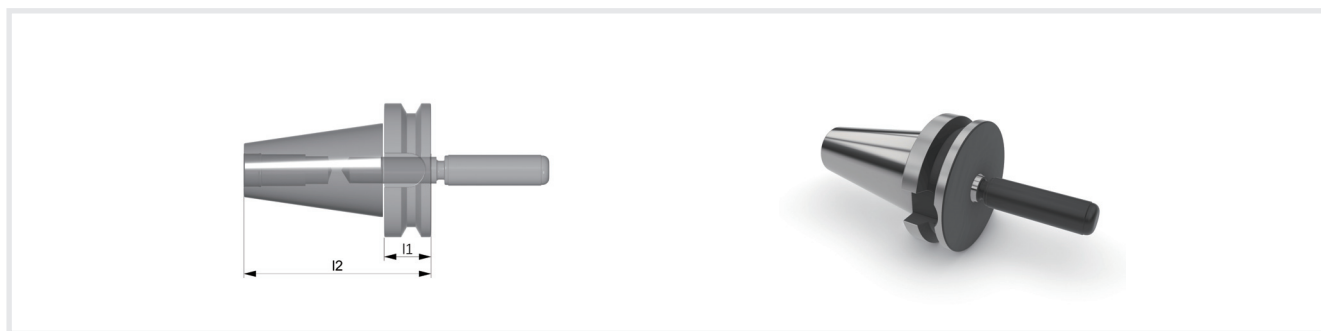
用于检查和校正刀具夹爪相对于刀库和机床主轴的工作位置。

Use:

For inspection and alignment of the position of the tool gripper to the magazine and machine spindle.

JIS B 6339 BT型

JIS B 6339 BT Tools Adjustment Gauges



NO.	Size	l1	l2
440.0086.170	40	25	92.4
440.0087.170	50	35	139.8

用途:

用于检查和校正刀具夹爪相对于刀库和机床主轴的工作位置。

Use:

For inspection and alignment of the position of the tool gripper to the magazine and machine spindle.

机床检具
Machine Measuring Gauges

4.1 主轴检具	042
主轴定向调整规	042
传动键测量	043
机械式锥柄测量	044

Machine Measuring Gauges

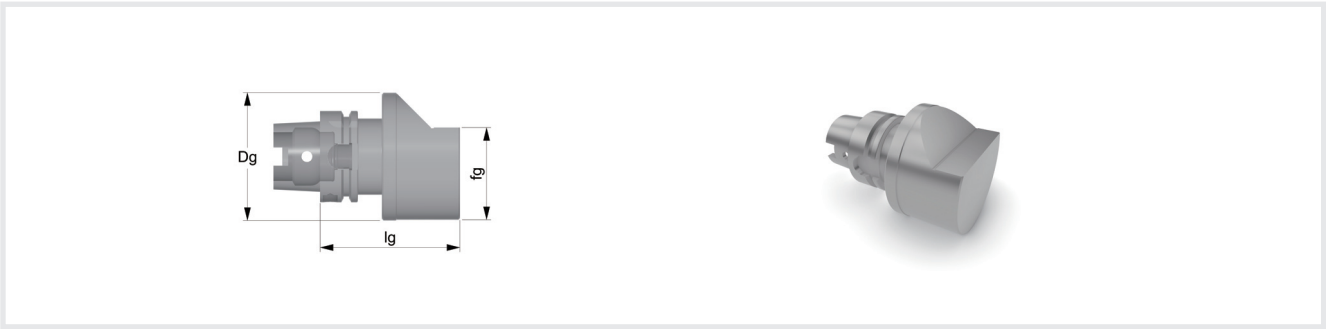
Contents

4.1 Main Spindle Measure Gauge	042
Adjustment Gauges	042
Drive-keys Gauges	043
Mechancial Taper Shank Gauges	044

主轴检具
Main Spindle Measure Gauge

主轴定向调整规

Adjustment Gauges

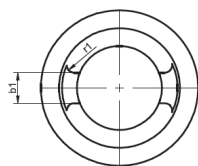


NO.	Model	Size	Dg	lg	fg
440.0078.170	SMGDIN69893T8896M	HSK63T	88	96	63.5
440.0079.170	SMGDIN69893T10285M	HSK100T	102	85	60

用途:
用于机床加工过程中的部件定位检测, 以保证重复定位精度。主轴定向调整规可用于检测主轴中心和主轴方向。此外该设备还可用于刀具预调仪的检验

Use:
It is used for component positioning detection in the machine tool processing to ensure repeated positioning accuracy. The spindle orientation adjustment gauge can be used to detect the spindle center and spindle direction. In addition, this equipment can also be used for the inspection of tool presettters.

