

MODULAR MEASURING SYSTEM

Quick Set™ is a retoolable modular system that can be assembled in three different gauging configurations:

- horizontal and vertical for multi-

dimensional and geometric checking of shaft-like parts;

- chuck for multidimensional and geometric checking on parts that cannot be referenced horizontally with vees or held between centers, such as bushings, bearings,

pistons and cylindrical parts that are manufactured with a flange.

Its flexibility guarantees quick retooling without any special tools, using shop-floor components available off the shelf.

The narrow 12 mm (.47") width of all components allows a large number of measuring sections on a short part surface. Several measuring assemblies can be mounted on the base to carry on diameter, distance and geometric measurements.

Part support options allow static as well as dynamic inspection.

It can accommodate any measuring gauge with clamping diameter 8 mm or 3/8", such as TESTAR Red Crown™ and Quick probe™, Quick Read™ compact electronic display unit, Quick Digit™ electronic digital indicator.

PART WEIGHT AND DIMENSIONS REFERENCE TABLE

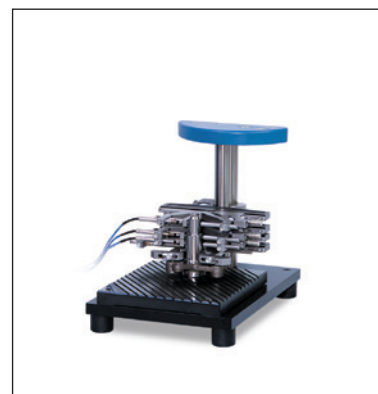
| GAUGE CONFIGURATION | MEASURABLE DIAMETER | MAX. NON-MEASURABLE DIAMETER | MAX. MEASURABLE LENGTH | WEIGHT |
|----------------------|---------------------------|------------------------------|------------------------|-------------|
| Quick Set-Horizontal | 5 – 160 mm (.02" – 6.30") | 260 mm (10.24") | 700 mm (27.56") | up to 14 kg |
| Quick Set-Vertical | 5 – 160 mm (.02" – 6.30") | 260 mm (10.24") | 520 mm (20.47") | up to 8 kg |
| Quick Set-Chuck | 5 – 160 mm (.02" – 6.30") | 260 mm (10.24") | 250 mm (9.84") | - |



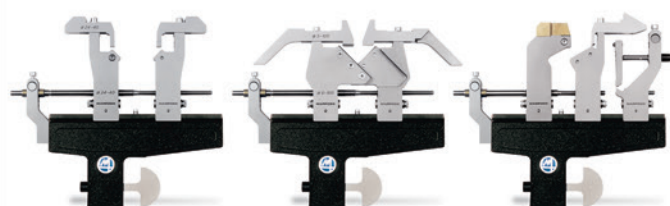
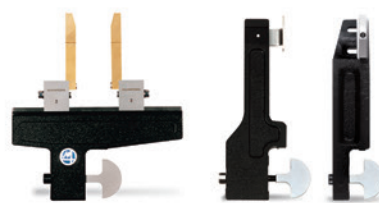
Quick Set - Horizontal



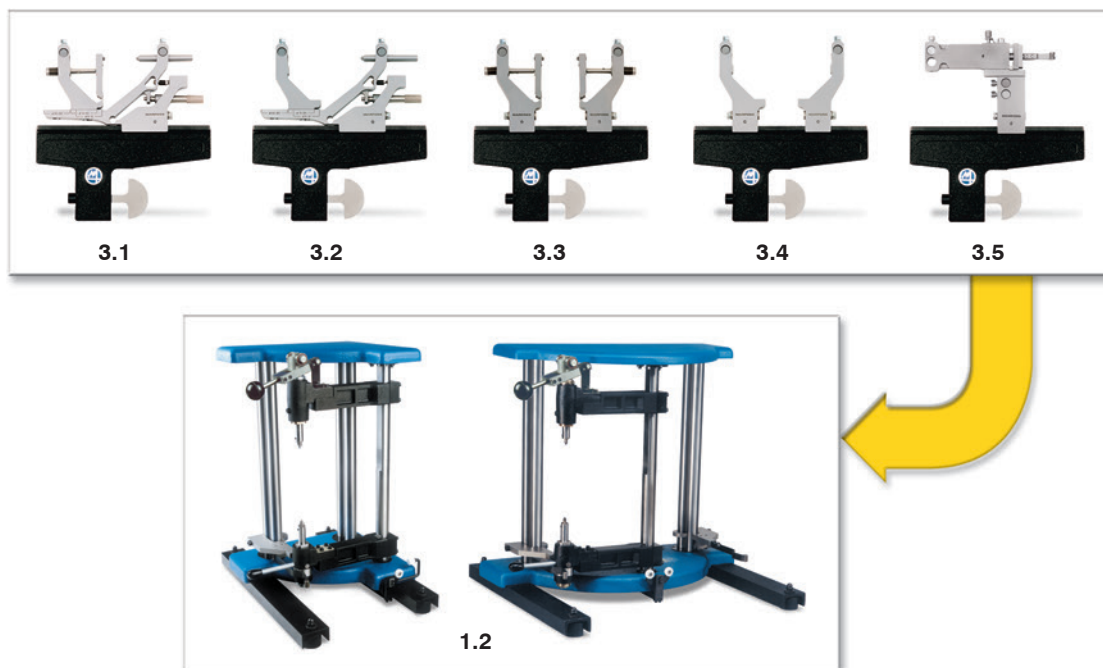
Quick Set - Vertical



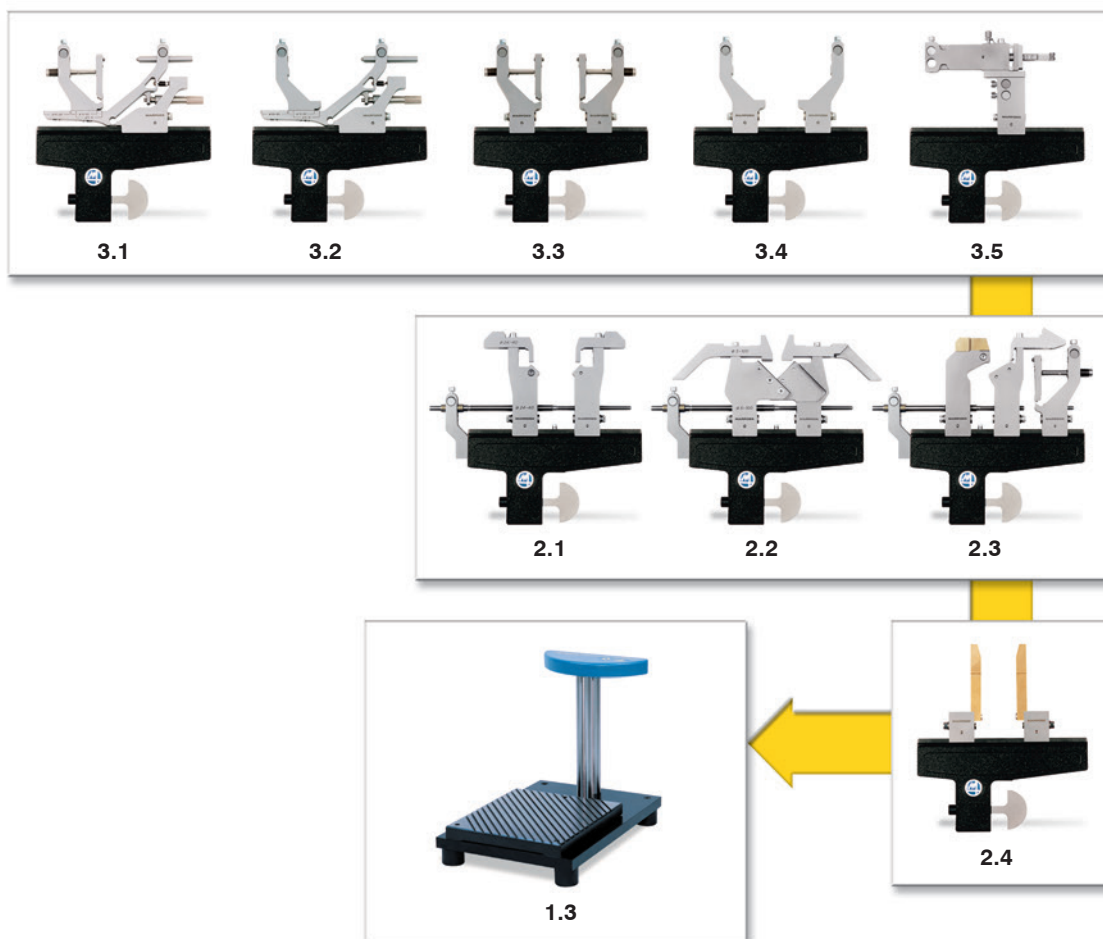
Quick Set - Chuck

QUICK SET - HORIZONTAL**3.1****3.2****3.3****3.4****3.5****2.1****2.2****2.3****2.7****2.4****2.5****1.1**

QUICK SET - VERTICAL



QUICK SET - CHUCK



INDEX

1. BASE STRUCTURE ASSEMBLY

- 1.1 Base structure assembly for Quick Set-Horizontal
- 1.2 Base structure assembly for Quick Set-Vertical
- 1.3 Base structure assembly for Quick Set-Chuck

