Ürün bilgileri

Ayar cihazı Multimar 844 S



Ürün özellikleri

- Sabitleme parçası ile kolay kullanım
- Gösterge bloku kombinasyonlarını kullanarak doğru nominal değer ayarı
- Yatay veya dikey konumda alet ayarı (844 Sf tabanını kullanarak)
- Üretimde veya muayene odasında mobil veya sabit kullanım için anotlanmış alüminyumdan yapılmış sert taban

Uygulama

Gösterge blok kombinasyonlarını kullanarak iç ve dış boyutlar için gösterge aletlerini, diğer bir deyişle Multimar 844 T ve Marameter 844 N'yi herhangi bir boyutta ayarlamak için.

Malzeme no.: **4503500**

Teknik veriler

Dış uygulama aralığı	40 - 400
İç uygulama aralığı	0 - 360

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Malzeme no.: **4503501**

Teknik veriler

Dış uygulama aralığı	40 - 1150
İç uygulama aralığı	0 - 1110

Ürün bilgileri

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- Sabitleme parçası ile kolay kullanım
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- Yatay veya dikey konumda alet ayarı (844 Sf tabanını kullanarak)
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Uygulama

Gösterge blok kombinasyonlarını kullanarak iç ve dış boyutlar için gösterge aletlerini, diğer bir deyişle Multimar 844 T ve Marameter 844 N'yi herhangi bir boyutta ayarlamak için.

Malzeme no.: **4503502**

Teknik veriler

Dış uygulama aralığı	40 - 2180
İç uygulama aralığı	0 - 2140

Mahr

Setting instrument



Multimar 844 S

Operating instructions

3722643

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CE

Dear customer,

Thank you for choosing a product by Mahr GmbH. We kindly request that you follow the instructions below to ensure the long-term precision of your instrument.
We operate a policy of continuous improvement and are constantly developing our products. Therefore, it is possible that there may be slight differences between the text and illustrations in this document and the instrument in your possession, especially with regard to type designations. We reserve the right to make changes to the design and scope of supply, the right to undertake further technical developments, and all rights relating to translation of this documentation.

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The following symbols are used in these operating instructions:

General information

Caution

Caution, hazard

Failure to follow instructions marked with this symbol may lead to inaccurate results and cause damage to equipment.

1. Introduction

Intended use

The 844 S setting instrument is used to adjust the length measurements in production, quality control and in the workshop.

Intended use is subject to compliance with all published information relating to this product. Any other use is not in accordance with the intended use. The manufacturer accepts no liability for damages resulting from improper use. All statutory and other regulations and guidelines applicable to the area of use must be observed.

The operating, maintenance and repair information detailed in these operating instructions must be followed.

To get the most out of this measuring instrument, you should read the operating instructions prior to commissioning the instrument.

2. Delivery of the 844 S setting instrument includes:

- Light alloy bar with gage block holder
- Operating instructions

3. Important information prior to commissioning the setting instrument

- To guarantee your setting instrument for extended use, use a dry cloth to remove any dirt from the instrument following use. Then use oil to preserve the metal clamping elements.
- Use a soft, dry cloth to clean dirty instrument following use. Wipe the instrument with a damp cloth if it is extremely dirty. Avoid volatile organic solvents such as thinners as these liquids may damage the device.
- Warranty claims are void if the device is dismantled.

We wish you all the best with your new setting instrument. Please do not hesitate to contact our technical consultants should you have any questions.

