

## Keyway position checking device for Diameter 100-260 mm



- ▶ Do you set high standards for the location of your feather groove?
  - ▶ Would you have series of rejects and thus avoid the high costs?
    - ▶ Then you should deal with this precision keyway position checking device closer look!

This instrument enables the precise control of the situation of a middle groove and the review of the long grooves parallel to the shaft axis.

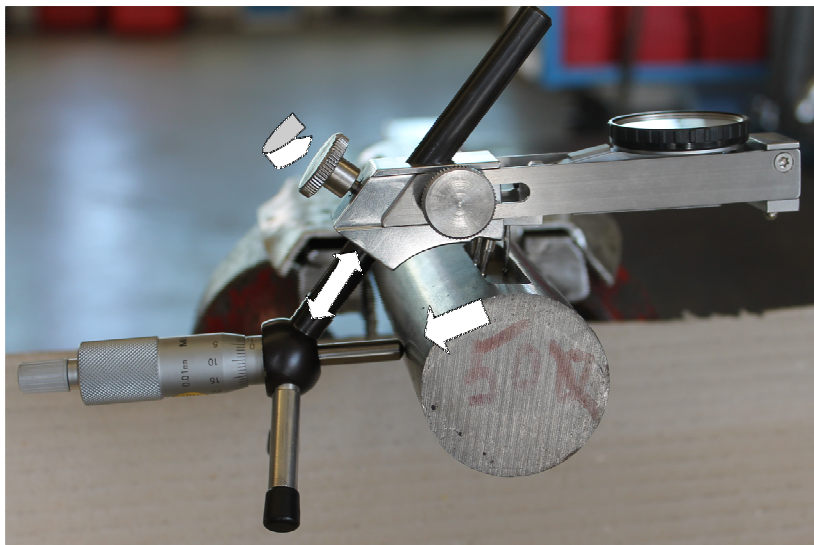
**Technical data:**

<b>Measurement range:</b>	Shafts $\varnothing$ 100 up to $\varnothing$ 260 mm Groove width 28 up to 63 mm
<b>Accuracy of measurement:</b>	+/- 0,01 mm

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## Keyway position checking device

### Instruction "how to use"



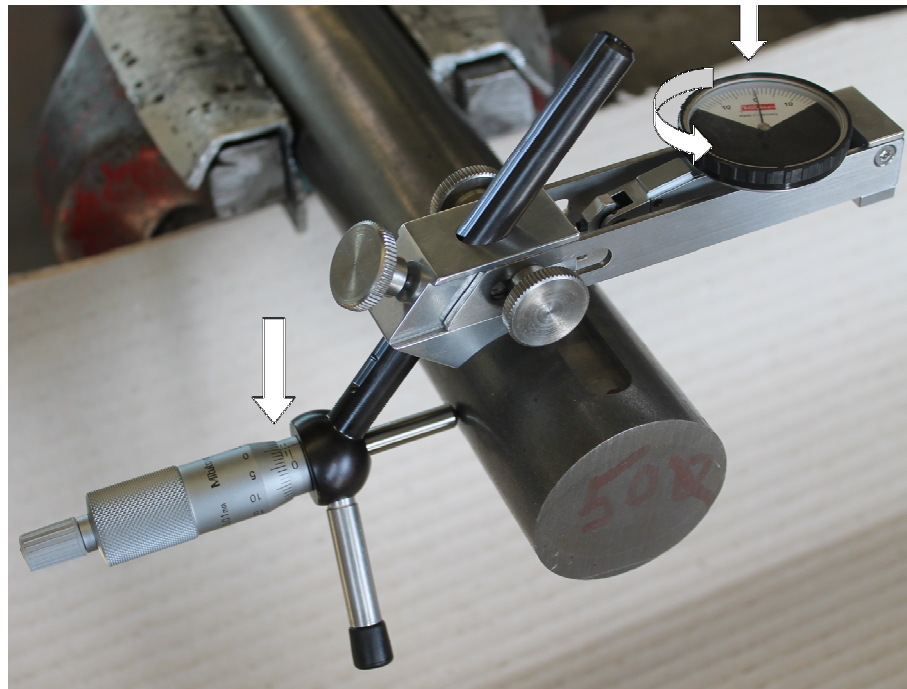
1. loose screw
2. move shaft up or down
3. micrometer shaft should be in middle position of workpiece
4. fix screw



1. loose screw
2. move body of dial gauge right or left
3. gauge finger must be between middle and right side of groove
4. fix screw