2. PART SUPPORT AND REFERENCE

- 2.1 Frontal "V" assembly
- 2.2 Crossed "V" assembly
- 2.3 Measuring "V" assembly
- 2.4 Part radial limiters assembly
- 2.5 Part axial limiters
- 2.6 Part pusher
- 2.7 Pivoting centers unit

3. PART MEASURING ASSEMBLY

- 3.1 Assembly with self-centering unit with transmission
- 3.2 Assembly with self-centering unit with direct probe
- 3.3 Assembly with single transmission unit
- 3.4 Assembly with direct probe unit
- 3.5 Assembly with shoulder transmission unit

4. CONTACTS AND ARMSETS

- 4.1 Standard contacts
- 4.2 Contacts for measuring V
- 4.3 Contact extensions
- 4.4 Off-set arms
 - 4.4.1 Armset for self-centering unit with transmission
 - 4.4.2 Armset for single transmission unit
- 4.5 Contacts and armsets for shoulder transmission unit

5. WRENCH SET

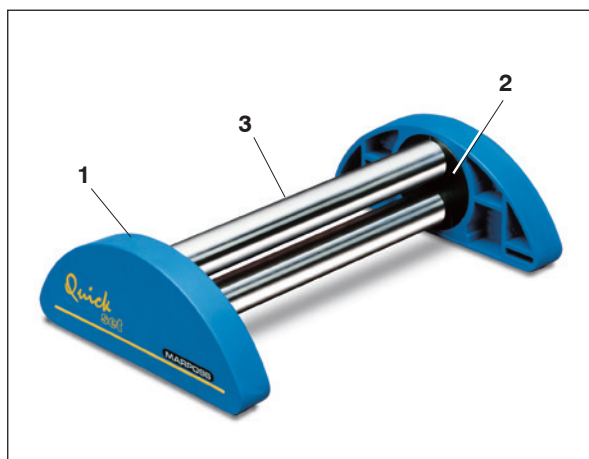
6. INSTRUCTION MANUAL

7. QUICK SET CONFIGURATOR PROGRAM

1 - BASE STRUCTURE ASSEMBLY

30 mm diameter stainless steel bars assure rigidity and exact positioning of the bench gauge elements. The bar system allows easy retooling and size expansion of the bench. The bars are fixed to the support by means of a screwed clamp fitted inside the support.

1.1 BASE STRUCTURE ASSEMBLY FOR QUICK SET-HORIZONTAL

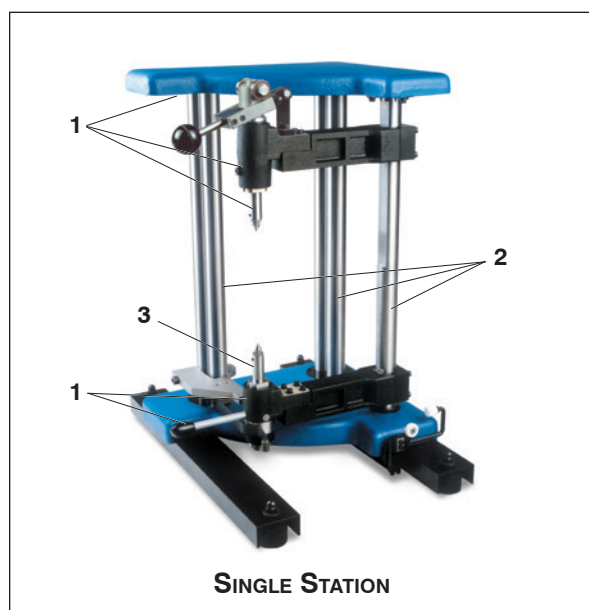


| BARS LENGTH | | BENCH WITH "V" | | | | BENCH WITH PIVOTING CENTERS | |
|-------------|--------|--|--------|---|--------|-----------------------------|--------|
| | | Max. part length with 2 introducing axial limiters | | Max. part length with 1 introducing axial limiter and 1 measuring axial limiter | | Max. part length | |
| (mm) | (inch) | (mm) | (inch) | (mm) | (inch) | (mm) | (inch) |
| 200 | 7.87" | 100 | 3.94" | 70 | 2.76" | 80 | 3.15" |
| 300 | 11.81" | 200 | 7.87" | 170 | 6.69" | 180 | 7.08" |
| 400 | 15.75" | 300 | 11.81" | 270 | 10.63" | 280 | 11.02" |
| 500 | 19.69" | 400 | 15.75" | 370 | 14.57" | 380 | 14.96" |
| 600 | 23.62" | 500 | 19.69" | 470 | 18.50" | 480 | 18.89" |
| 800 | 31.50" | 700 | 27.56" | 670 | 26.38" | 680 | 26.77" |

The base structure assembly includes bars, support feet and clamping devices.

| REF. | DESCRIPTION | ORDER CODE |
|------|-------------------------|------------|
| 1 | SUPPORT FEET (PAIR) | 2924017005 |
| 2 | CLAMPING DEVICES (PAIR) | 2924017115 |
| 3 | BARS L = 200 mm (PAIR) | 2924017010 |
| | BARS L = 300 mm (PAIR) | 2924017020 |
| | BARS L = 400 mm (PAIR) | 2924017030 |
| | BARS L = 500 mm (PAIR) | 2924017040 |
| | BARS L = 600 mm (PAIR) | 2924017050 |
| | BARS L = 800 mm (PAIR) | 2924017070 |

1.2 BASE STRUCTURE ASSEMBLY FOR QUICK SET-VERTICAL



| BARS LENGTH | | QUICK SET-VERTICAL | | | | | | | |
|-------------|--------|---|--------|------|--------|---|--------|------|--------|
| | | Part length with lower center support L=12 mm | | | | Part length with lower center support L=37 mm | | | |
| | | Min. | | Max. | | Min. | | Max. | |
| (mm) | (Inch) | (mm) | (Inch) | (mm) | (Inch) | (mm) | (Inch) | (mm) | (Inch) |
| 500 | 19.69" | 24 | 0.94" | 220 | 8.66" | 5 | 0.20" | 200 | 7.87" |
| 600 | 23.62" | 24 | 0.94" | 320 | 12.60" | 5 | 0.20" | 300 | 11.81" |
| 700 (*) | 27.56" | 24 | 0.94" | 420 | 16.54" | 5 | 0.20" | 400 | 15.75" |
| 800 (*) | 31.50" | 24 | 0.94" | 520 | 20.47" | 5 | 0.20" | 500 | 19.69" |

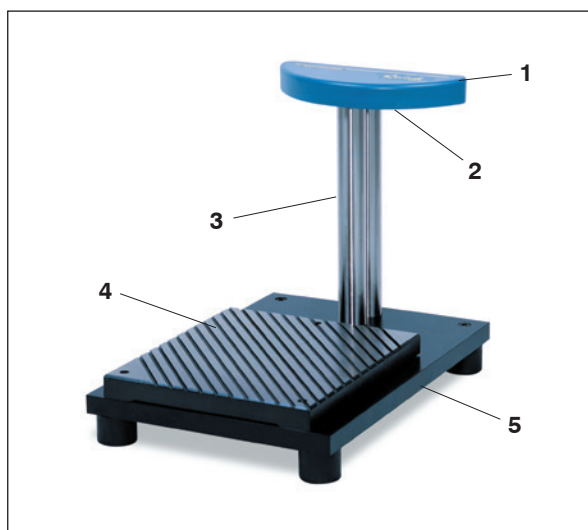
(*) Only for dual station.

