

Instruction for use internal chamfer measuring instrument IFM

General

The largest diameter of internal chamfers and tapers can be measured with the IFM. The face and the measuring taper of the IFM are made of hardened steel

With the internal chamfer measuring instrument IFM the maximum diameter of chamfers, tapers and the upper chamfer diameter of bores can be defined. The plane surface and the measuring taper are hardened steel and must be protected against rust.

The indicator has a special face which takes into account the necessary ratio 1:2. Therefore, this dial gauge can not be used for other applications. When using standard indicators, the value shown must be doubled.

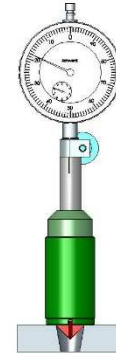
Measuring

The measuring taper must not be put on the work piece impulsively, because this can damage the measuring taper as well as the indicator.

The measured value can be read directly on the indicator.

Calibration

For calibration either a corresponding setting master has to be used or the measuring instrument has to be put on a plane surface for continuous checking. The value shown must be identical to the setting dimension on the side of the indicator.



Measuring



Calibrating

Technical data

Size taper angle 90° Measuring range

IFM 20	0,5	–	20,5 mm
IFM 40	20,1	–	40,1 mm
IFM 60	40,1	–	60,1 mm

Special design with chamfer angle 127°:

Size Measuring range

IFM 20	0,5	–	20,5 mm
IFM 40	20,1	–	40,1 mm

Due to the ratio of the measuring chamfer, 1 mm at the indicator corresponds to a diameter change of 4 mm!

Internal chamfer measuring instrument IFM

Instructions for use



SCHWENK Längenmesstechnik GmbH & Co. KG

Esslinger Straße 84
D- 70736 Fellbach