

Preparing the depth measuring device



Güdel uses the dial gauge with item number 10140477. As an alternative, you can employ a comparable product (resolution = 0.01 mm and shaft = Ø 8 mm).

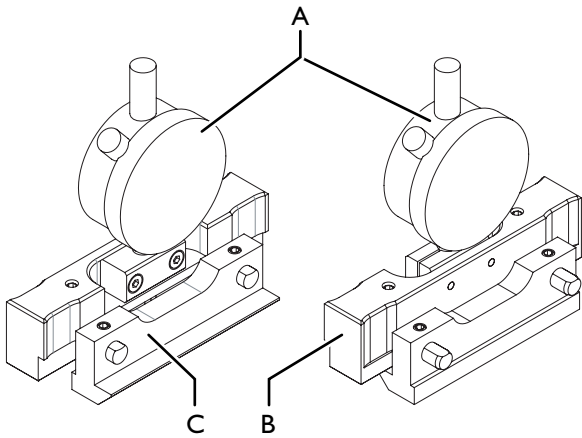


Fig. I-1

Depth measuring device

A Dial gauge 10140477

B Depth measuring device, configuration for prism guideway

C Depth measuring device, configuration for flat guideway

Tool	Use	Item number
Depth measuring device	Measure notches on guideway	10416748
Lubricating spray	Pre-lubricating guideways and racks	10406825

Table I-1

Special tools, testing and measuring instruments

Preparing the
depth measuring
device

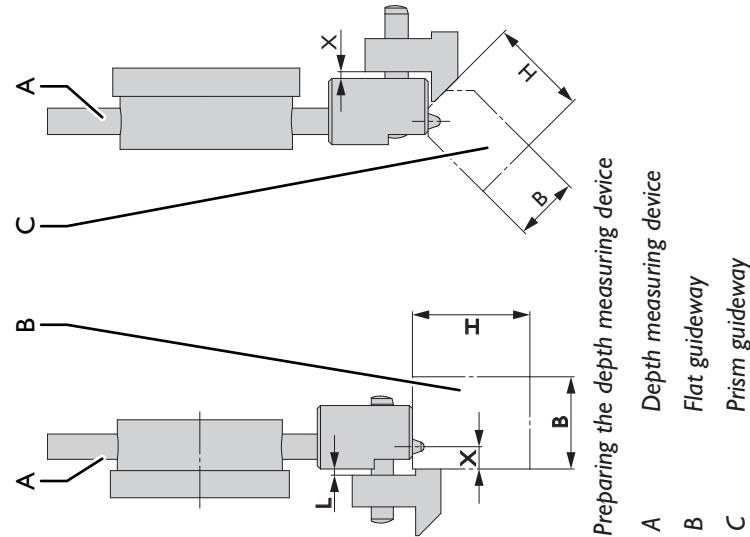


Fig. I-2

Roller support item number	Dimension B [mm]	Dimension H [mm]	Dimension X [mm]	Dimension L [mm]
904200 / 904210	29	37	7	2
904230 / 904240	34.6	46.6	9.5	4.5

Table I-2

Preparing the depth measuring device: Flat guideway

Roller	Guideway	Dimension B [mm]	Dimension H [mm]	Dimension X [mm]
FR15	FSV150 / FZV(A)15(G)	14.5	24.5	1
FR20	FSV200 / FZV(A)20(G)	19.5	29.5	2.5
FR25	FSV250 / FZV(A)25(G)	24.7	33	3.5
FR35	FSV350 / FZV(A)35(G)	34.6	46.6	5

Table I-3

Preparing the depth measuring device: Prism guideway

Prepare the depth measuring device as follows:

- I Set X dimension according to the table.
- The depth measuring device has been prepared.

Measuring the depth of the notch

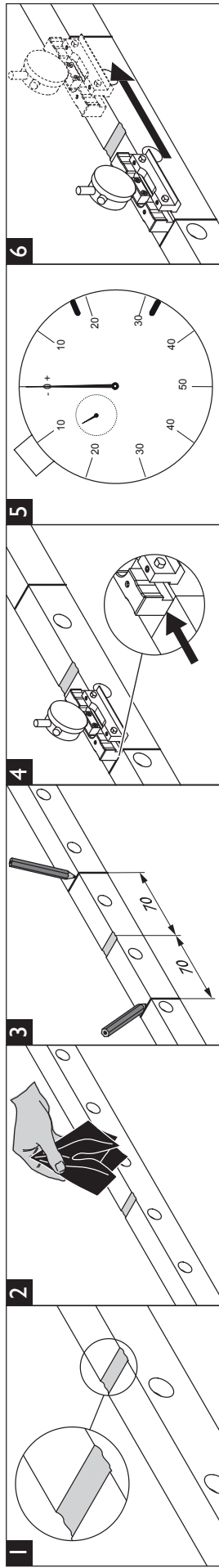


Fig. I-3

Measuring the depth of the notch

Lubricants	Specification	Lubrication quantity
Elkalub FLC 8 HI	Cannot be determined	
Cleaning agents		
mild universal cleaner free from aromatic compounds (e.g. Motorex OPAL 5000)		

Measure the depth of the notch on the guideway as follows:

- I Define the notch to be measured.
- 2 Clean the guideway on both sides of the measurement point with a clean cloth along a length of 200 mm.
- 3 Attach markings 70 mm to the left and right of the measurement point.
- 4 Attach the depth measuring device on the guideway and align it with the left-hand marking.
- 5 Set the dial gauge to "0".
- 6 Move the depth measuring device beyond the measurement point until it reaches the right-hand marking.
(Press the depth measuring device slightly into the guideway when doing so and read the maximum value on the dial gauge.)
- 7 Make note of the maximum value.
- 8 Repeat process as of step 6 until the measured value is reproducible.
- 9 Make note of the final measurement.
- 10 Lubricate the guideway.
- The depth of the notch has been measured.