Max. part weight: 6 kg for the single station, 8 kg for the dual station.

The base structure assembly is composed of base, bars, lower center support and centers. The upper center support is supplied with the base.

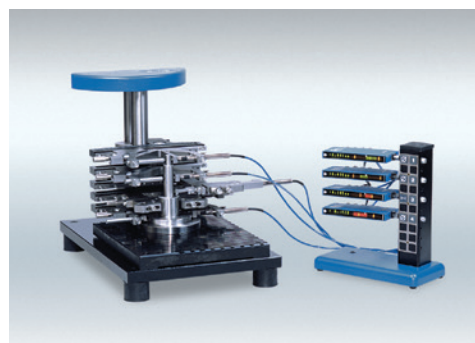
| REF. | DESCRIPTION | ORDER CODE |
|------|---|------------|
| 1 | SINGLE STATION BASE | 3024025501 |
| | DUAL STATION BASE | 3024025001 |
| 2 | BARS L = 500 mm | 3024025025 |
| | BARS L = 600 mm | 3024025026 |
| | BARS L = 700 mm | 3024025027 |
| | BARS L = 800 mm | 3024025028 |
| 3 | LOWER CENTER SUPPORT L = 12 mm | 3024025220 |
| | LOWER CENTER SUPPORT L = 37 mm | 3024025210 |
| | UNIVERSAL CENTER | 1024017753 |
| | SHORT CENTER | 1024017755 |
| | SUPPORT BRACKET WITH BACK HOLES FOR TOOL | 2924025255 |
| | RETOOLING TOOL (ONLY FOR BRACKET WITH BACK HOLES) | 2924025050 |

1.3 BASE STRUCTURE ASSEMBLY FOR QUICK SET-CHUCK



The base structure assembly is composed of bars, support feet, clamping devices, serrated referencing surface and support plate.

| REF. | DESCRIPTION | ORDER CODE |
|------|---|------------|
| 1 | SUPPORT FEET (PAIR) | 2924017005 |
| 2 | CLAMPING DEVICES (PAIR) | 2924017115 |
| 3 | BARS L = 300 mm (PAIR) | 2924017880 |
| 4 | SERRATED REFERENCING PLATE (220 x 250 mm) | 2924017885 |
| | CHROMED SERRATED REFERENCING PLATE (220 x 250 mm, HRC 68) | 2924017886 |
| 5 | SUPPORT PLATE (INCLUSIVE OF RUBBER FEET) | 2924017890 |

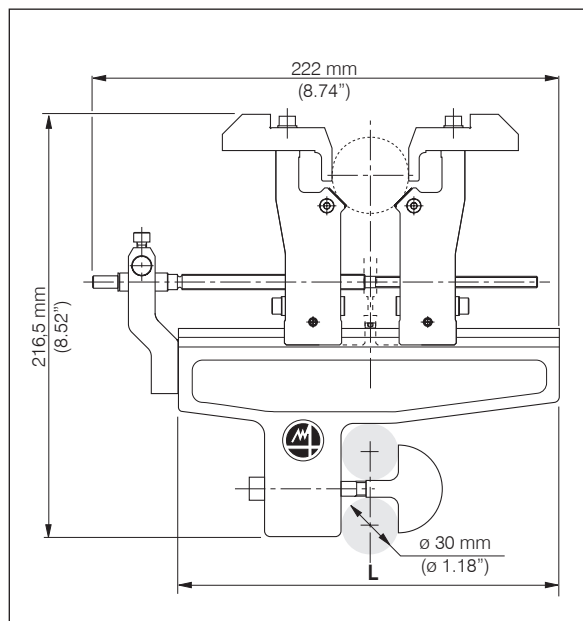


2 - PART SUPPORT AND REFERENCE

2.1 FRONTAL "V" ASSEMBLY



ASSEMBLY WIDTH: 12 mm (.47")
VERSION WITH SELF-CENTERING SCREW



The frontal "V" accurately defines the measuring mechanical axis of the part. The assembly is available in two versions:

- with self-centering screw, for fast and frequent retooling;
- without self-centering screw, for economical part positioning.

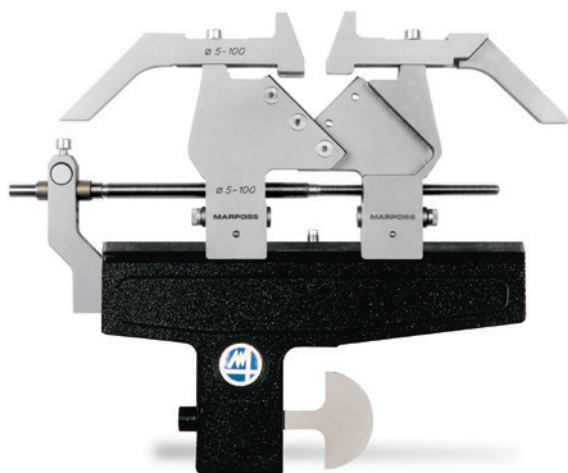
Two assemblies are normally required to support the part.

The assembly is composed of one support bracket and one frontal "V".

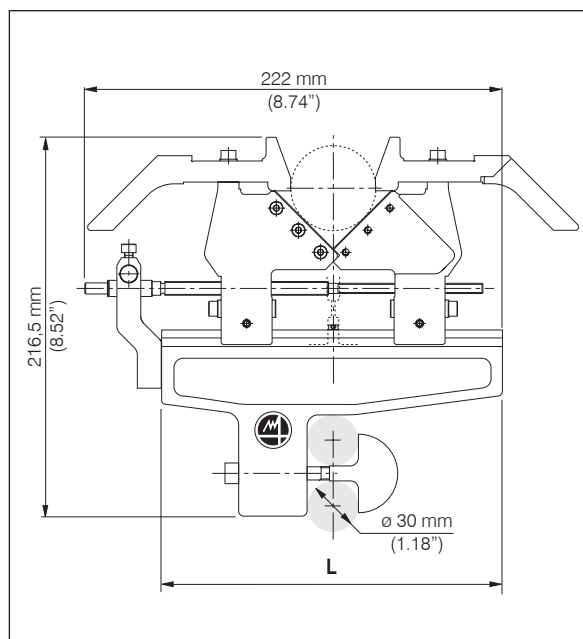
| | SUPPORT BRACKET | | | FRONTAL "V" | | |
|---------------------------------------|-----------------|--------|------------|-------------|---------------|------------|
| | LENGTH L | | ORDER CODE | RANGE | | ORDER CODE |
| | (mm) | (inch) | | (mm) | (inch) | |
| ASSEMBLY WITH SELF-CENTERING SCREW | 200 | 7.87" | 3024017540 | 5 - 10 | .19" - .39" | 3024017633 |
| | | | | 10 - 15 | .39" - .59" | 3024017643 |
| | | | | 15 - 24 | .59" - .94" | 3024017653 |
| | | | | 24 - 40 | .94" - 1.57" | 3024017663 |
| | | | | 40 - 70 | 1.57" - 2.76" | 3024017673 |
| | | | | 55 - 100 | 2.16" - 3.94" | 3024017693 |
| ASSEMBLY WITHOUT SELF-CENTERING SCREW | 200 | 7.87" | 3024017000 | 5 - 10 | .19" - .39" | 3024017632 |
| | | | | 10 - 15 | .39" - .59" | 3024017642 |
| | | | | 15 - 24 | .59" - .94" | 3024017652 |
| | | | | 24 - 40 | .94" - 1.57" | 3024017662 |
| | | | | 40 - 70 | 1.57" - 2.76" | 3024017672 |
| | | | | 55 - 100 | 2.16" - 3.94" | 3024017692 |
| | 250 | 9.84" | 3024017050 | 100 - 150 | 3.94" - 5.91" | 3024017695 |

| DESCRIPTION | ORDER CODE |
|--|------------|
| OPTIONAL GUIDE FOR VEE RANGE 55–100 mm (IT HAS TO BE USED WHEN ONTO THE SAME SUPPORT BRACKET OF THE VEE , TWO SINGLE TRANSMISSIONS ARE ASSEMBLED TO CHECK THE DIAMETER (55–100 mm)) | 2924017695 |

2.2 CROSSED “V” ASSEMBLY



ASSEMBLY WIDTH: 12 mm (.47")
VERSION WITH SELF-CENTERING SCREW



The crossed “V” is used for very frequent retooling and when a large retooling range is needed. The assembly is available in two versions:

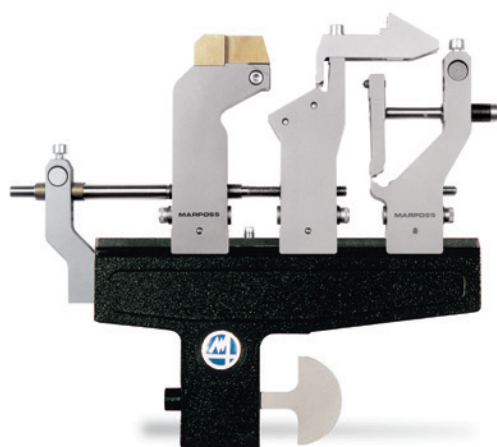
- with self-centering screw, for fast and frequent retooling;
- without self-centering screw, for economical part positioning.