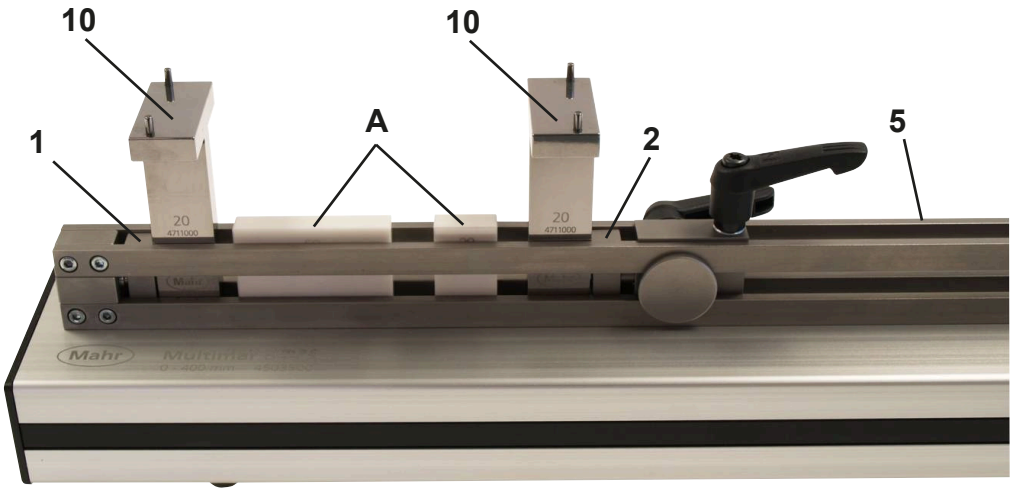
Confirmation of traceability

We declare, with sole responsibility, that this product conforms to the standards and technical data as specified in our sales documents (operating instructions, leaflet, catalog).
We certify that the testing equipment used to check this product, and guaranteed by our quality assurance system, is traceable to national standards.
Thank you for placing your trust in us by purchasing this product.

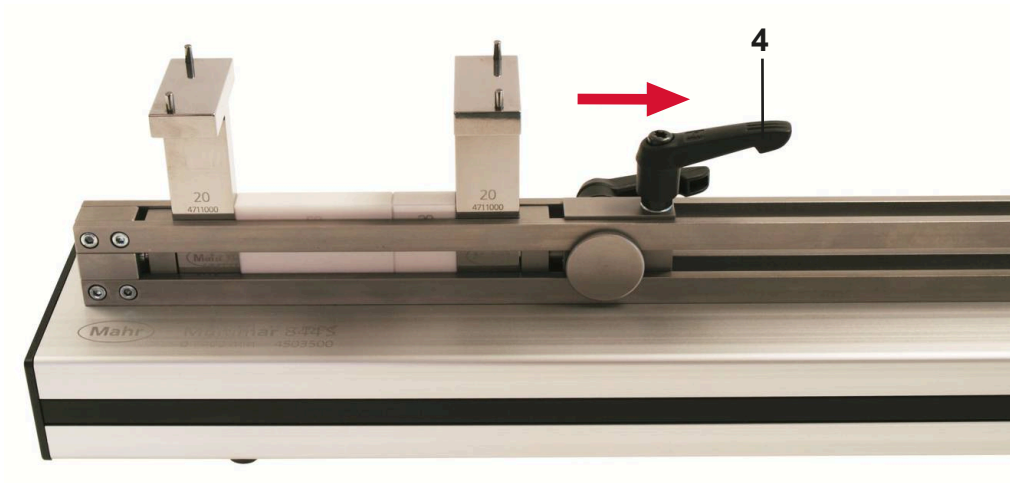
	Description	Dimensions	Use for:	Quantity unit	Order no.
	T-parallel jaw to position and precisely set the Multimar for outer and inner dimensions	Width 20.000 mm ±1 µm Height 75 mm Contact area 32 mm	Measuring arm pairs 844 Tma, 844 Tmi, 844 Tms, 844 Te with 844 Tw	Pair	**4503510**
	Spacers to raise the T-parallel jaw when using long measuring arms 844 Te, 844 Tms	Height 30 mm Contact area 32 mm	Long measuring arm pairs 844 Te Required quantity: 844 Te L 70 mm = 1 pair 844 Te, 844 Tms L 100 mm = 2 pairs	Pair	**4503511**
	Setting bridge to support the 844 N centering bridge	L x W 70 x 12 mm	844 N Measuring range 18 - 250 mm	Unit	**4474080**
	Setting bridge to support the 844 N centering bridge	L x W 165 x 17 mm	844 N Measuring range 18 - 400 mm	Unit	**4474081**
	Setting bridge to support the 844 N centering bridge	L x W 320 x 20 mm	844 N Measuring range 18 - 800 mm	Unit	**4474082**
	Flat measuring jaw to support the fixed measuring pin of the 844 T	L x W x H 60 x 9 x 9.5 mm	844 N Measuring range 18 - 800 mm	Unit	**4470095**
	Heavy steel base plate, to adjust the vertical position of the 844 S setting instrument	L x W x H 200 x 200 x 25 mm Weight 7.5 kg	844 S, 4503500 0 - 400 mm 844 S, 4503501 0 - 1150 mm	Unit	**4503512**

