

Foreword

This instrument is a Linear Gage 0.1µm Resolution. To obtain the highest performance and the longest service life from your Linear Gage, carefully read this manual thoroughly prior to setup and operation. After reading this manual keep it near the Linear Gage for quick reference. The specifications of this gage and the descriptions in this manual are subject to change without prior notification.

Safety Precautions

To ensure operator safety, use the instrument in conformance with the directions and specifications given in this User's Manual.



- If a contact point with a sharp tip is used, exercise sufficient care in handling during replacement or use of it so as not to get hurt.
- If a contact point is released freely after it has been pressed in, the contact point may burst forth at a very high speed depending on the amount of spindle travel. Sufficiently exercise care so that your fingers or hand may not be pinched.

Precautions for Use

Carefully avoid the following attempts and conditions to protect the instrument from failure and malfunction.

IMPORTANT

- Do not apply sudden shocks including a drop or excessive force to the linear gage.
- Do not use and store the gage at sites where it is exposed to direct sunlight or at extremely hot or cold sites.
- To use the gage highly accurately, avoid sites where the temperature will change abruptly.
- Absolutely do not apply an electric engraver to the gage. The high voltage may damage electronic parts. Also, do not use the gage at sites where it is subject to large electric noises.
- Do not exert load on the spindle in the perpendicular direction and do not twist the spindle.
- Do not clamp the stem too tightly, since the spindle will not move smoothly.
- Do not apply excessive tension to the cable or do not bend it forcibly.
- To perform stable measurement, allow at least 10 minutes after turning on the power.
- Do not set up the origin point at either end of the stroke.
- If the gage is used in combination with other instruments, the maximum performance could not be obtained depending on environmental and operating conditions. Take those conditions into consideration prior to use.
- The functions and performance will not be guaranteed, if the gage is used in other conditions than those specified.
- Take sufficient damage-preventive processing (safety measures), should this gage have been at fault.
- A contact point could hurt a workpiece depending on the workpiece material, measuring force, impact when the contact point comes in contact with the workpiece, etc. Check that there is no problem of hurt on a workpiece during measurement or accuracy variation depending on the measuring force, etc., in advance of use.

Electromagnetic Compatibility (EMC)

This product complies with the EMC Directive. Note that in environments where electromagnetic interference exceeds EMC requirements defined in this directive, appropriate countermeasures are required to assure the product performance.

Disposal of Old Electrical & Electronic Equipment (Applicable in the European Union and other European countries with separate collection systems)



This symbol on the product or on its packaging indicates that this product shall not be treated as household waste. To reduce the environmental impact of WEEE (Waste Electrical and Electronic Equipment) and minimize the volume of WEEE entering landfills, please reuse and recycle.

For further information, please contact your local dealer or distributors.

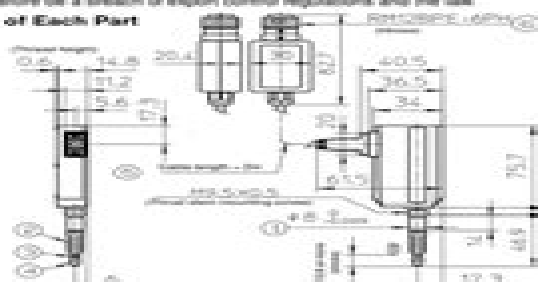
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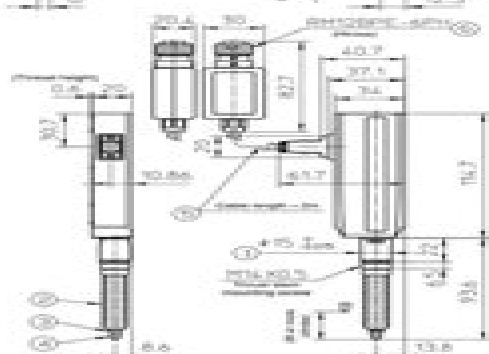
1. Name and Dimension of Each Part

- (1) Stem
- (2) Rubber boot
- (3) Spindle
- (4) Contact point
- (5) Output cable
- (6) Output connector

