

LMM 400 / 600

Gauge Calibration

Universal Length Measuring System



LMM 400 / LMM 400T

Universal Length Measuring Machine



LMM 600 / LMM 600T

Universal Length Measuring Machine



Features :

- These models of Universal Length Measuring machines specially designed as standard quality assurance tool in general engineering industry & reference instrument for gauge calibration.
- Compliance with Abbe's comparator principle
- Precision work table provided with 5 axis adjustments for easy location of inversion point.
- Constant measuring force over entire measuring range
- High precision electronic incremental encoder system.
- Provided with variety of accessories to cater wide measurement applications.
- Most affordable price
- Taper Measuring facility available with both machine models as LMM 400T & LMM 600T which facilitates taper measurements also.
- Machine can be interfaced with Gauge measurement and management softwares.
- Optional facility for real time thermal error corrections through software.

Technical Specifications:	LMM 400	LMM 600
Measuring Range		
Absolute	100 mm	
Differential	400 mm	600 mm
Application Range		
External Plain	0-400 mm	0-600 mm
Internal Plain	3 to 300 mm	3 to 450 mm
External Taper	upto 350 mm	upto 550 mm
Internal Taper	3 - 100 mm	3 - 100 mm
Cylindrical Thread External (d2) (Pitch : 0.2 - 6 mm)	1 - 350 mm	1 - 550 mm
Cylindrical Thread Internal (D2) (Pitch : 0.5 - 6 mm)	3 - 300 mm	3 - 450 mm
Taper Thread External (d2)	upto 350 mm	upto 550 mm
Taper Thread Internal (D2)	3 - 100 mm	3 - 100 mm
Gear External (MdK)	7 - 300 mm	7 - 550 mm
Gear Internal (MdK)	30 - 300 mm	30 - 450 mm
Measuring Instruments		
Dial Indicators, Dial test indicators, Cylinder bore gauges	up to 100 mm	up to 100 mm
Internal Micrometer - 2 point	400 mm	600 mm
External Micrometer	150 mm	400 mm

Technical Specifications:	LMM 400	LMM 600
Performance data		
X axis resolution	0.1 μ m	0.1 μ m
Measurement uncertainty	0.5 + L /1000 μ m	0.5 + L /1000 μ m
Measuring force	0.2 N, 2 N	0.2 N, 2 N
Work Table / Vertical Axis		
Work table dimension	160 X 160 mm	160 x 160 mm
Height adjustment	75 mm	100 mm
Resolution	0.1 μ m	0.1 μ m
Float	20 mm	20 mm
Rotation	$\pm 1.5^\circ$	$\pm 1.5^\circ$
Tilt	$\pm 1.5^\circ$	$\pm 1.5^\circ$
Load Capacity	15 kg	20 kg
Dimensions, weight and operational conditions		
L x W x H	850 x 250 x 470 mm	1150 x 250 x 470 mm
Weight (kg)	70 kg	120 kg
Power supply	230 VAC, 50 Hz	230 VAC, 50 Hz
Display System	DRO / PC based	DRO / PC based

Notes:

- In some cases additional standards & optional accessories are required to archive the measuring range.
- Special accuracies, measuring ranges are available upon request.

Octagon ULM Inspect

Gauge Measurement and Management Software



Octagon ULM Inspect.

Features :

- Online Data acquisition from ULM
- Facility for thermal error corrections (Manual / Online)
- Automatic Reversal Point detection for dynamic data
- Operator guided measurement program for plain gauges, thread gauges, spline gauges and inspection / calibration measuring instruments like dial indicators, bore gauges and micrometers.
- Calibration report generation in the format complying to ISO/IEC 17025.
- Gauge record management including calibration date, user details, gauge type, due dates etc.



Basic Module:

- Operator guided measurement program for plain and thread gauges.
- Automatic Tolerance calculations for Plain gauges as per IS 3455 & ISO 919 metric thread gauges as per IS 4218, IS 2334 & ISO 965.
- Thread formulae evaluation for over wire / ball measurements.
- Facility for thermal error corrections (Manual / on-line), correction of systematic machine errors.
- Maintenance of Gauge records

Add-on Module 1

- This add-on module facilitates automatic tolerance calculations and measurement program for various types of thread gauges including ISO metric M, ISO metric MJ, Unified UN -UNR -UNJ, Withworth, ISO pipe G threads, ISO Trapezoidal, ACME Trapezoidal, Stub trapezoidal, Miniature, Buttress, Knuckle screw threads as per various National & International standards.