传动键槽检测 Drive-keys Gauges



NO.	ISO 12164-2 A/C	b1(±0.05)	r1 (-0.05)
284.001	HSK32	6.8	1.5
284.002	HSK40	7.8	2.0
284.003	HSK50	10.3	2.5
284.004	HSK63	12.3	3.0
284.005	HSK80	15.8	4.0
284.006	HSK100	19.78	5.8
284.007	HSK125	24.78	6.0
284.008	HSK160	29.78	8.0

用途:

用来测量传动槽宽度的偏心度, 以及传动槽相对于空心柄半径的位置和形状。可用来检测带加工余量的锥柄和精加工后的锥柄。

标准配置:

成套检具装在木盒内, 含带指示表环规 (指示表分度值0.001mm)

Use:

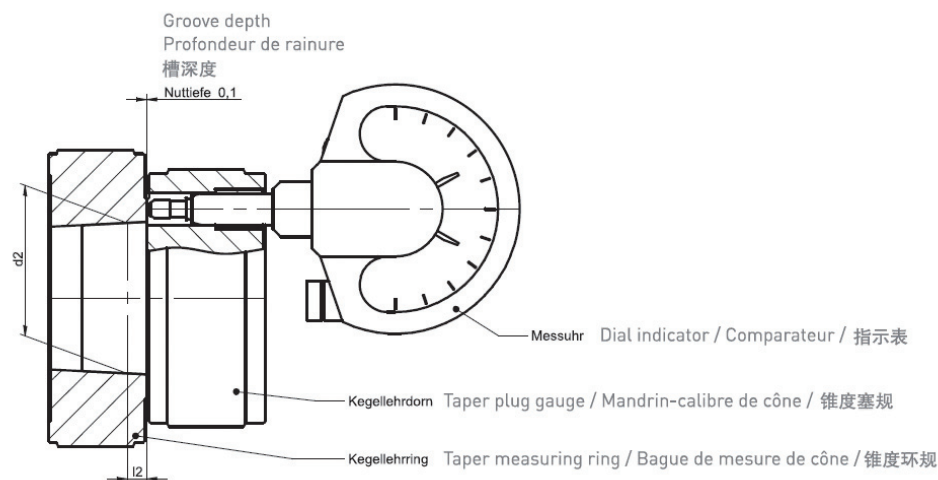
Gauge to measure the eccentricity of the driving groove width as well as the position and form of the groove with the radius to the hollow shank. For tool shanks with allowance as well as with finished dimensions.

Standard Specification:

Measuring gauge set in wooden box including measuring ring with dial indicator (scale value 0.001 mm).

机械式锥柄测量

Mechanical Taper Shank Gauges



NO.	ISO 12164-2 A/C DIN 69063 E	DIN 69063 B/D/F		d2	l2
280.029	HSK25	HSK32	*19.000	+0.003	2.5
280.030	HSK32	HSK40	23.998	+0.0015 -0.0015	3.2
280.031	HSK40	HSK50	29.998	+0.0015 -0.0015	4.0
280.032	HSK50	HSK63	37.998	+0.002 -0.002	5.0
280.033	HSK63	HSK80	47.998	+0.002 -0.002	6.3
280.034	HSK80	HSK100	59.997	+0.0025 -0.0025	8.0
280.035	HSK100	HSK125	74.997	+0.003 -0.003	10.0
280.036	HSK125	HSK160	94.996	+0.0035 -0.0035	12.5
280.037	HSK160	-	119.995	+0.0035 -0.0035	10.0

用途:

用来检测HSK主轴内锥度,尤其适合定期检测使用。

标准配置:

成套检具装在木盒内, 内含锥度塞规、定位规、指示表(分度值 0.001mm)及合格证书。

功能:

使用调整环、锥度塞规和千分表, 将与公称锥度直径d2相关的测量距离l2 (按照ISO 12164-2) 设置为零 (0.00)。将被测量的HSK主轴与用锥度塞规置零的千分表进行比较。

备注:

定位规扁平接触面上凹槽(0.10)是测量HSK主轴上公差带偏差的必要辅助。

Use:

Gauge to measure the inner taper of HSK spindles. Especially suitable for regular testing.

Standard Specification:

Measuring gauge set in wooden box with taper plug gauge, setting ring, dial indicator (scale value 0.001 mm) and certificate.

Function:

The measuring distance l2 (acc.to ISO 12164-2) in connection with the nominal taper diameter d2 is set to zero (0.00) with the setting ring, the taper plug gauge and the dial indicator. The HSK spindle to be measured will be compared with the data of the taper plug gauge and the dial indicator set to zero.

Note:

The groove at the flat contact surface of the setting ring (0.10) is necessary to measure deviations at the HSK spindle above the upper tolerance.

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