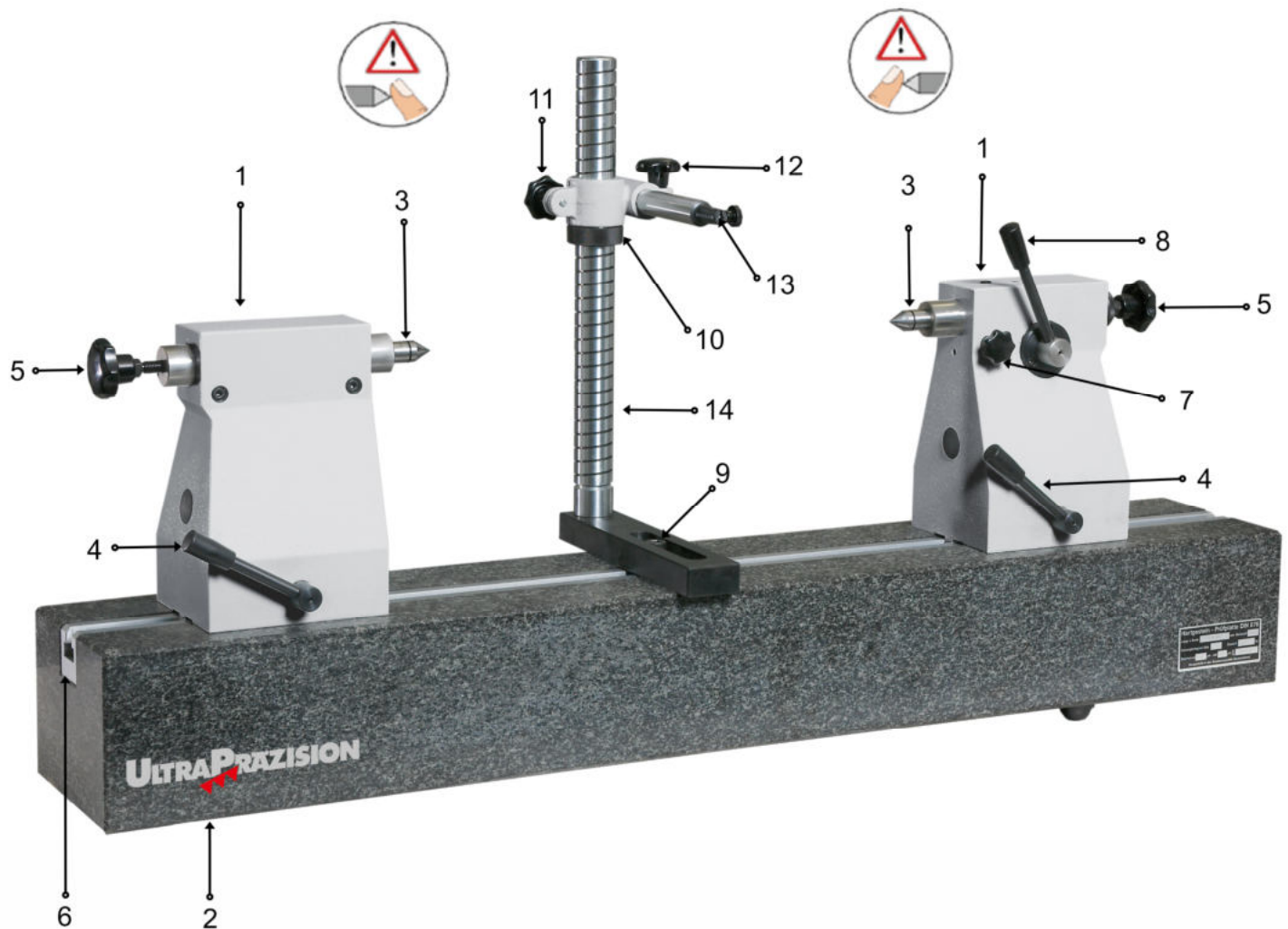


## Complete concentricity tester with granite bench, tailstock-pair and measuring stand



- 1 Tailstocks
- 2 Measuring bench made of natural granite
- 3 centring points (**Warning: pointed, risk of injury**)
- 4 Clamping lever for eccentric clamping
- 5 Forcing screw for removing the centre points
- 6 T-slot rail
- 7 Locking screw of the movable centring point
- 8 Lever for the movable centring point
- 9 Fixation for the stand on the T-slot
- 10 Fine adjustment for height adjustment of the cross arm
- 11 Locking screw for height adjustment of the cross arm
- 12 Locking screw for depth adjustment of the cross arm
- 13 Dial indicator holder  $\varnothing$  8mm with locking screw
- 14 Stand