Add-on Module 2

- Inspection program for Gauge block / length Bar. This add-on module facilitates automatic tolerance calculations and measurement program for gauge blocks as per ISO 3650, IS 2984 and length Bars as per IS 7014.

Add-on Module 3

- Inspection program for Internal / external micrometers. This add-on module facilitates automatic tolerance calculations and measurement program for Internal micrometer as per IS 2966 and external micrometers as per IS 2967 standards.

Add on Module 4

- Inspection program for Dial indicators & Cy. Bore Gauges. This add-on module facilitates automatic tolerance calculations and measurement program for Dial Indicators as per IS 2092, Dial test indicators as per IS 11498 and Cy. Bore Gauges as per JIS 7515 Standard.

Add on Module 5

- Inspection program for Spline Gauges This add-on module facilitates automatic tolerance calculations and measurement program for spline gauges as per ISO 4156.

Add on Module 6

- Inspection program for Taper Gauges. This add-on module facilitates automatic tolerance calculations and measurement program for Taper gauges as per IS 9475, IS 2251 and Taper thread gauges as per BS 21, ANSI/ASNE B1.20.1(NPT)



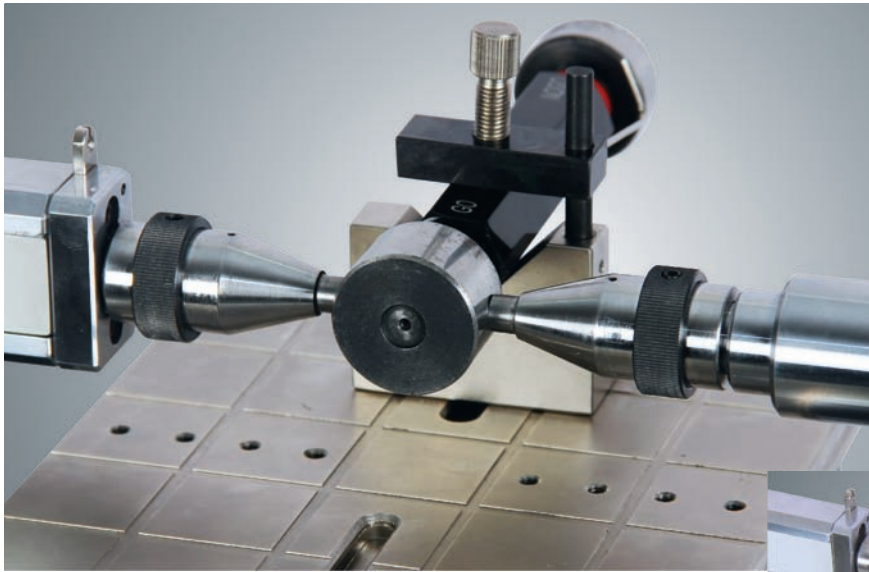
QMSOFT® Gauge Management Software

Octagon Length Measurement machines can also be offered with QMSOFT® Software package from L&W GmbH as an alternative option.

Features :

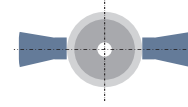
- All nominal sizes and tolerances for all related DIN or ISO standards as well as for ANSI standards, British standards and partly for Japanese, French or Korean standards are calculated by the program system.
- Gauge inspections will be started directly from the gauge management system and will be performed with inspection programs specially designed for the gauge type selected.
- Predefined inspection procedures does the following exactly the given rules and standards. So you do not need any preparation before starting a measurement.



