

Measuring Appliance for turning parts

Measuring task

For checking turning parts in the running production the following characteristics have to be measured:

- 3x outside diameter
- 2x run-out to the diameters

Solution

A handling system deposits the parts to be measured on a pneumatic guide (picture 1). In this position, bloc measuring elements measure the first diameter. Then, the slide drives the workpiece in the measuring appliance itself (picture 2). Now, 4 inductive probes for the \varnothing -measurements and 6 probes for the measurements of the run-out are supplied pneumatically.

A SPC-Computer saves and processes the measured data.

After the measurements have been made, the inductive probes are retracted and the slide returns to the pick-up position.

The measurements are based on the principle of comparator measuring, in cyclical intervals, the measuring appliance must be calibrated with a setting master.