7. Setup of the 844 S setting instrument using the example of a Multimar 844 T:

7.1 Insert the parallel jaws**10** and gage block combination **A** into the gage block holder **5** between the two clamping elements **1** and **2**



7.2 Put the tension lever for the eccentric clamp **4** in the middle position to pull back the mobile gage block clamping element



8. Setting dimensional references

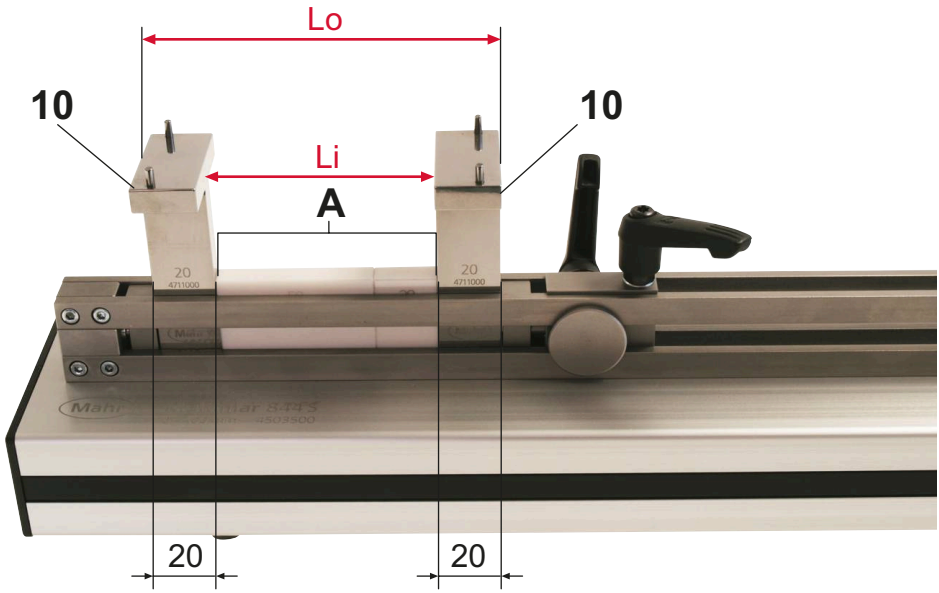
8.1 Setup for a Multimar 844 T

Required accessories:
- 844 Sp parallel jaw **10** in T-shape
- Gage block combination **A** (in accordance with the reference dimension)
- 844 Sph Spacers **11** (for long jaws starting at 70 mm)
- 844 Sf Base plate **12** for vertical use (if necessary)

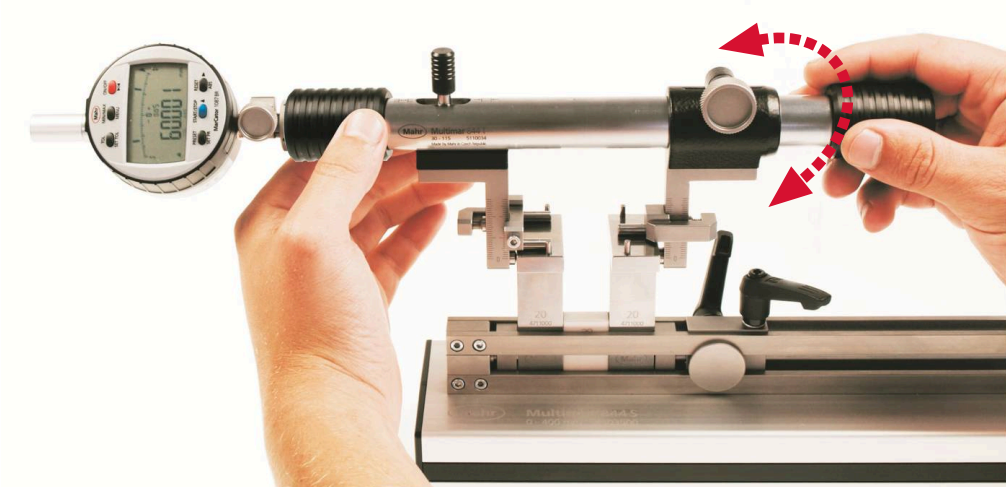
⚠ **Handle the 844 Sf base plate carefully due to its heavy weight (7.5 kg)!**
We recommend using the included table clamps to attach the base plate to the measuring station.