Two assemblies are normally required to support the part.

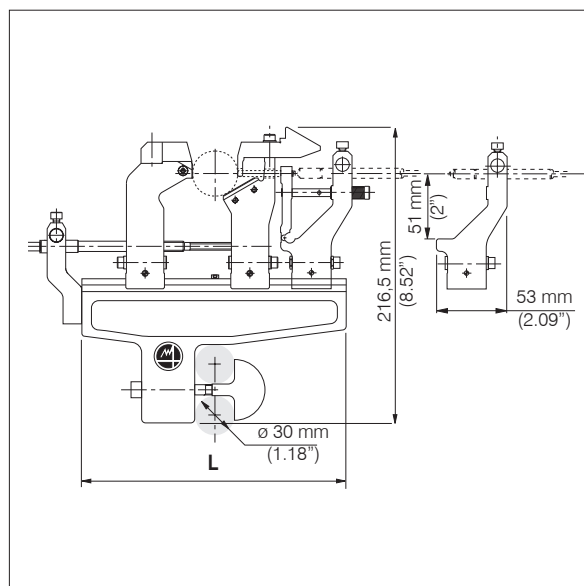
The assembly is composed of one support bracket and one crossed “V”.

| | SUPPORT BRACKET | | | CROSSED “V” | | |
|---|-----------------|--------|------------|-------------|--------------|------------|
| | LENGTH L | | ORDER CODE | RANGE | | ORDER CODE |
| | (mm) | (inch) | | (mm) | (inch) | |
| ASSEMBLY WITH SELF-CENTERING SCREW | 200 | 7.87" | 3024017540 | 5 - 100 | .19" - 3.94" | 3024017553 |
| ASSEMBLY WITHOUT SELF-CENTERING SCREW | 200 | 7.87" | 3024017000 | 5 - 100 | .19" - 3.94" | 3024017552 |

2.3 MEASURING “V” ASSEMBLY



ASSEMBLY WIDTH: 12 mm (.47")
VERSION WITH SELF-CENTERING SCREW



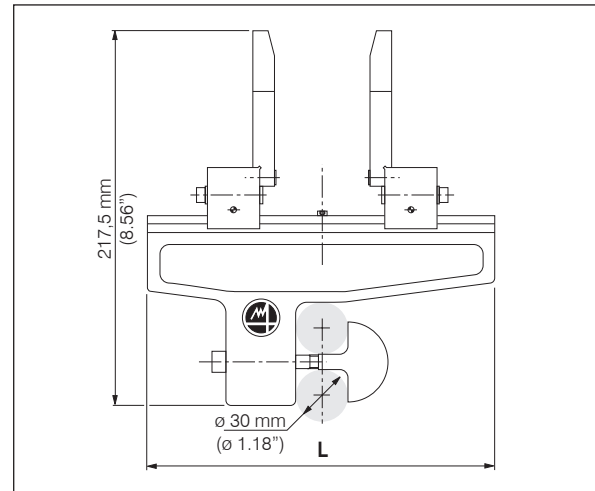
The measuring “V” is used when both part reference and part diameter measurement have to be carried on in the same section. The measurement is performed by using a special contact for measuring “V” mounted on a single transmission unit or on a direct probe unit (see 4.2 CONTACTS FOR MEASURING “V”).

The assembly is composed of one support bracket, one measuring “V”, and one single transmission unit or one direct probe unit. The special contact for measuring “V” and the probe to be mounted in the transmission unit or in the direct probe unit must be ordered separately (see section TRANSDUCERS AND MEASUREMENT TRANSMISSIONS).

| | SUPPORT BRACKET | | | MEASURING “V” | | |
|---|-----------------|--------|------------|---------------|---------------|------------|
| | LENGTH L | | ORDER CODE | RANGE | | ORDER CODE |
| | (mm) | (inch) | | (mm) | (inch) | |
| ASSEMBLY WITH SELF-CENTERING SCREW AND SINGLE TRANSMISSION OR DIRECT PROBE UNIT | 200 | 7.87" | 3024017540 | 5 - 35 | .19" - 1.38" | 3024017524 |
| | | | | 35 - 65 | 1.38" - 2.56" | 3024017526 |
| ASSEMBLY WITHOUT SELF-CENTERING SCREW, WITH SINGLE TRANSMISSION OR DIRECT PROBE UNIT | 200 | 7.87" | 3024017000 | 5 - 35 | .19" - 1.38" | 3024017520 |
| | | | | 35 - 65 | 1.38" - 2.56" | 3024017522 |

| PROBE SUPPORT | CLAMPING Ø FOR PROBE | ORDER CODE |
|--------------------------|----------------------|------------|
| SINGLE TRANSMISSION UNIT | 8 mm | 3024017155 |
| | 3/8" | 3024017157 |
| DIRECT PROBE UNIT | 8 mm | 3024017145 |
| | 3/8" | 3024017147 |

2.4 PART RADIAL LIMITERS ASSEMBLY



The part radial limiters limit the part radial movement and allows correct part introduction in the bench.

Two versions are available:

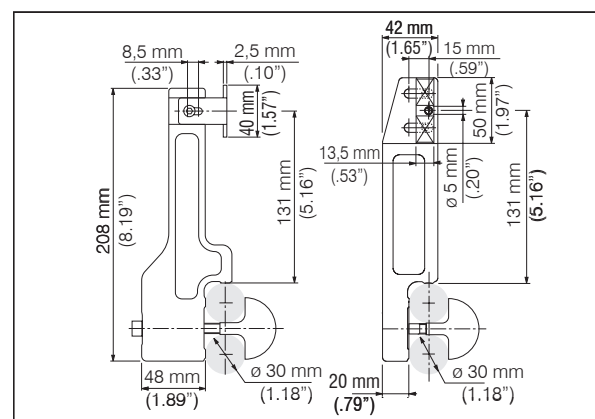
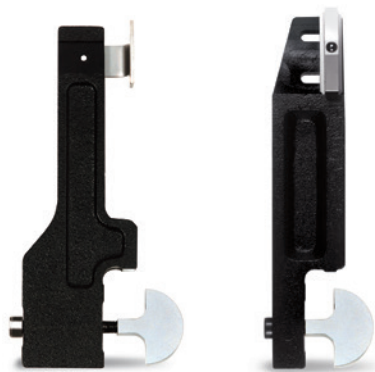
- steel limiter;
- brass limiter for parts with low hardness.