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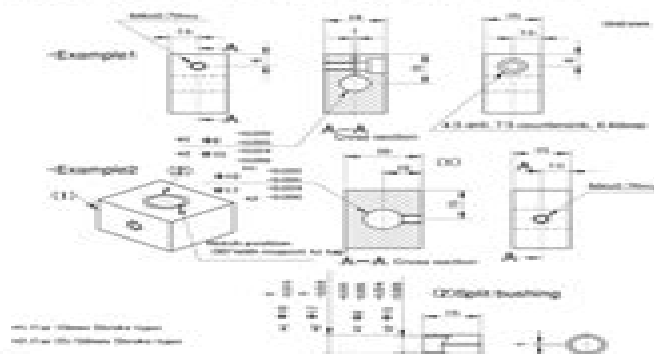


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2. Mounting the Gage

To mount the gage on another instrument or a fixture, clamp the #8 stem or #10 stem. It is recommended to use a slotted holder or a split bushing for the mount structure.



IMPORTANT

- Absolutely avoid pressing the stem directly with set screws. (The built-in bearing may be damaged.)
- Notice that excessively tightening the stem can cause trouble in the spindle operation.
- Never fix a linear gage at other than the stem.
- Mount the gage so that the spindle is directed perpendicular to the measured surface. If the gage is mounted at an angle to the measured surface, an error may be generated in measurement results.
- Exercise care so as not to exert a force on the gage through the cable.



3. Precautions in Protecting the Gage from Dust and Water

IMPORTANT

- The output connector plug and preamplifier (counter side) is not protective structured. Install the gage at a place where it is not splashed directly with water or oil.
- If an extension cable is used, completely cover the preamplifier and connector area with a seal so as not to be exposed to environments.
- If the cable covering is broken, liquid will generate into the gage inside due to capillary phenomenon. This will cause damage to the gage, immediately repair the cable.
- Be greatly careful not to damage the rubber boot due to chips, etc. If the rubber boot is damaged, dust-proof function will be deteriorated. Immediately replace or repair the rubber boot.
- The materials including rubber which are used for the rubber boot and other sealing parts are not universal against diversified coolants and chemicals. If those parts deteriorate mutually, consult the nearest Mitutoyo Service Center.
- If linear gages are used in adverse environments where they are subject to frequent splashes of water and oil, it is recommended to take preventive measures such as replacing them before being damaged.
- Each part of the gage is sealed up, and therefore must not be disassembled. If any part is disassembled, the rated performance will not be obtained. Do not absolutely disassemble the gage.

4. Connecting the Gage to a Counter

Connect the output connector of the gage to the input connector on a linear gage counter. For detailed information, refer to the user's manual of the linear gage counter.

IMPORTANT

- If the gage cable is close to the power line for other instruments, the gage may malfunction. Connect the gage cable as apart from the power line as possible.
- If the gage is connected with other counter than Mitutoyo made, allow at least 0.2 second after the gage is turned on, then read the counter.

5. Gage Output Signals

- Output connector: RM12BPC-60H (Hirose)

Pin assignment

Pin No.	Signal name	Pin No.	Signal name	Pin No.	Signal name
1	5V ₊	3	5V ₋	5	5V ₊
2	SA	4	SB	6	SB

Power supply to the gage head

Power voltage: 5V₊ (4.8V to 5.2V)
Ripple voltage: 200mVp-p or less
Current consumption: 120mA max.

- Input/output signal level
0.4, 0.8, 0.9, 0.2 (TTL line driver AM25L531 or equivalent)

Output signal chart

This series of gages are provided with the following three patterns for their output signals. Therefore, always design the reception circuitry so that it includes an error detecting process making use of these patterns:

- (A) Real-time pulse output (Phase-A wave advances when the spindle is retracted.)



- (1) Output condition: Spindle moving speed = Gage response speed * 4
- (2) Minimum edge-to-edge interval of output pulses: Tr = 0.2 µs
- (3) Output delay time ⁽¹⁾ Max. 2.5 µs

Mitutoyo Operating Manual

**Dr.Dhanalakshmi,Dr.P.Murugabharathi
, Mrs.R.A.Latha Devi,Mrs.V.Suganthi,
Mr.K.Madhavan**

Mitutoyo Operating Manual:

Applied Metrology for Manufacturing Engineering Ammar Grous, 2013-03-04 Applied Metrology for Manufacturing Engineering stands out from traditional works due to its educational aspect Illustrated by tutorials and laboratory models it is accessible to users of non specialists in the fields of design and manufacturing Chapters can be viewed independently of each other This book focuses on technical geometric and dimensional tolerances as well as mechanical testing and quality control It also provides references and solved examples to help professionals and teachers to adapt their models to specific cases It reflects recent developments in ISO and GPS standards and focuses on training that goes hand in hand with the progress of practical work and workshops dealing with measurement and dimensioning