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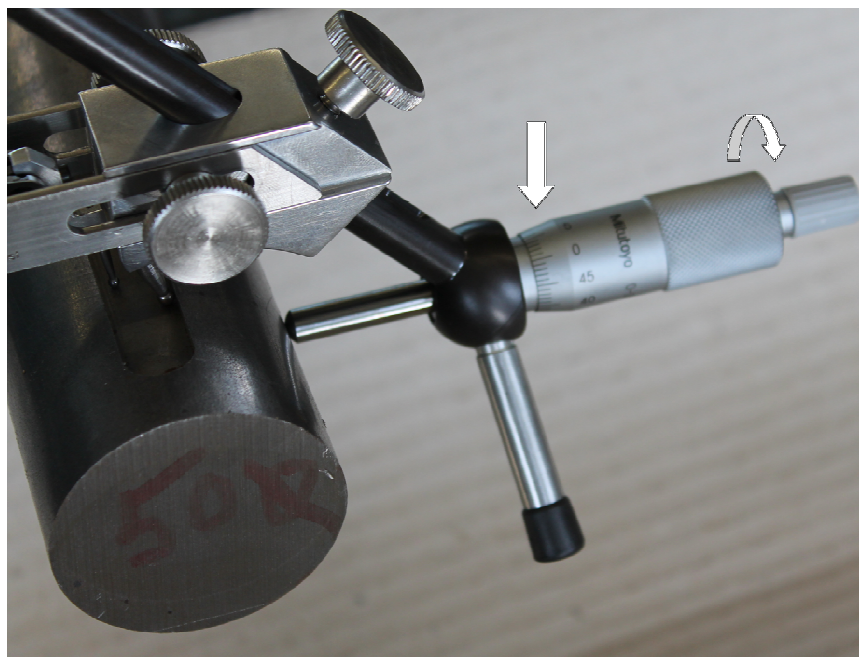
1. micrometer on any "0" position
2. rotate gauge ring to zero position of the gauge finger



1. move checking device to other side of keyway



You will see on gauge if there is any positioning error if its not on zero position.



1. rotate micrometer as long as position is on the gauge becomes zero
2. read the error on micrometer
3. at this shaft the error on micrometer was 0,04mm
4. **divide the error by 2** then you have actual position error (at this workpiece 0,02mm)

## Keyway position checking device Description and Application

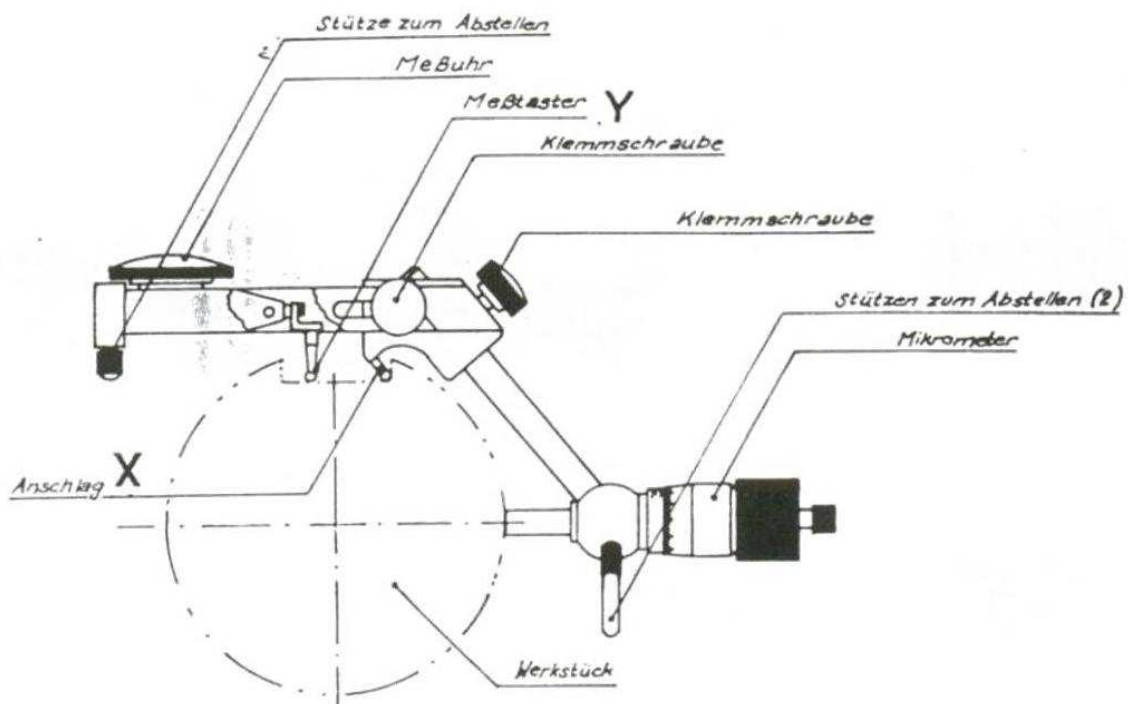
The device is linked to the attack in an X edge of the groove. It is set so that the axis of the micrometer about by the wave center runs and that the probe Y in the vicinity of the other groove side the groove ground affected.

Reassign device following the wave on the other side needs to gauge without changing the micrometer screw show the same value.

Few handles allow to convert the keyway position checking device to other wave and groove dimensions.

The setting is locked with screws.

Three columns are used to store the device.



### Handling

1. Shaft diameter and groove wideness will be adjusted at the device
2. Device will be hinged with the fixture in one groove side.
3. Dial gage and micrometer will be adjusted to „0“
4. Device has to be moved by 180° to the other groove side without any adjustments.
5. Micrometer will be adjusted until the gage will show again „0“. Now the micrometer shows the double deviation of the groove position of the center position.



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