Setting up a dimensional reference Lo for outer measurement:
Dimensional reference Lo = gage block combination (Li) + 844 Sp (2 x 20 mm)

Setting up a dimensional reference Li for inner measurement:
Dimensional reference Li = gage block combination between T-parallel jaws



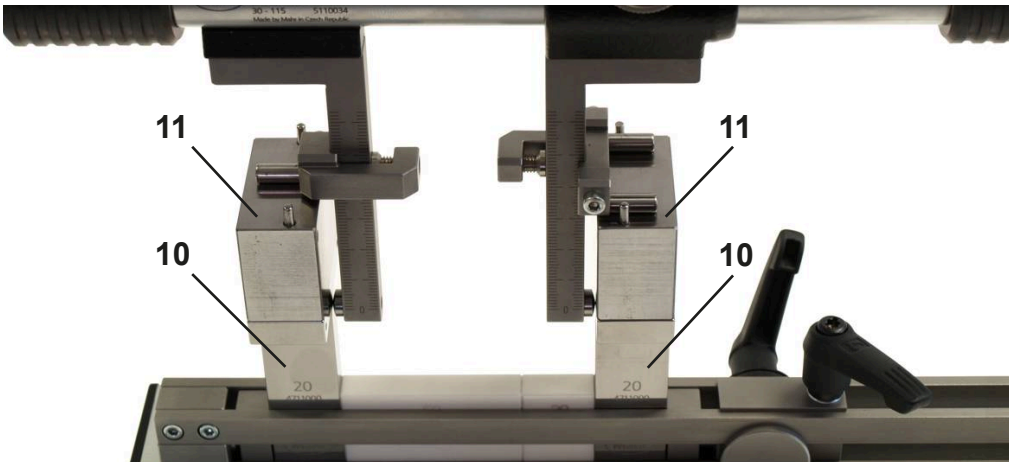
8.2.3 Setting the display unit by determining the reversing point (MIN or MAX) by swiveling the Multimar 844 T



8.3 Setting the Multimar 844 T with long measuring arms

When using long measuring arms, 844 Sph spacers **11** are used on the 844 Sp parallel jaws **10** to increase the measuring depth.

- 1 pair of 844 Sph **11** is required for 70 mm measuring arms.
- 2 pairs of 844 Sph **11** are used for measuring arms of 100 mm in length. Two spacers stacked on top of one another are used for each side.



8.5 Setting a MaraMeter 844 N

The display unit (dial comparator or dial gage) is set by determining the reversing point (MIN value) by swiveling the MaraMeter 844 N between the measuring surfaces of 844 Neb **13** and 844 em **14**.



8.6 Setting in proper position provides maximum measuring accuracy

The **Multimar 844 S** setting instrument can be equipped with the optional **844 Sf** base plate. This allows the **Multimar 844 S** to be used in a vertical position as well.
To achieve maximum measuring accuracy, a comparative measuring instrument should be set in the same position and measurement in or on the work piece should occur.

Example: A precise hole in a turned part should be measured in the lathe with a 844 N bore gage. To do this, the 844 N bore gage must be inserted horizontally. It is in exactly this horizontal position that the 844 N bore gage is to be previously calibrated.

Please note:

! When setting the **Multimar 844 S** setting instrument in the vertical position, it is recommended that the fixed measuring contact be placed on the lower parallel jaw. This way, the dead weight of the measuring instrument is supported by the lower parallel jaw and not by the movable, spring-mounted, probe.