Handbook of Optical Metrology Toru Yoshizawa, 2017-07-28 Handbook of Optical Metrology Principles and Applications begins by discussing key principles and techniques before exploring practical applications of optical metrology Designed to provide beginners with an introduction to optical metrology without sacrificing academic rigor this comprehensive text Covers fundamentals of light sources lenses prisms and mirrors as well as optoelectronic sensors optical devices and optomechanical elements Addresses interferometry holography and speckle methods and applications Explains Moir metrology and the optical heterodyne measurement method Delves into the specifics of diffraction scattering polarization and near field optics Considers applications for measuring length and size displacement straightness and parallelism flatness and three dimensional shapes This new Second Edition is fully revised to reflect the latest developments It also includes four new chapters nearly 100 pages on optical coherence tomography for industrial applications interference microscopy for surface structure analysis noncontact dimensional and profile metrology by video measurement and optical metrology in manufacturing technology

Measurement, Instrumentation, and Sensors Handbook John G. Webster, Halit Eren, 2018-09-03 This new edition of the bestselling Measurement Instrumentation and Sensors Handbook brings together all aspects of the design and implementation of measurement instrumentation and sensors Reflecting the current state of the art it describes the use of instruments and techniques for performing practical measurements in engineering physics chemistry and the life sciences explains sensors and the associated hardware and software and discusses processing systems automatic data acquisition reduction and analysis operation characteristics accuracy errors calibrations and the incorporation of standards for control purposes Organized according to measurement problem the Second Edition Consists of 2 volumes Features contributions from 240 field experts Contains 53 new chapters plus updates to all 194 existing chapters Addresses different ways of making measurements for given variables Emphasizes modern intelligent instruments and techniques human factors modern display methods instrument networks and virtual instruments Explains modern wireless techniques sensors measurements and applications A concise and useful reference for engineers scientists academic faculty students designers managers and industry professionals involved in instrumentation and measurement research and development Measurement

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Coordinate Measuring Machines and Systems Robert J. Hocken,Paulo H. Pereira,2016-04-19 Since John Bosch edited and published the first version of this book in 1995 the world of manufacturing and coordinate measuring machines CMMs and coordinate measuring systems CMSs has changed considerably However the basic physics of the machines has not changed in essence but have become more deeply understood Completely revised and updat **Measurement, Instrumentation, and Sensors Handbook, Second Edition** John G. Webster, Halit Eren,2014-01-29 The Second Edition of the bestselling Measurement Instrumentation and Sensors Handbook brings together all aspects of the design and implementation of measurement instrumentation and sensors Reflecting the current state of the art it describes the use of instruments and techniques for performing practical measurements in engineering physics chemistry and the life sciences and discusses processing systems automatic data acquisition reduction and analysis operation characteristics accuracy errors calibrations and the incorporation of standards for control purposes Organized according to measurement problem the

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Grainger ,1996 **Conventional and Powder Mixed Electro-Discharge Machining** Ahmad Majdi Abdul-Rani,Masdi Muhammad,T V V L N Rao,Saeed Rubaiee,Anas Ahmed,Mohd Danish,2024-09-02 This book presents the evolution of the electro discharge machining EDM process from conventional EDM to powder mixed EDM with emphases on biomedical applications It discusses the theory behind each process and their applications in the field of biomedical research and presents a brief background to various EDM processes current research challenges and detailed case studies of powder mixed EDM of various materials It also includes a state of the art review of the EDM process Features Focuses on biomedical implant and device manufacturing using commercialization of powder mixed electro discharge machining PM EDM technology Discusses surface modification of biomaterials through the PM EDM process Reviews processing of the metallic biomaterials for biomedical applications Explores optimization of the process factors for achieving optimal responses using NSGA II Includes comprehensive mechanism and application details of the PM EDM process This book is aimed at graduate students and researchers in manufacturing production materials and biomedical engineering *Railway Machinery* ,1973