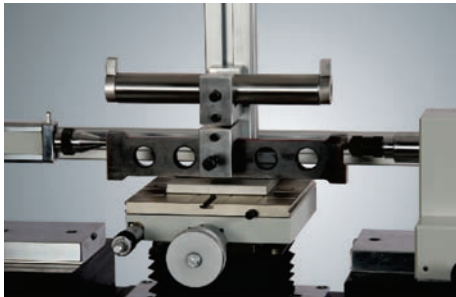


Plug Gauge (below 40 mm) measurement : Hold in Vee block holder

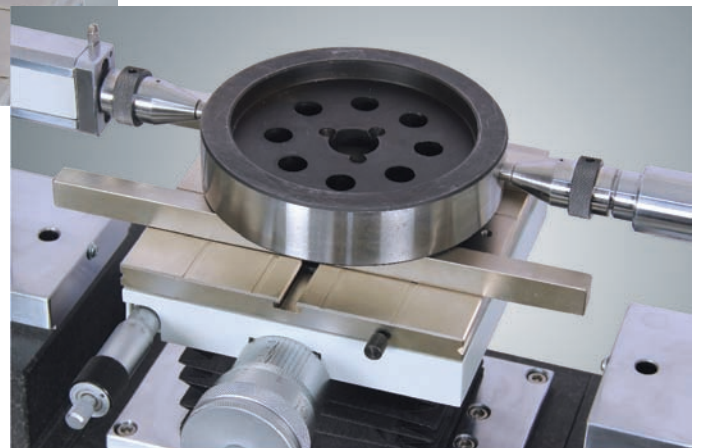
External Measurements
Plain Plug Gauge / Cy. Standard Measurement :
By using a pair of Flat Anvils 8 mm dia.



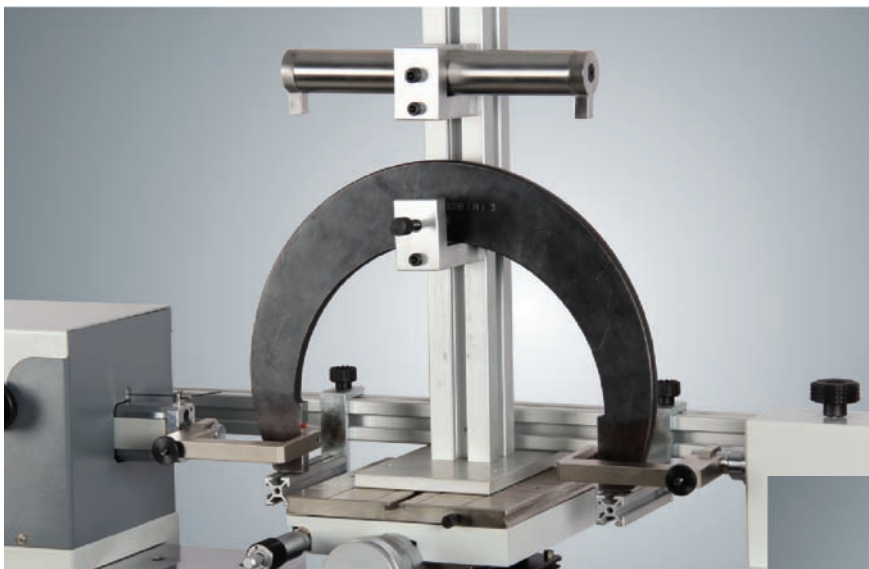
Measurement of cylinder diameter across flat anvils