The assembly is composed of one support bracket and one pair of radial limiters.

| ASSEMBLY WITH RADIAL LIMITERS | SUPPORT BRACKET | | |
|----------------------------------|-----------------|------------|------------|
| | LENGTH L | | ORDER CODE |
| | (mm) | (inch) | |
| | 200 | 7.87" | 3024017000 |
| 250 | 9.84" | 3024017050 | |

| DESCRIPTION | ORDER CODE |
|------------------------------|------------|
| STEEL RADIAL LIMITERS (PAIR) | 3024017200 |
| BRASS RADIAL LIMITERS (PAIR) | 3024017210 |

2.5 PART AXIAL LIMITERS



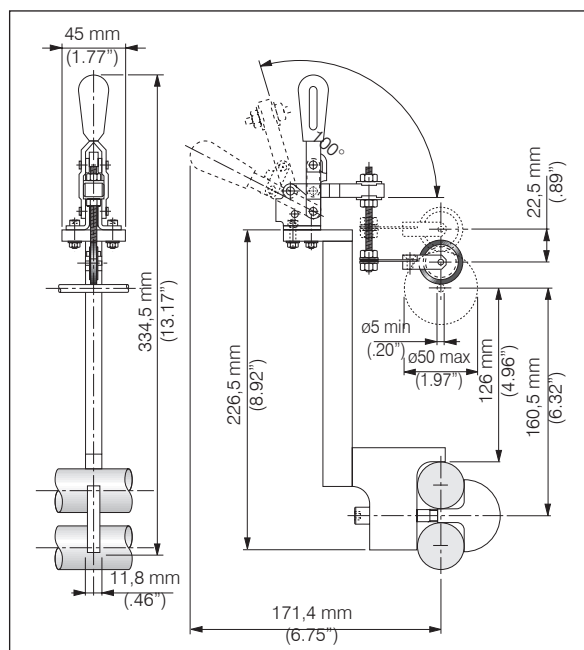
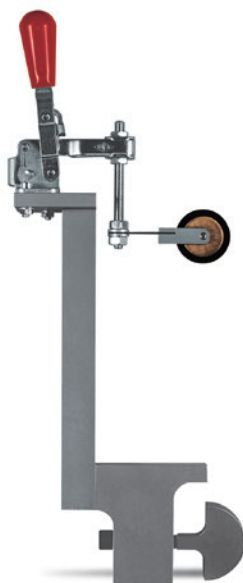
The part axial limiter limits the part axial movement and allows correct part positioning in the bench.

Two versions are available:

- Introducing axial limiter to limit part position;
- Measuring axial limiter used both to limit part position and as mechanical reference for a distance measurement carried on by a shoulder transmission unit (see 3. PART MEASURING ASSEMBLY).

| DESCRIPTION | ORDER CODE |
|---------------------------|------------|
| INTRODUCING AXIAL LIMITER | 3024017214 |
| MEASURING AXIAL LIMITER | 3024017218 |

2.6 PART PUSHER

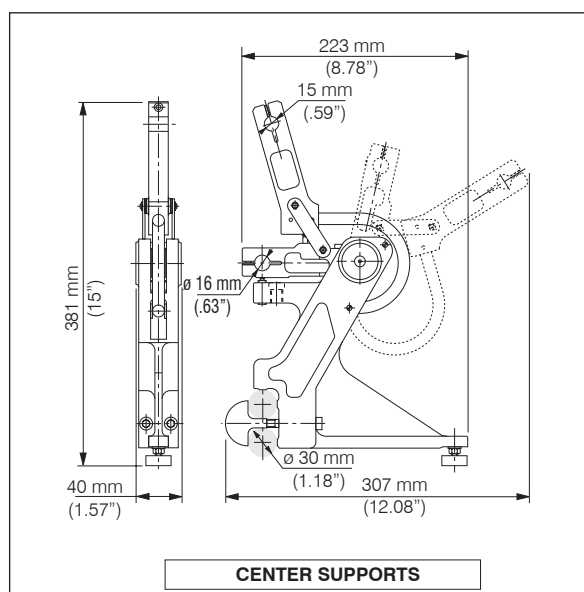


The part pusher guarantees the contact between the part and the “V” supports. It is particularly suitable for parts with weight lower than 200 gr.

- Suitable for part diameters from 5 to 50 mm (.19" - 1.97")

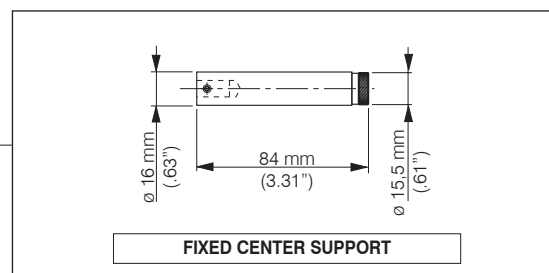
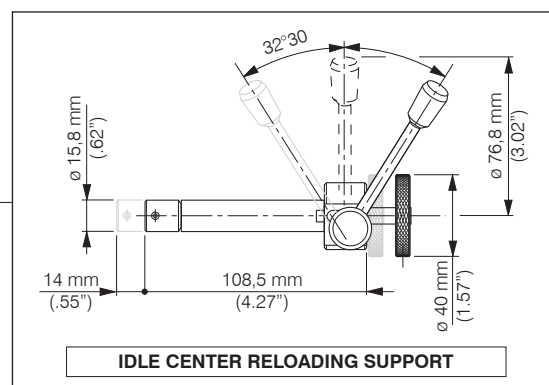
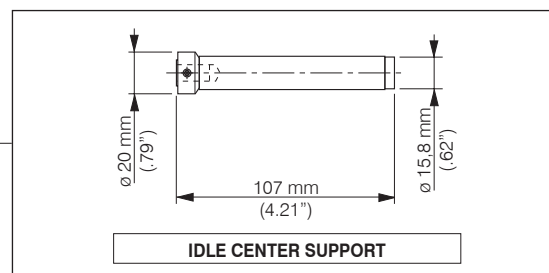
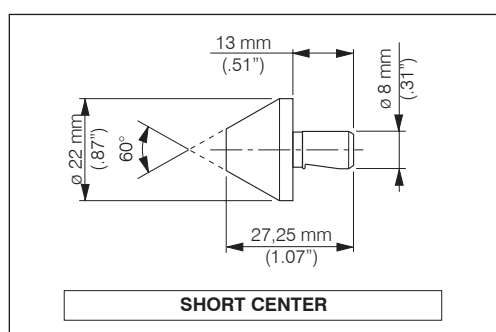
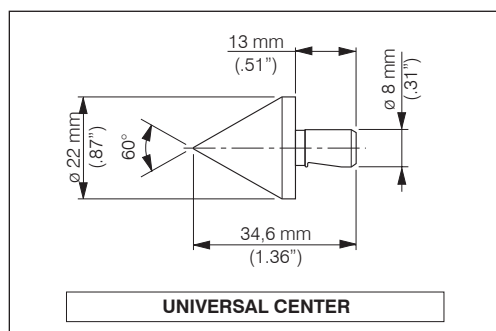
| DESCRIPTION | ORDER CODE |
|-------------|------------|
| PART PUSHER | 3024017980 |

2.7 PIVOTING CENTERS UNIT



This unit is needed when the part to be measured is provided with centers holes. The part is loaded on the centers and then introduced into the measuring station.

It is recommended for small parts [max. part weight 3 kg and max. flywheel overall diameter 170 mm (6.69")]. Dampers are available to avoid impacts during part positioning in the measuring station.



The pivoting centers unit is composed of one pair of center supports and their connecting shaft, whose length depends on the length of the bars of the base structure assembly.

The centers, their supports and the dampers must be ordered separately. To order the base structure assembly see 1. BASE STRUCTURE ASSEMBLY.

| CENTER SUPPORTS (PAIR) | | | | | CONNECTING SHAFT FOR CENTER SUPPORTS | | |
|------------------------|--------|-----------------|--------|------------|--------------------------------------|--------|------------|
| BASE BARS LENGTH L | | MAX PART LENGTH | | ORDER CODE | LENGTH L | | ORDER CODE |
| (mm) | (inch) | (mm) | (inch) | | (mm) | (inch) | |
| 200 | 7.87" | 80 | 3.15" | 3024017355 | 360 | 14.17" | 1024017369 |
| 300 | 11.81" | 180 | 7.08" | | 460 | 18.11" | 1024017371 |
| 400 | 15.75" | 280 | 11.02" | | 560 | 22.04" | 1024017373 |
| 500 | 19.69" | 380 | 14.96" | | 660 | 25.98" | 1024017375 |
| 600 | 23.62" | 480 | 18.89" | | 760 | 29.92" | 1024017377 |
| 800 | 31.50" | 680 | 26.77" | | 960 | 37.79" | 1024017379 |

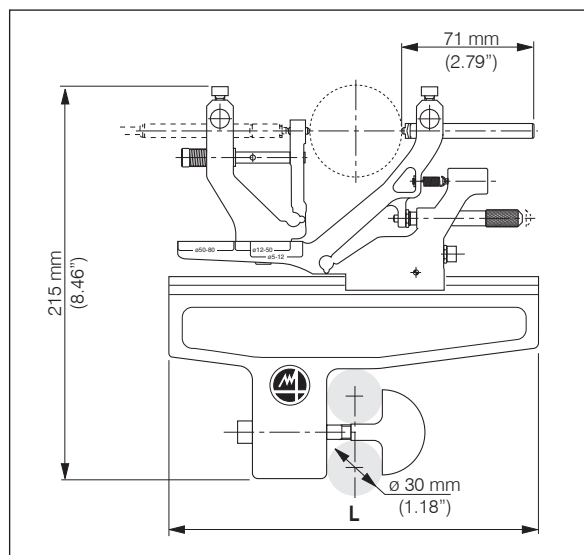
| DESCRIPTION | ORDER CODE |
|------------------------------------|------------|
| FIXED CENTER SUPPORT | 1024017567 |
| IDLE CENTER SUPPORT | 3024017325 |
| IDLE CENTER RELOADING SUPPORT | 3024017315 |
| UNIVERSAL CENTER | 1024017753 |
| SHORT CENTER | 1024017755 |
| DAMPER (FOR MAX. PART WEIGHT 3 kg) | 44331AC108 |

N.B.