ULTRA PRÄZISION MESSZEUGE GMBH · Weitzkaut 3 · 63864 Glattbach/Germany

## Construction:

- Place the measuring bench (2) on a flat surface.
- Insert the stand (14) into the T-slot rail (6) and place it in the needed position
- Insert the tailstocks (1) from the outside into the T-slot rail (6) so that the centre points (3) point inwards

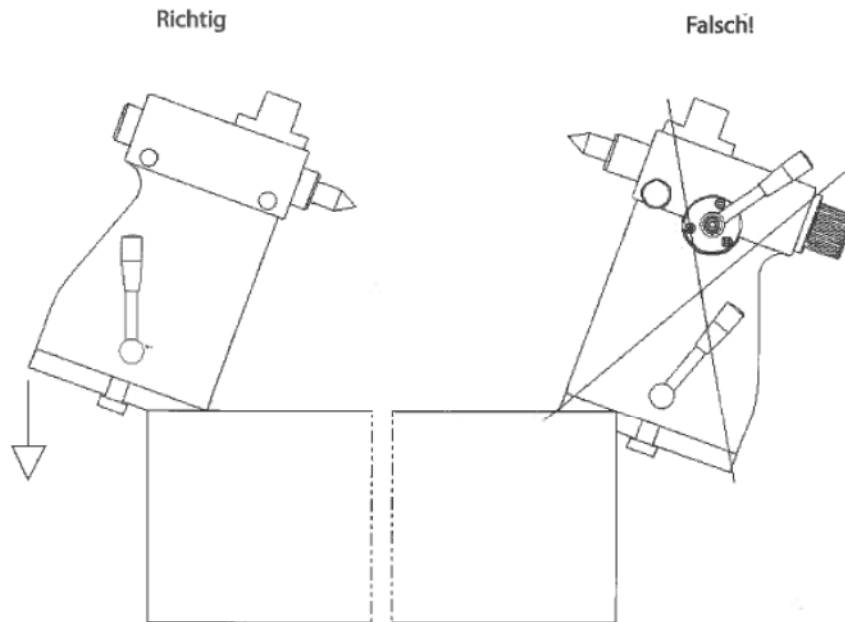
## Insert workpiece and perform measurement:

- Loosen the lever (4) at the tailstocks and set it to the correct distance for the workpiece to be tested and then fix the lever (4) again
- If necessary, loosen the lock (7) and pull back the lever (8) for the centring point of the right tailstock
- Clamp the workpiece between the centring points (3) by let go of the lever (8) forward again
- With the locking screw (7) you can fix the centring points of the right tailstock
- Clamp your dial indicator into the dial indicator holder (13)
- Adjust the cross arm with the dial indicator that the measuring tip of the dial indicator contact the desired measuring point at your workpiece
- With the screw (9) you can loosen the stand and move it to the needed position left or right
- The height of the cross arm can be finely adjusted using the adjusting screw (10) and can be fixed with the locking screw (11)
- With the locking screw (12) you can loosen or fix the cross arm in order to adjust it to the needed position at your workpiece.
- When the dial indicator is placed on the workpiece, set the dial indicator to 0 and rotate the workpiece carefully by hand
- Read the deviations on the dial gauge.

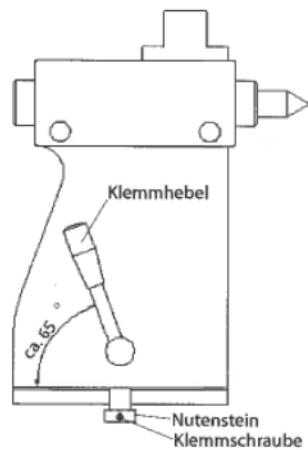
## Maintenance:

- Lubricate the T-slot rail, centring points and sleeve by using a fin oil (example WD40) to protect the surface against corrosion

Richtiges Aufsetzen der Reitstöcke RST 200 auf der Meßbank:  
(Gilt auch für Abrollböcke AB 200)



Richtige Klemmhebelstellung einstellen:



1. Klemmschraube lösen
2. Nutenstein drehen
3. Hebelstellung durch klemmen in T-Nut überprüfen
4. Nutenstein ev. nochmal drehen
5. Klemmschraube anziehen, wenn richtige Hebelstellung eingestellt ist.