Plug Gauge (plate type) measurement : Hold on universal holder

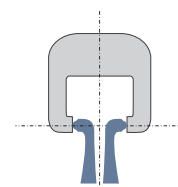


Plug Gauge (above 40 mm) measurement : Hold on parallel blocks

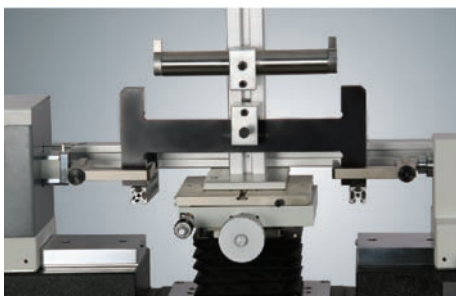


Snap Gauge C Type (above 300 mm) measurement : Hold on universal holder

Internal Measurements
Snap Gauge Measurement :
By using fixed dual arms



Measurement of gap by using spherical contact fixed dual arms



Snap Gauge (I type) measurement : Hold on universal holder

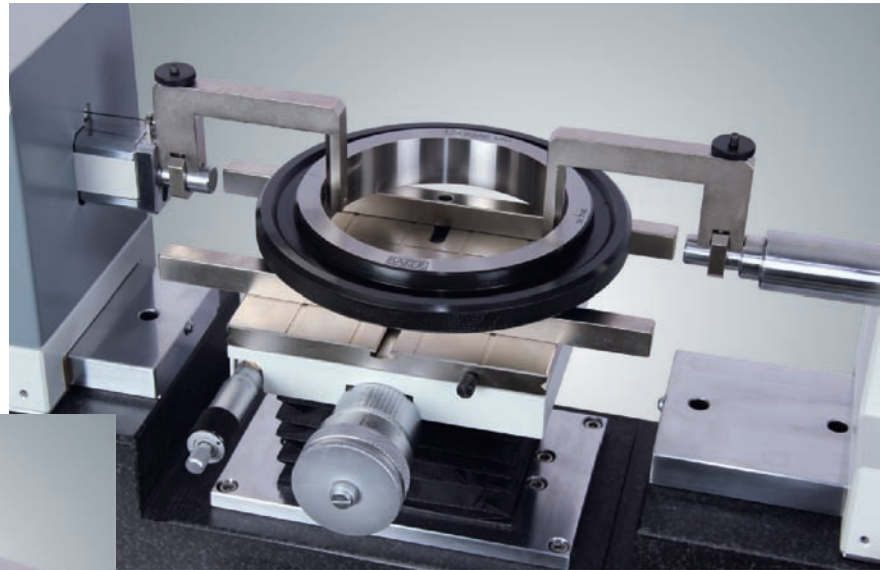


Snap Gauge (below 300 mm) measurement : Hold on snap gauge holding attachment

Internal Measurements

Ring Gauge Measurement :

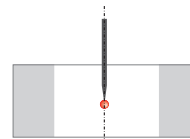
By using Single Arm measuring attachment and / Or by using a pair of fixed dual arms.



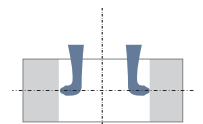
Plain ring diameter (above 10 mm) measurement : Using a pair of fixed arms



Plain ring diameter (above 2 mm) measurement : Using a Single Ruby Ball Stylus with bi-directional probing system of single arm measuring attachment



Measurement of internal diameter by using single arm measuring attachment with one axis bi-directional probing

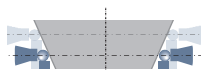


Measurement of internal diameter by using spherical contact fixed dual arms

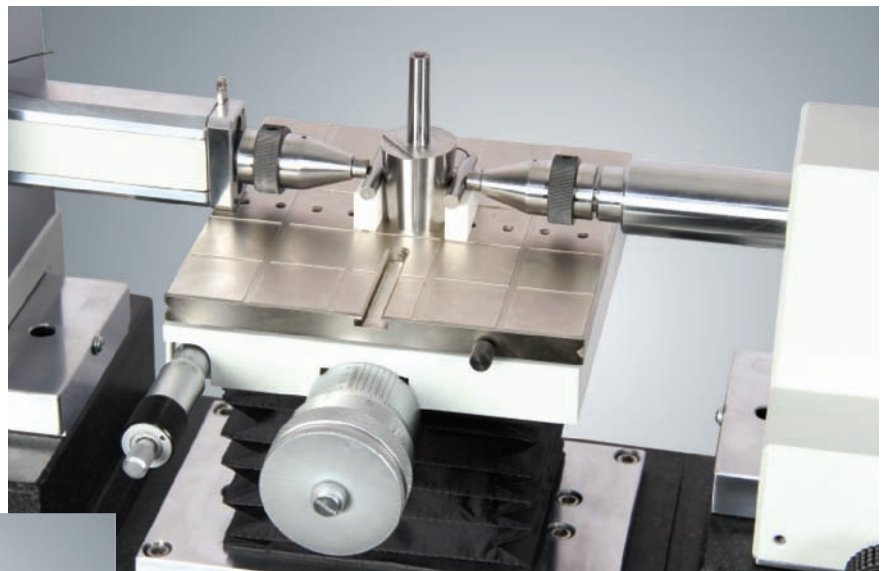
External & Internal Taper Measurements :

Taper Plug Gauge / Taper Ring Gauge

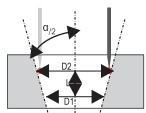
By using Single Arm measuring attachment and / Or by a pair of Flat Anvils 8 mm dia.



