Maho

Test Card
for circular indexing table
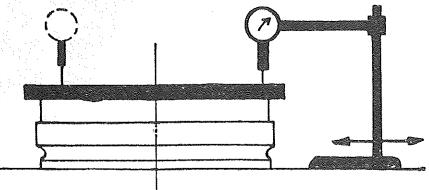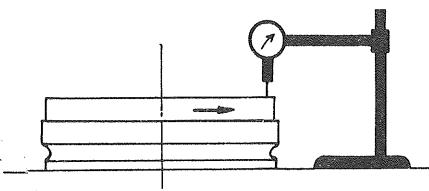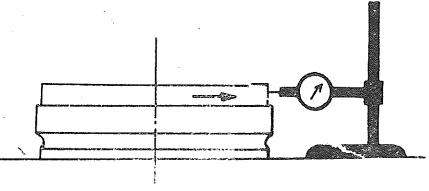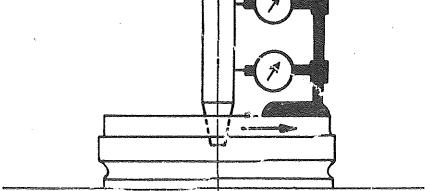### Farbe: 6011
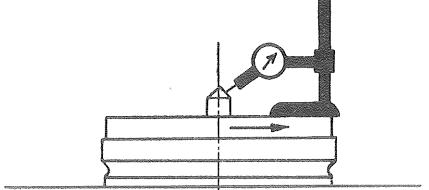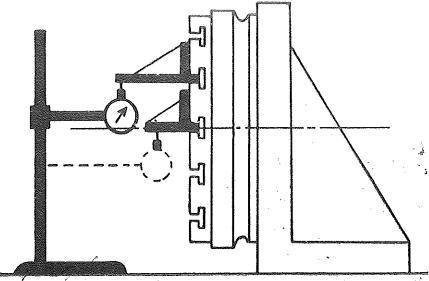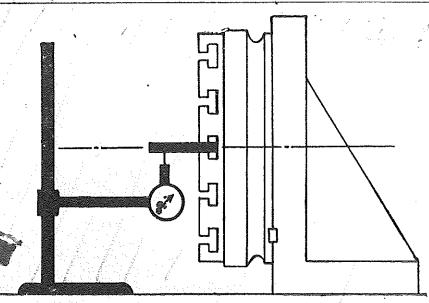
Type: Sk 250 – 450 **Consignee:** Transocean, Montreal

Serial No. 11 660 **Order No.** MH 600 **Date:** 14.12.69 **Purchaser:** Pfeiffer H.

No.	Object of measurement	Illustration	Measuring tool	Perm. tolerance	Measured tolerance (deviation)	Instruction for test method
1	Circular table plane linear lateral		Line, graduated Dial gage	Linear 0,02/300 mm Lateral 0,02/300 mm	.0004 .0002	Put graduated straight edge on circular table. Adjust dial gage i. pos. Measure at 2 oposite points. Dito in transverse direction.
2	True running (planeface) of circular table		Dial gage	0,02/300 mm	.0004	Adjust dial gage i. Pos. (see illustration). Turn circular table slowly.
3	Concentric running of circular table		Dial gage	0,05 mm ∅	.0008	Adjust dial gage (see illustration). Turn circular table slowly.
4	Cone-shaped centering point		Testing plug gage and Dial gage	0.02/300 mm	.0006	Dial gage on table, put plug gage into cone. Turn circular table slowly.
5	Concentric running of centering point		Dial gage	0,01 mm	.0002	Dial gage on table (see illustration). Turn circular table slowly.
6	Parallelism of slots		Clamping angle Bevel protractor Dial gage	± 0,02/300 mm	Stots 1 ___ 2 ___ 3 ___ / 4 ___ 5 ___ 6 ___ 7 ___	Set circular table vertically. Slots parallel to table. Clamp bevel in first slot. Measure full lenght of slot. Dito 2nd slot. Note deviation of parallelism of the slots, laying side by side. Each slot: Width:
7	Displacement of middle slot from center		Clamping angle End block Dial gage		.0024 for instance 0,05 →	Set circular table vertically. Clamp end block into middle slot. Measure distance (see illustration). Slot has to be parallel to 2nd plate. Turn circular table 180 deg. without notches. Again measure distance. Note difference. Engrave half of this difference and mark with arrow, pointing to side with smaller deviation.

No.	Object of measurement	Illustration	Measuring tool	Perm. tolerance	Measured tolerance (deviation)	Instruction for test method
8	Middle slot corresponds with notch		Clamping angle End block Dial gage	± 0,06/300 mm	₀0012	Set circular table vertikally. Fit T-slots horizontally in inner angle of circular table. Clamp end block into middle slot. Adjust dial gage (see illustr.) Measure full lenght of slot with dial gage. Turn circular table 180 deg. Measure again. If coarse differences equalize with eccentric.
9	Division of Indexing plate		Graduated control disc with clamping device Microscope Lamp for (indirect) counter-light	Total ± 1 Min. For fractional divisions ± 45 sec.	± 2'	Put control disc on circular table and center it. Adjust lamp and microscope (see illustration). Turn spindle (40 turns of spindle = 1 rotation of circular table). Check faults by means of microscope and read off per control disc.
10	Division of notches		Graduated control disc with clamping device Microscope Lamp for (indirect) counter-light	Total 1 min. Notches per pair ± 45 sec.	± 2' /	Put control disc on circular table and have it centered. Adjust lamp and microscope. Turn circular table and have it notches-in. Verify distances of notches by means of microscope.

PS. re: 7 and 8 Take care, that gage blocks are perfectly angular to table.

re: 9 and 10 Note down by what method of measurement deviation has been identified.
Specify notch, indexing plate and hole circle.