WITH THIS UNIT DIAMETER, OVALITY AND DISTANCE MEASUREMENTS ONLY CAN BE CARRIED ON. FOR MEASUREMENTS SUCH AS PERPENDICULARITY, T.I.R., CONCENTRICITY, ETC., THAT ARE REFERRED TO THE CENTERS AXIS, PLEASE CONTACT YOUR NEAREST MARPOSS OFFICE.

3 - PART MEASURING ASSEMBLY

3.1 ASSEMBLY WITH SELF-CENTERING UNIT WITH TRANSMISSION

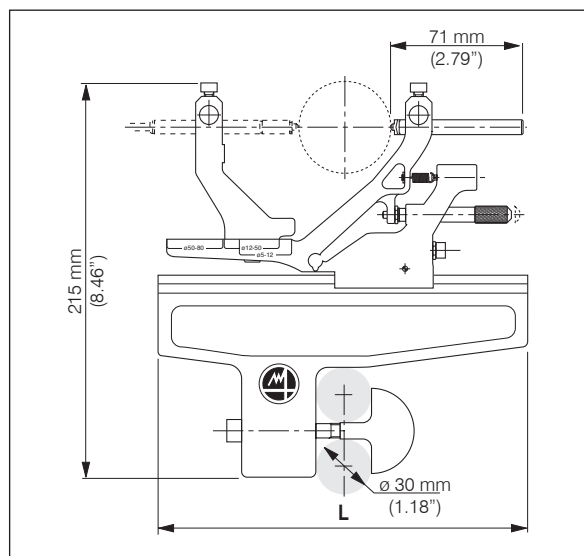


The self-centering unit with transmission is used to carry out diameter measurements only. It can accommodate both pencil probes and dial indicators with diameter 8 mm or 3/8". The probe is not in direct contact with the part and is therefore preserved from radial impact by part loading/unloading.

The assembly is composed of one support bracket and one self-centering unit with transmission. The probe and the two contacts to be mounted on the unit must be ordered separately (see 4. CONTACTS AND ARMSETS and section TRANSDUCERS AND MEASUREMENT TRANSMISSIONS).

| SUPPORT BRACKET | | | SELF-CENTERING UNIT WITH TRANSMISSION | | | |
|-----------------|--------|------------|---------------------------------------|--------------|----------------------|------------|
| LENGTH L | | ORDER CODE | RANGE | | CLAMPING Ø FOR PROBE | ORDER CODE |
| (mm) | (inch) | | (mm) | (inch) | | |
| 200 | 7.87" | 3024017000 | 5 - 80 | .20" - 3.15" | 8 mm | 3024017460 |
| | | | | | 3/8" | 3024017462 |

3.2 ASSEMBLY WITH SELF-CENTERING UNIT WITH DIRECT PROBE



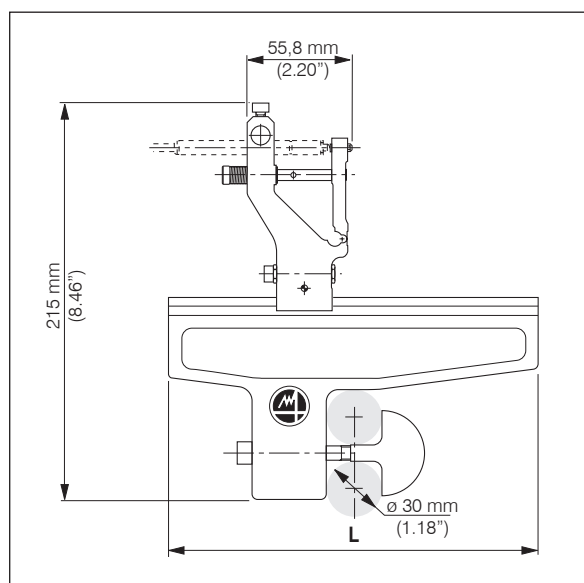
The self-centering unit with direct probe is used to carry out diameter measurements only. It can accommodate both pencil probes and dial indicators with diameter 8 mm or 3/8".

The assembly is composed of one support bracket and one self-centering unit with direct probe. The probe and the contact to be mounted on the unit must be ordered separately (see 4. CONTACTS AND ARMSETS and section TRANSDUCERS AND MEASUREMENT TRANSMISSIONS).

| SUPPORT BRACKET | | | SELF-CENTERING UNIT WITH DIRECT PROBE | | | |
|-----------------|--------|------------|---------------------------------------|--------------|----------------------|------------|
| LENGTH L | | ORDER CODE | RANGE | | CLAMPING Ø FOR PROBE | ORDER CODE |
| (mm) | (inch) | | (mm) | (inch) | | |
| 200 | 7.87" | 3024017000 | 5 - 80 | .20" - 3.15" | 8 mm | 3024017470 |
| | | | | | 3/8" | 3024017472 |

3.3 ASSEMBLY WITH SINGLE TRANSMISSION UNIT

WORKING RANGE OF ONE SINGLE TRANSMISSION UNIT 1.150 mm/.0452"



The single transmission unit is used to carry out both diameter and form measurements. It can accommodate both pencil probes and dial indicators with diameter 8 mm or 3/8". The probe is not in direct contact with the part and is therefore preserved during part loading/unloading.

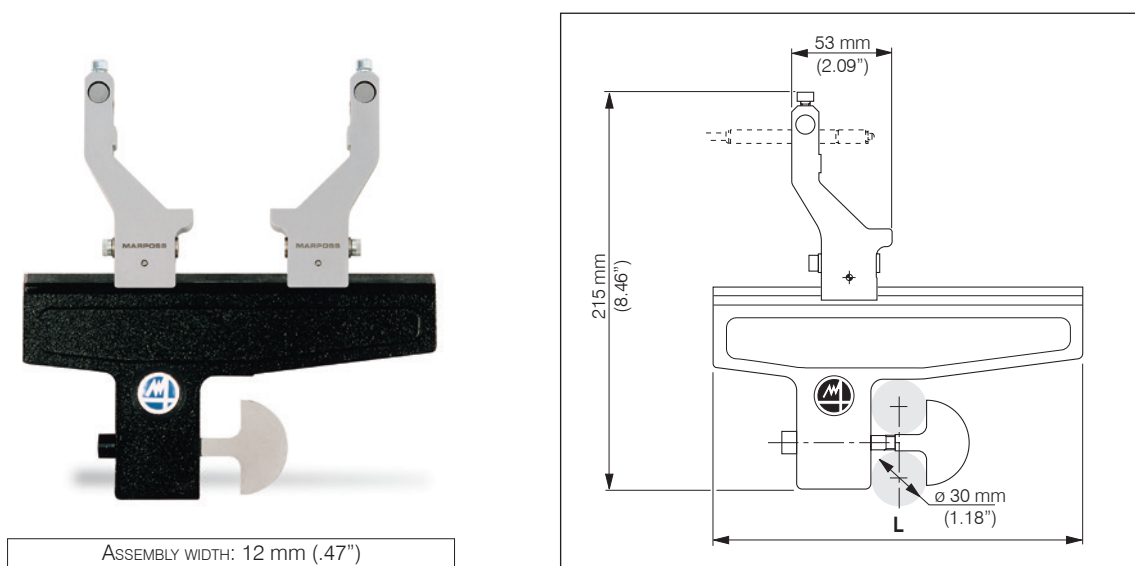
The assembly with only one transmission unit is particularly used for T.I.R. measurements.