Measurement of Taper angle and diameter by Precision cylindrical pin gauges.



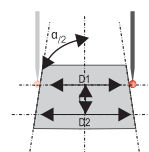
Taper plug gauge measurement : By using cylindrical pin gauges (over pin measurement)



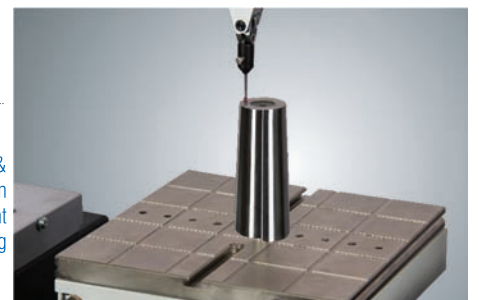
Measurement of Taper angle and diameter by using single arm measuring attachment with two axis bi-directional probing



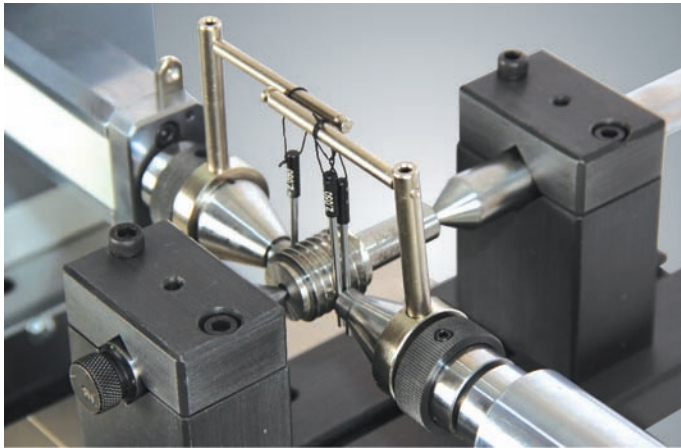
Taper ring gauge measurement : Using a Single Ruby Ball Stylus with bi-directional probing system of single arm measuring attachment



Measurement of Taper angle & diameter by using single arm measuring attachment with two axis bi-directional probing



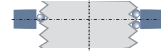
Taper Plug gauge measurement : Using a Single Ruby Ball Stylus with bi-directional probing system of single arm measuring attachment



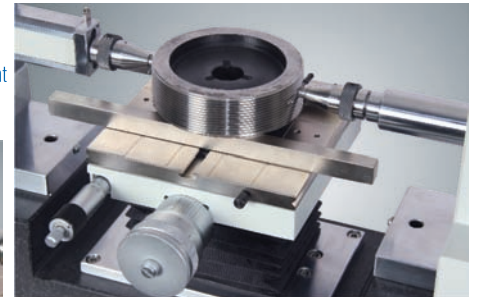
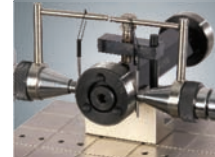
Cylindrical Thread Measurement (External)

Thread Plug Gauge Measurement :

By using three wire method : a pair of Flat Anvils 8 mm dia. & Thread measuring wires



Three Wire Method For Measurement Of Effective Diameter (d2) Of External Thread



Cy. Thread Plug Gauge (below 100 mm) measurement : Hold between center table

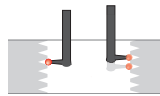
Cy. Thread Plug Gauge Measurement of Effective diameter Below 40 mm : Hold in Vee block holder

Above 40 mm : Hold on parallel blocks

Cylindrical Thread Measurement (Internal)

Thread Ring Gauge Measurement :

Single Arm Measurement /Dual Arms Measurement

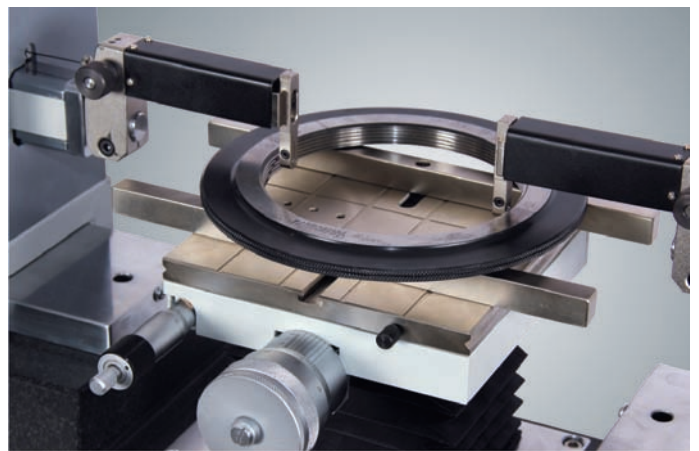


Thread ring gauge measurement of Effective Diameter (D2) by using flexible dual arm & spherical ruby styli

