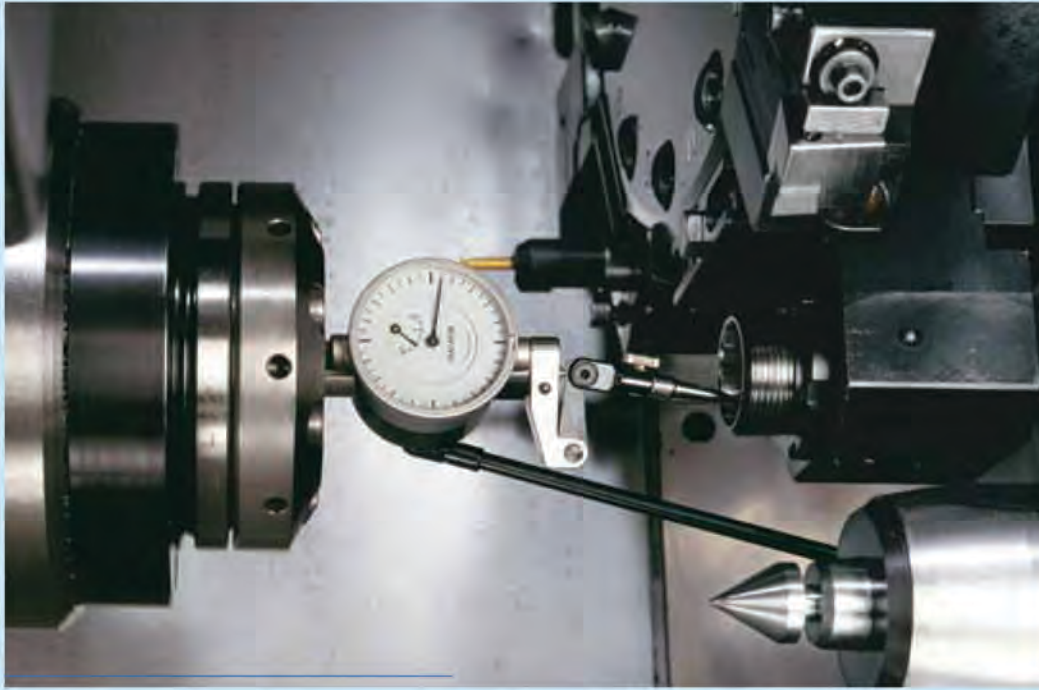




DIACATOR – 校中心检具
DIACATOR – ALIGNMENT GAUGE





DIACATOR 带有一个固定的指示表和一个可旋转测头，是一种可以在多数旋转的机床上快速准确地找到孔和轴中心的检测仪器。

指示表保持面向操作者的方向不变，所以，可以根据校准过程实时进行精确的调整。
校准时，可旋转测头和工作心轴形成一个整体。

The DIACATOR is an instrument with a stationary indicator and a rotary probe for fast and accurate concentric alignment of bores and shafts on most rotary machine tools.

The dial remains stationary and is positioned to face the operator so that he may conveniently and accurately follow the alignment process. During alignment the revolving probe and the working spindle form a single unit.

中心范围

内径: $\Phi 1.5\text{mm}-\Phi 120(340)\text{mm}$
(.06"-4.72" (13.38"))
外径: $\Phi 5\text{mm}-110\text{mm}$
(.2"-4.33")

设计特点

DIACATOR 装有两个精密球轴承，旋转自如。测头使用一个安全的离合器连接，防止运动过程中测头撞到障碍物损坏了仪器。

Centering range

Internal: $\varnothing 1.5\text{ mm to }120(340)\text{ mm}$
(.06" to 4.72" (13.38"))
External: $\varnothing 5\text{ mm to }110\text{ mm}$
(.2" to 4.33")

Design features

The DIACATOR is mounted in two precision ball bearings that render it entirely free from play. The probe yoke is provided with a safety clutch. This is a precaution against damage to the instrument should the probe hang-up on an obstacle while in motion.

应用

用于在铣床、磨床等上面进行加工的孔或轴找正中心使用。

尤其适用于 CNC 机床上基准点的找正。

夹紧能力

8, 10, 12 和 16 mm 以及 3/8", 1/2", 和 5/8" 插入式筒夹；三爪或四爪卡盘；内锥 MK1。

Applications

Concentric alignment of bores and shafts on milling and boring machines etc. Especially suitable for finding reference points on CNC machines.

Chucking possibilities

8, 10, 12 and 16 mm and 3/8", 1/2" and 5/8" spacers for draw-in collet chuck. Three and four jaw chuck. Inside morse taper MK1.

操作特点

相对于其他找正方法而言，进行此种找正操作时，机床处于运动中，这样，找正与之后的工作条件相同。

Operation characteristics

Contrary to other alignment methods, the machine is in motion during the aligning operation. This alignment takes place under the same conditions as the subsequent work.