The assembly is composed of one support bracket (L=200 mm or 250 mm) and one or two single transmission units. The probe and the contact to be mounted on the unit must be ordered separately (see 4. CONTACTS AND ARMSETS and section TRANSDUCERS AND MEASUREMENT TRANSMISSIONS).

| SUPPORT BRACKET | | | | |
|-----------------|--------|---------|--------------|------------|
| LENGTH L | | RANGE | | ORDER CODE |
| (mm) | (inch) | (mm) | (inch) | |
| 200 | 7.87" | 3 - 118 | .12" - 4.64" | 3024017000 |
| 250 | 9.84" | 3 - 160 | .12" - 6.30" | 3024017050 |

| PROBE SUPPORT | CLAMPING Ø FOR PROBE | ORDER CODE |
|--------------------------|----------------------|------------|
| SINGLE TRANSMISSION UNIT | 8 mm | 3024017155 |
| | 3/8" | 3024017157 |

3.4 ASSEMBLY WITH DIRECT PROBE UNIT



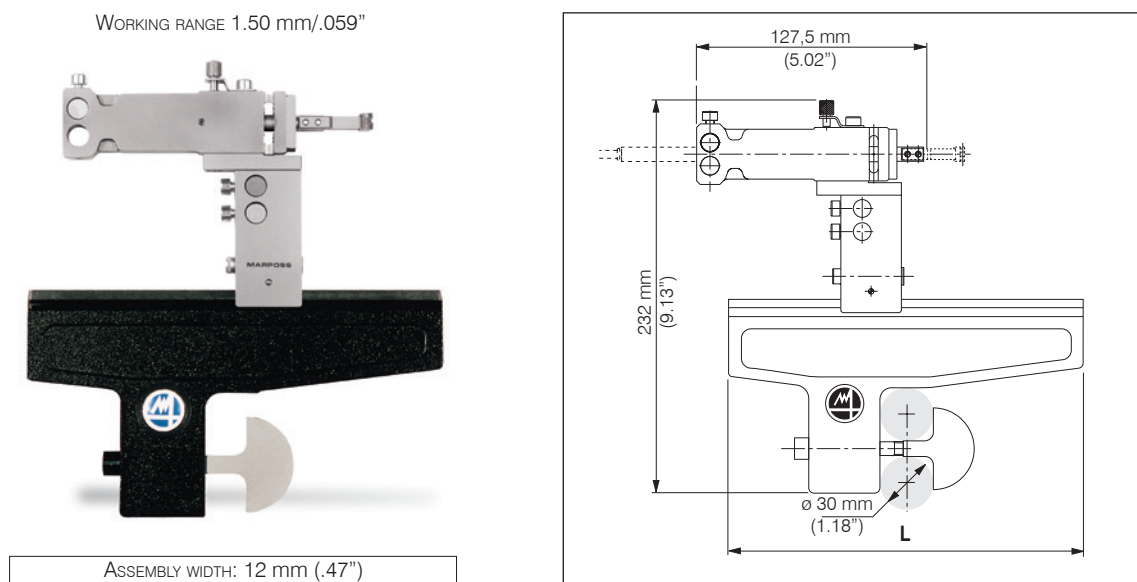
The direct probe unit is used to carry out both diameter and form measurements. It can accommodate both pencil probes and dial indicators with diameter 8 mm or 3/8".

The assembly is composed of one support bracket (L=200 mm or 250 mm) and one or two direct probe units. The probe to be mounted on the unit must be ordered separately (see section TRANSDUCERS AND MEASUREMENT TRANSMISSIONS).

| SUPPORT BRACKET | | | | |
|-----------------|--------|---------|--------------|------------|
| LENGTH L | | RANGE | | ORDER CODE |
| (mm) | (inch) | (mm) | (inch) | |
| 200 | 7.87" | 3 - 118 | .12" - 4.64" | 3024017000 |
| 250 | 9.84" | 3 - 160 | .12" - 6.30" | 3024017050 |

| PROBE SUPPORT | CLAMPING Ø FOR PROBE | ORDER CODE |
|-------------------|----------------------|------------|
| DIRECT PROBE UNIT | 8 mm | 3024017145 |
| | 3/8" | 3024017147 |

3.5 ASSEMBLY WITH SHOULDER TRANSMISSION UNIT



To carry out distance measurements. It can accommodate both pencil probes and dial indicators with diameter 8 mm or 3/8". The probe is not in direct contact with the part and is therefore preserved during part loading/unloading. Distance measurements can be carried out by using two assemblies or one assembly and a measuring axial limiter.

The assembly is composed of one support bracket and one shoulder transmission unit. The armset and the contact to be mounted on the unit must be ordered separately (see 4. CONTACT AND ARMSETS).

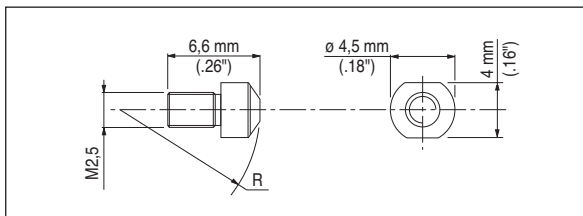
| SUPPORT BRACKET | | |
|-----------------|--------|------------|
| LENGTH L | | ORDER CODE |
| (mm) | (inch) | |
| 200 | 7.87" | 3024017000 |
| 250 | 9.84" | 3024017050 |

| CLAMPING Ø FOR PROBE | | ORDER CODE |
|----------------------------|------|------------|
| SHOULDER TRANSMISSION UNIT | 8 mm | 3024017330 |
| | 3/8" | 3024017331 |

4 - CONTACTS AND ARMSETS

All contacts and extensions to be fitted on Quick Set components must be M 2,5. Contacts 4-48 UNF are listed as accessory to 3/8" pencil probes and dial indicators.

4.1 STANDARD CONTACTS

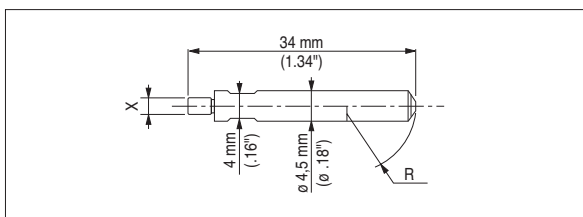


To be used with:

- Self - centering unit with transmission (Q.ty = 2)
- Self - centering unit with direct probe (Q.ty = 1)
- Single transmission unit (Q.ty = 1)

| RADIUS R | | MATERIAL | ORDER CODE |
|----------|--------|----------|------------|
| (mm) | (inch) | | |
| 10 | .39" | CARBIDE | 3392401702 |
| 50 | 1.97" | CARBIDE | 3392401705 |
| 100 | 3.94" | CARBIDE | 3392401706 |
| 10 | .39" | DIAMOND | 3392401722 |
| 50 | 1.97" | DIAMOND | 3392401725 |
| 100 | 3.94" | DIAMOND | 3392401726 |

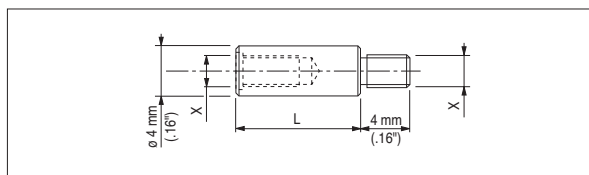
4.2 CONTACTS FOR MEASURING "V"



Special carbide contact to be mounted on the single transmission unit or directly on the probe.

| RADIUS R | | THREAD X | ORDER CODE |
|----------|--------|----------|------------|
| (mm) | (inch) | | |
| 10 | .39" | M 2,5 | 3392401701 |
| 50 | 1.97" | M 2,5 | 3392401720 |
| 100 | 3.94" | M 2,5 | 3392401721 |

4.3 CONTACT EXTENSIONS



Available with thread M 2.5 or 4-48 UNF. It can be used:

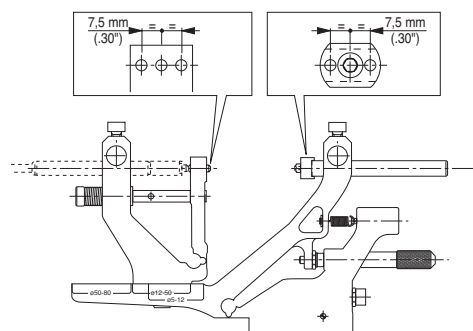
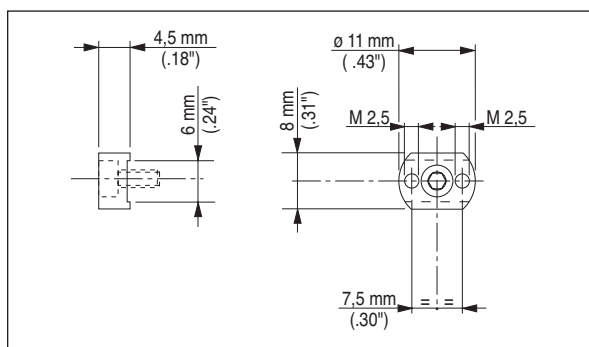
- With self-centering unit
- With single transmission unit
- With direct probe unit
- With dial indicators

| L | | THREAD X | ORDER CODE |
|------|--------|------------|------------|
| (mm) | (inch) | | |
| 10 | .39" | M 2.5 | 1024017105 |
| 15 | .59" | M 2.5 | 1024017106 |
| 20 | .79" | M 2.5 | 1024017107 |
| 25 | .98" | M 2.5 | 1024017108 |
| 30 | 1.18" | M 2.5 | 1024017109 |
| 10 | .39" | 4 - 48 UNF | 1024017115 |
| 15 | .59" | 4 - 48 UNF | 1024017116 |
| 20 | .79" | 4 - 48 UNF | 1024017117 |
| 25 | .98" | 4 - 48 UNF | 1024017118 |
| 30 | 1.18" | 4 - 48 UNF | 1024017119 |

4.4 OFF-SET ARMS

4.4.1 ARMSET FOR SELF-CENTERING UNIT WITH TRANSMISSION

It is needed to carry on measurements very close to each other and close to a shoulder (min. 3 mm) by offsetting the contact.

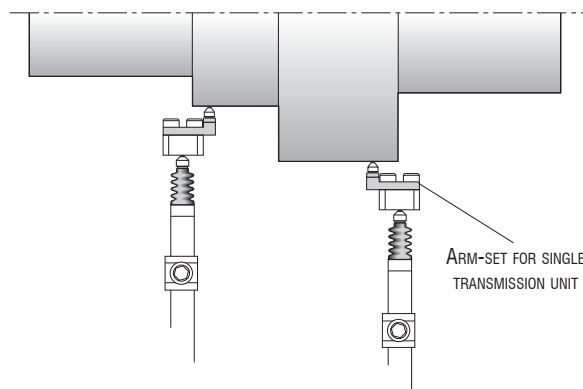
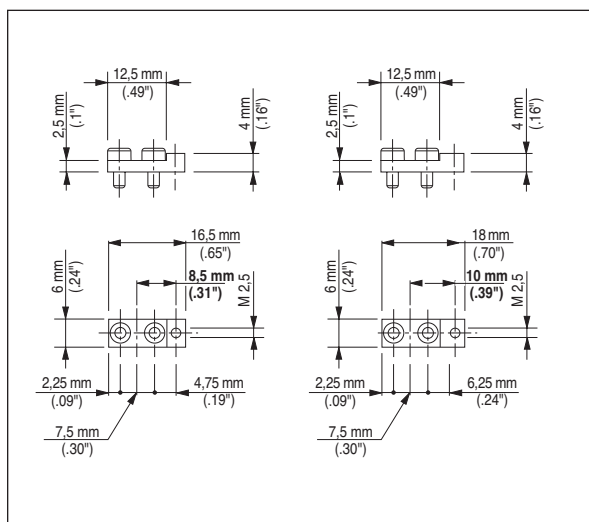


MIN. DISTANCE BETWEEN TWO MEASURING SECTIONS: 5,2 mm

| ARMSET + FIXING SCREW | ORDER CODE |
|-----------------------|------------|
| | 2924017405 |

4.4.2 ARMSET FOR SINGLE TRANSMISSION UNIT

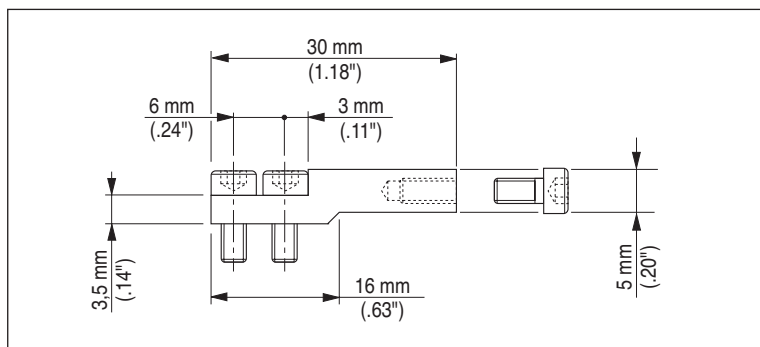
For contact off-set when measurements close to each other must be carried on.



MIN. DISTANCE BETWEEN TWO MEASURING SECTIONS: 5,2 mm

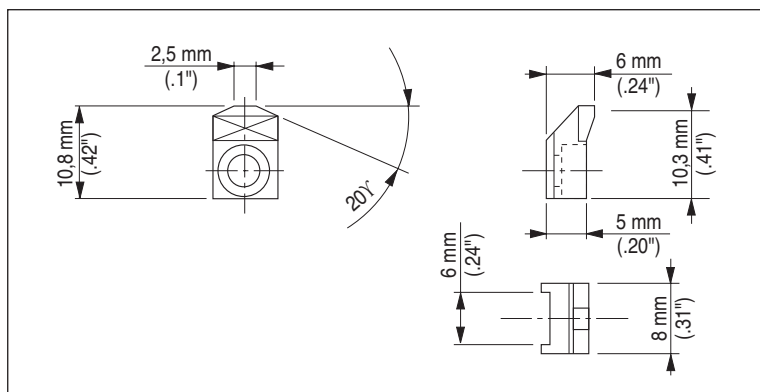
| ARMSET + FIXING SCREW | OFF-SET L | | ORDER CODE |
|-----------------------|-----------|--------------|------------|
| | (mm) | (inch) | |
| | 8.5 10 | .33" .39" | |

4.5 CONTACTS AND ARMSETS FOR SHOULDER TRANSMISSION UNIT



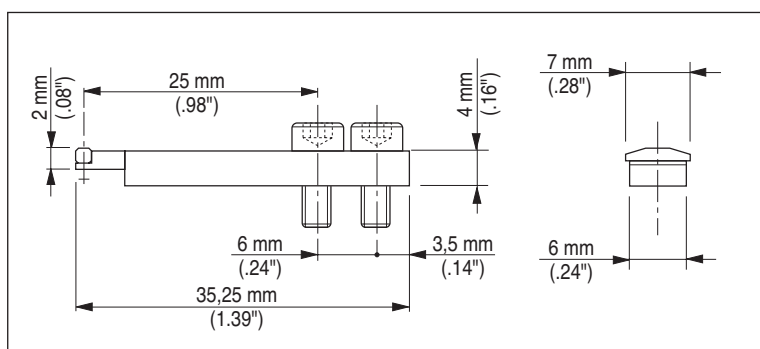
ARMSET

It is the interface for the mounting of the contact on the unit.



CONTACT

Available with carbide or diamond tip.



ARMSET FOR GROOVES

It is equipped with a carbide contact and must be directly mounted on the unit

| DESCRIPTION | ORDER CODE |
|--------------------|------------|
| ARMSET | 2924017302 |
| CARBIDE CONTACT | 3292401702 |
| DIAMOND CONTACT | 3292401712 |
| ARMSET FOR GROOVES | 3292401705 |

5 - WRENCH SET



For bench assembly and set-up.

| DESCRIPTION | ORDER CODE |
|-------------|------------|
| WRENCH SET | 2924017990 |

For a full list of address locations, please consult the Marposs official website

Edition 08/2018 - Specifications are subject to modifications © Copyright 2018 MARPOSS S.p.A. (Italy) - All rights reserved.

MARPOSS, logo and Marposs product names/signs mentioned or shown herein are registered trademarks or trademarks of Marposs in the United States and other countries. The rights, if any, of third parties on trademarks or registered trademarks mentioned in the present publication are acknowledged to the respective owners.

Marposs has an integrated system to manage the Company quality, the environment and safety, attested by ISO 9001, ISO 14001 and OHSAS 18001 certifications.

Some models of the product line, or parts of them, may be subject to export restrictions if exported outside the European Union or may be subject to restrictive measures adopted by the competent national, supranational or international authorities.