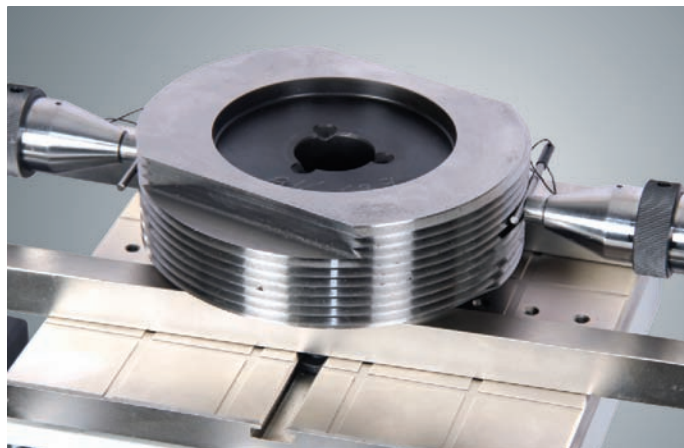


Thread ring gauge measurement of Effective Diameter (D2) by using single arm measurement attachment with single axis bi-directional probe & T-shape stylus

Cy. Measurement of effective diameter by using single arm measuring attachment & Precision Ruby T-Shape styli



Cy. Thread Ring gauge measurement of effective diameter by Precision Ruby ball styli and flexible dual measuring arms



Measurement of effective diameter by thread measuring wires

Taper Thread Plug Gauge Measurement :

By using thread measuring wires and a pair of flat Anvils (8 mm) and / or by using Single Arm Measuring attachment with μ_{2d} probe (Two axis bi-directional probing) and T-shape Ruby stylus.



Taper Thread plug gauge measurement of d2 by using thread measuring wires and a pair of flat anvils



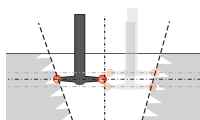
Taper thread plug gauge measurement of d2 by using single arm measurement attachment



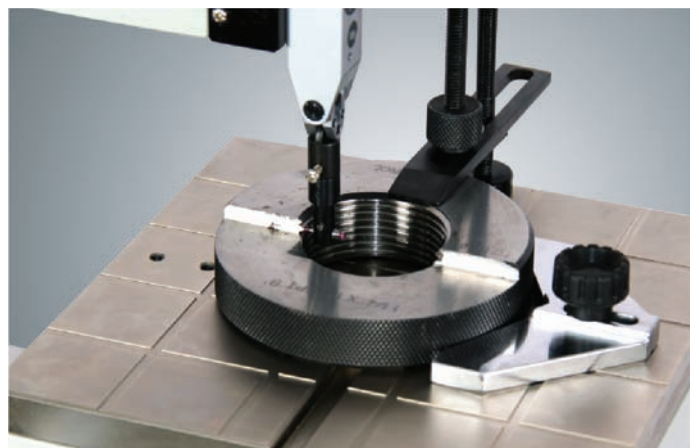
Measurement of effective diameter by T Shape Ruby Stylus Two axis bi-directional probing

Taper Thread Ring Gauge Measurement :

By using Single Arm Measuring attachment with μ_{2d} probe (Two axis bi-directional probing) and T-shape Ruby stylus.

