

## J. SUBITO® ST for pillow block bores, grooves and recesses

This measuring instrument has been developed especially for the determination of internal diameters, where a smaller bore lying in front of this diameter, has to be passed. Furthermore it serves for the measurement of grooves and undercuts, also in high measuring depths (up to 2000 mm). A measuring pin rotatable by 180° makes this possible, which is lying parallel to the centring plate during the passing of the small bore d1 and is rotated around a connection link for the measurement of the larger diameter d2. The ST instrument is distinguished by a considerable retraction travel of up to 40 % of the diameter d2. The range of application of the ST instrument is from 30 up to 530 mm for the diameter d2. Because of the subdivision of the range of application into seven instrument sizes, a good centring in the bore to be measured and therefore a high measuring certainty is ensured. The exact bore diameter is determined by oscillating the measuring instrument. The measuring principle of the ST instrument is based on the SUBITO® deviation, which ensures a high precision. The calibration of the instrument is effected with the fixed measuring pin swung out, by means of a master setting ring or the setting device ESU with special setting jaws for the ST series.

### technical data ST

range of application 50 - 220 mm  
 repeatability  $f_w \leq 1 \mu\text{m}$   
 max. deviation  $f_e \leq 2 \mu\text{m}$   
 hysteresis  $f_u \leq 2,5 \mu\text{m}$

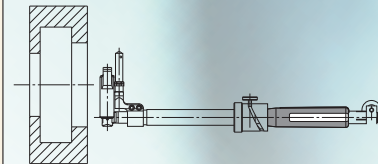
range of application 180 - 530 mm  
 repeatability  $f_w \leq 1,5 \mu\text{m}$   
 max. deviation  $f_e \leq 3 \mu\text{m}$   
 hysteresis  $f_u \leq 3,5 \mu\text{m}$

### SELECTION CRITERIA FOR SUBITO® ST

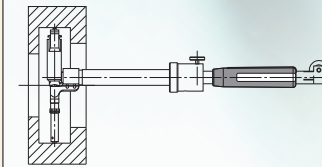
Range of application D	mm	mm	mm	mm	mm	mm	mm
from	30	50	60	80	120	180	290
up to	52	70	100	150	220	360	530
travel s	1,3	1,3	1,4	1,4	1,4	1,6	1,6
measuring depth MT	60	60	60	95	107	148	170
total length L	194	208	209	243	270	343	409
tube Ø R	12	12	14	14	15,3	22	28
centring plate width ZB	-	19,5	29,5	39	63	98	155
front distance h	4,25	5,25	7	7	8	12	15
centring plate height ZH	-	6	8	8	10	12	18
no. of measuring pins	6	5	8	7	7	6	6
no. of increment washers	2	3	3	3	3	4	4
extension S	12	-	-	(1)35	(2)35	(2)60	(3)60



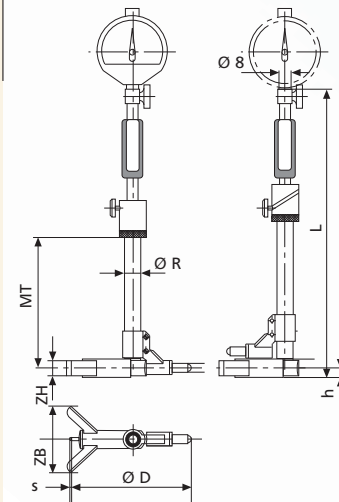
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inserting



measuring



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