技术参数

标准仪器包括:

- 指示表 (刻度不分等级——它仅显示偏差用于帮助调整使用)
- 莫氏锥度 MK1
- 夹紧套 $\Phi 10$, 12 和 16 mm, 或 3/8" 1/2" 5/8" 可以选择 (订货时请说明)。
- 挡块 160 mm
- 六角扳手 SW 2mm (0.08")
- 木盒、说明表、检测证书。



Ratings

A standard set includes:

- Dial Indicator (the scale is not graduated – it indicates deflection to assist with adjustment). When Indicator Pointer is stationary then Max Centering Errors below are valid.
- Morse taper MK1
- Screw on spacers $\Phi 10$, 12 and 16 mm or 3/8", 1/2" and 5/8" (pls. specify choice when ordering)
- Stop-rod 160 mm long
- Socket-head wrench SW 2 mm (.08")
- Wooden case, instruction sheet, inspection certificate

测头

测头	内径 Φ mm	最大 中心误差 μm	外径 Φ mm	最大 中心误差 μm
摆动测头	1.5 - 5	10	-	-
测头 25mm	5 - 65	6	5 - 65	10
测头 48mm	10 - 120	8	10 - 110	10

特殊测头 (按要求)

测头	内径 Φ mm	最大 中心误差 μm	外径 Φ mm	最大 中心误差 μm
测头 100mm	20-180	10	-	-
测头 125mm	20-220	15	-	-
测头 150mm	20-260	18	-	-
测头 200mm	20-340	20	-	-

Probe

Probe	Inside- Φ mm	Max. center. Error μm	Outside- Φ mm	Max. center. Error μm
Pendul. Probe	1.5 - 5	10	-	-
Probe 25 mm	5 - 65	6	5 - 65	10
Probe 48 mm	10 - 120	8	10 - 110	10

Special probes (on request)

Probe	Inside- Φ mm	Max. center. Error μm	Outside- Φ mm	Max. center. Error μm
Probe 100 mm	20 - 180	10	-	-
Probe 125 mm	20 - 220	15	-	-
Probe 150 mm	20 - 260	18	-	-
Probe 200 mm	20 - 340	20	-	-

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 地址: 北京市朝阳区八里庄西里 1 号远洋天地 61-603
 邮编: 100025
 Tel: 010-85868342/8, 85865481/2, 13701161985
 Fax: 010-85865483; E-mail: islive@china.com
 Website: www.islive.com.cn

DIATEST Hermann Költgen GmbH

Schottener Weg 6
 D-64289 Darmstadt
 Germany

Tel.: +49 61519790
 Fax: +49 6151979111
 E-Mail: info@diatest.com
www.diatest.com

DIATEST (U.K.) Ltd.

18, Avondale Avenue,
 Hinchley Wood, Surrey,
 KT10 0DA England

Phone +44 2083981100
 Fax +44 2083989887
 E-Mail: sales@diatest.co.uk
www.diatest.co.uk

DIATEST – France S.A.R.L.

Z.I. de la Malnoue, 41,
 Avenue de L'Europe
 77184 Emerainville
 France

Phone +33 (0) 160951277
 Fax +33 (0) 160174798
 E-Mail: info@diatest.fr
www.diatest.fr

DIATEST Sverige

AB Hans Ehlers
 Ranhammarsvägen 24
 168 67 Bromma
 Sweden

Tel.: +46 856470188
 Fax: +46 8362279
 E-Mail: m.ehlers@diatest.se
www.diatest.se

DIATEST USA

11 West College Drive
 Suite I
 Arlington Heights, IL 60004
 USA

Phone +1 8003428378
 Fax +1 8473922197
 E-Mail: diatest@aol.com
www.diatest.us

DIATEST JAPAN Ltd.

15-29, 1-Chome Hitotsuya
 580-0003 Matsubara City,
 Osaka
 Japan

Phone +81 723306661
 Fax +81 723338223
 E-Mail: d-info@diatest-j.co.jp
www.diatest-j.co.jp

DIATEST do BRASIL

Produtos de Medição LTDA
 R. Ulisses Cruz, nº 1.050/1052 -
 3º andar – CJ.06 – Tatuapé
 ZIP: 03077-000 – São Paulo – SP –
 Brazil

Phone +55 1120918811
 Fax +55 1120918801
 E-Mail: info@diatest.com.br
www.diatest.com.br

DIATEST Beijing

Room 603, Ocean Business
 Center No. 61 Balizhuang Xili,
 Chaoyang District
 100025 Beijing

Phone +86 1085865481/82
 Fax +86 1085865483
 E-Mail: islive@china.com
www.islive.com.cn