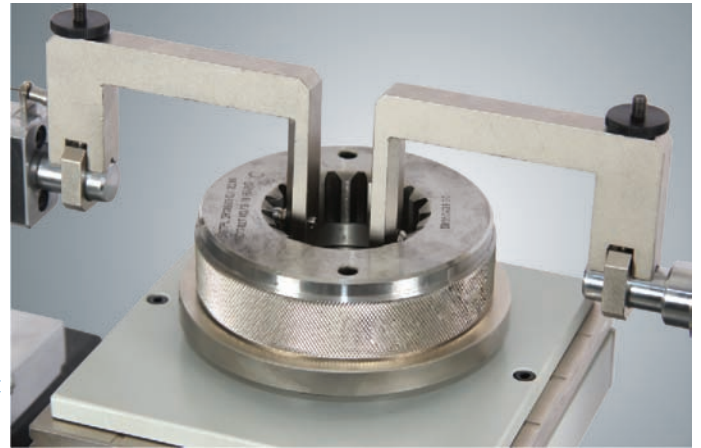
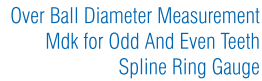
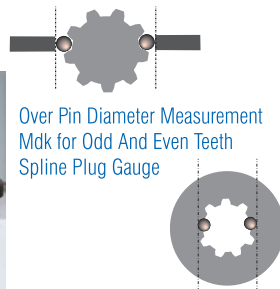
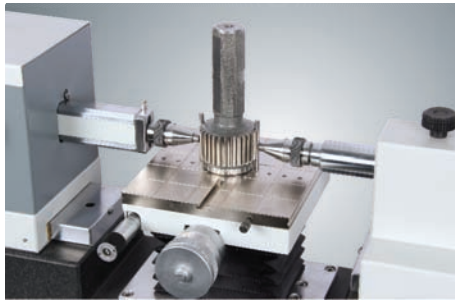


Taper thread ring gauge measurement of D2 by using single arm measurement attachment



Measurement of effective diameter by T Shape Ruby Stylus Two axis bi-directional probing

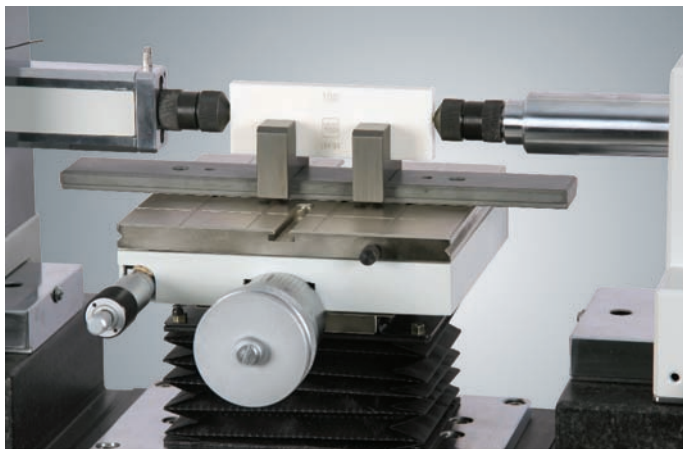
Gear Measurement :
Spline Plug Gauge, Spline Ring Gauge measurement



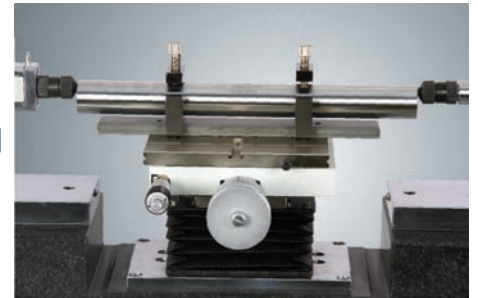
Spline ring gauge measurement by using fixed dual arm and precision spherical styli : Hold on floating table.

Spline plug gauge measurement by using cylindrical pins and a pair of flat anvils

Calibration / Inspection of measuring instruments :
Gauge Block, length Bar, setting standards measurements :
By using a pair of spherical Anvils



Gauge block /
Length Bar measurement
by using a pair of ball anvils



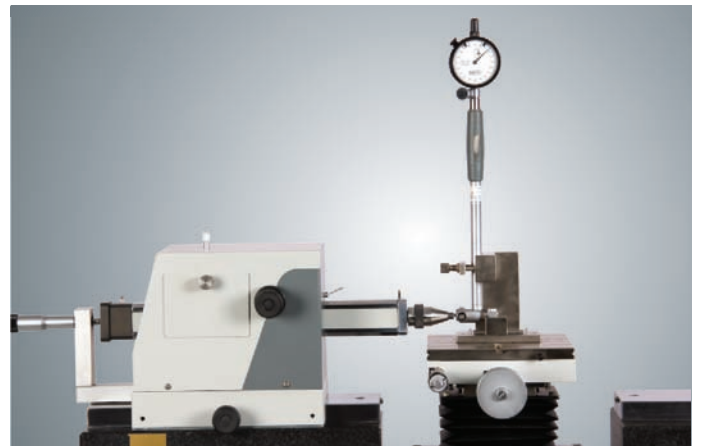
Length bar measurement : Hold on table by using holding attachment