Modern Aspects of Pharmaceutical Quality Assurance Minal Ghante,Manohar Potdar,Vidhya Bhusari,2024-03-11 The pharmaceutical quality system ensures that the process performance is suitably achieved the product quality is regularly met improved opportunities are identified and evaluated and the knowledge is constantly expanded Auditing also plays a crucial role within the pharmaceutical industry It helps to assess and review quality to improve and build a better system for the benefit of companies This book aims to develop a tool that will substantially decrease the number of Inspectional Observations and Warning letters thus eliminating Import Alerts and Consent Decree This book targets the Pharmaceutical Industry and students of Pharmaceutical Quality Assurance so they can get in hand ready consolidated information on Pharmaceutical Quality guidelines Quality metrics and implementation of simplified SOP guidelines plant layouts to implement Quality metrics for Pharmaceutical Manufacturing systems in tablets capsules liquid orals and semi solid dosage forms The chapters cover the various aspects of Pharmaceutical Quality Assurance The selection of topics is mainly based on the requirements of Pharmaceutical regulatory guidelines of India the UK the USA Australia and South Africa Each chapter includes the abstract detailed explanation implementation guidelines flowcharts layouts and Standard Operating Procedure

of quality metrics for the Pharmaceutical Manufacturing System **A Practical Guide to Surface Metrology** Michael Quinten, 2020-01-01 This book offers a genuinely practical introduction to the most commonly encountered optical and non optical systems used for the metrology and characterization of surfaces including guidance on best practice calibration advantages and disadvantages and interpretation of results It enables the user to select the best approach in a given context Most methods in surface metrology are based upon the interaction of light or electromagnetic radiation UV NIR IR and different optical effects are utilized to get a certain optical response from the surface some of them record only the intensity reflected or scattered by the surface others use interference of EM waves to obtain a characteristic response from the surface The book covers techniques ranging from microscopy including confocal SNOM and digital holographic microscopy through interferometry including white light multi wavelength grazing incidence and shearing to spectral reflectometry and ellipsometry The non optical methods comprise tactile methods stylus tip AFM as well as capacitive and inductive methods capacitive sensors eddy current sensors The book provides Overview of the working principles Description of advantages and disadvantages Currently achievable numbers for resolutions repeatability and reproducibility Examples of real world applications A final chapter discusses examples where the combination of different surface metrology techniques in a multi sensor system can reasonably contribute to a better understanding of surface properties as well as a faster characterization of surfaces in industrial applications The book is aimed at scientists and engineers who use such methods for the measurement and characterization of surfaces across a wide range of fields and industries including electronics energy automotive and medical engineering *Eureka* ,2005 *Information Modeling for Interoperable Dimensional Metrology* Y Zhao,T Kramer,Robert Brown,Xun Xu,2011-08-28 Dimensional metrology is an essential part of modern manufacturing technologies but the basic theories and measurement methods are no longer sufficient for today s digitized systems The information exchange between the software components of a dimensional metrology system not only costs a great deal of money but also causes the entire system to lose data integrity *Information Modeling for Interoperable Dimensional Metrology* analyzes interoperability issues in dimensional metrology systems and describes information modeling techniques It discusses new approaches and data models for solving interoperability problems as well as introducing process activities existing and emerging data models and the key technologies of dimensional metrology systems Written for researchers in industry and academia as well as advanced undergraduate and postgraduate students this book gives both an overview and an in depth understanding of complete dimensional metrology systems By covering in detail the theory and main content techniques and methods used in dimensional metrology systems *Information Modeling for Interoperable Dimensional Metrology* enables readers to solve real world dimensional measurement problems in modern dimensional metrology practices *Greater Delaware Valley Regional Industrial Purchasing Guide* ,1987 *Quality Today* ,2003 *Materials World* ,2006

Mitutoyo Operating Manual: Bestsellers in 2023 The year 2023 has witnessed a noteworthy surge in literary brilliance, with numerous engrossing novels captivating the hearts of readers worldwide. Lets delve into the realm of bestselling books, exploring the captivating narratives that have captivated audiences this year. The Must-Read : Colleen Hoover's "It Ends with Us" This heartfelt tale of love, loss, and resilience has captivated readers with its raw and emotional exploration of domestic abuse. Hoover expertly weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can triumph. Mitutoyo Operating Manual : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids absorbing storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens "Where the Crawdads Sing" This captivating coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens weaves a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These bestselling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of engaging stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a brilliant and gripping novel that will keep you wondering until the very end. The novel is a cautionary tale about the dangers of obsession and the power of evil.

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