Gauge block measurement : Hold on table by using holding attachment

Calibration / Inspection of measuring instruments :
Dial Indicators, Dial Test Indicators, Bore Gauge



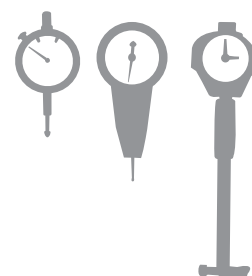
Dial Indicator Calibration : Hold on table by using holding attachment



Bore Gauge Calibration : Hold on table by using holding attachment and machine spindle drive unit.

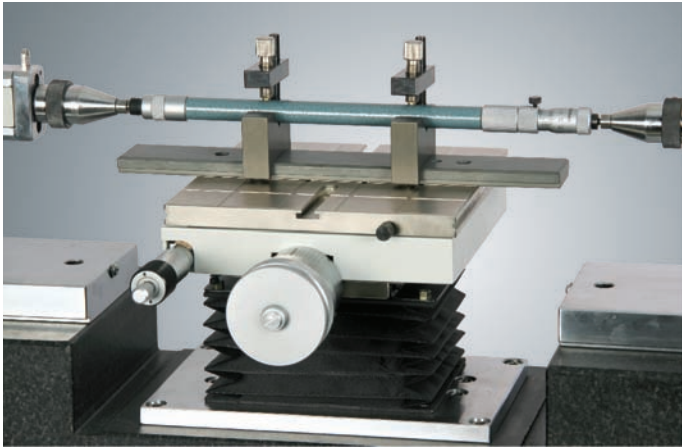


Dial Test Indicator Calibration : Hold on table by using holding attachment



Universal Length Measuring System For Calibration Metrology

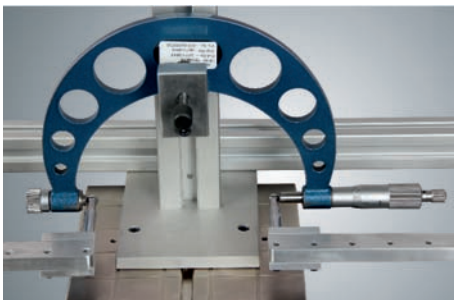
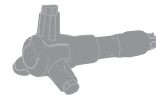
Calibration / Inspection of measuring instruments :
External Micrometers / Internal Micrometers, Calipers.



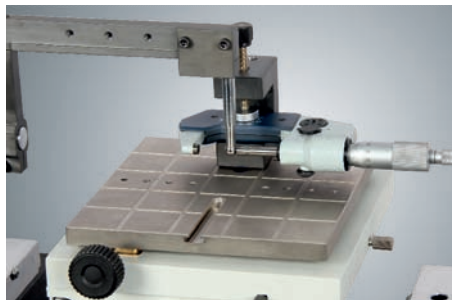
Internal Micrometer (2 point) Calibration : Hold on table by using holding attachment



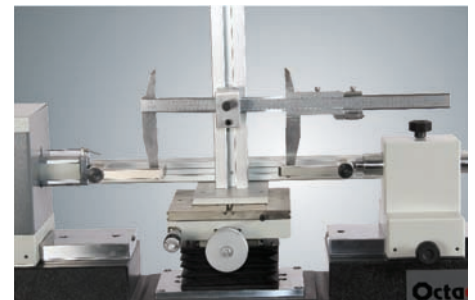
Internal micrometer (3 point) Calibration : By using V reference standards and Flat anvil.



External Micrometer (above 150 mm) Calibration :
Hold on universal holder.



External Micrometer (Below 150 mm) Calibration :
Hold on table by using C clamp



Caliper Calibration : Hold on universal holder



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