

# OPERATING INSTRUCTIONS

## IKT INTERNAL TAPER GAUGES

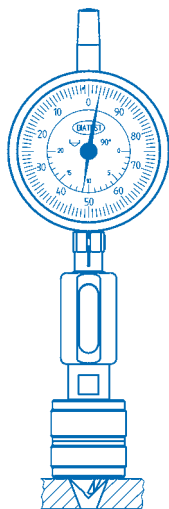


Fig. 1

### General:

Avoid impulsive impact to plunger to prevent damage to indicator mechanism. Apply equal pressure to surface plate against work-piece, in order to prevent damage to the probe

**Please note: IKT dial indicators have a special transmission ratio! When not in use, keep plunger greased or otherwise suitable protected against corrosion.**

### Measuring process: Fig. 1

Insert taper gauge into the internal taper. Press surface plate against work-piece. Read largest  $\varnothing$  of internal taper directly on dial indicator (e.g. Fig. 1  $\varnothing$  is 10,97 mm).

### Zero-setting:

The IKT has been adjusted at the factory to zero and the adjustment reading is marked on the back of the indicator.

### Checking for zero setting: Fig. 2

To verify setting, place gauge upright on a surface plate. Dial reading should then correspond to figure on indicator back (e.g. Fig. 2 setting size is 0,22 mm). If necessary move dial gauge in clamping bore  $\varnothing$  8 H 7. For IKT60-1, IKT90-1 and IKT127-1 a setting master is available.

**Please note:** Graduated collar is secured against twisting. For IKT size 1 setting size might change due to wear at taper tip.

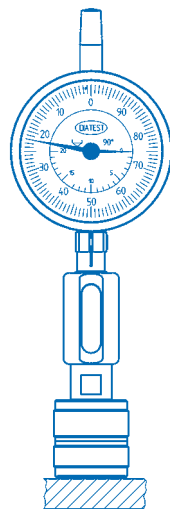
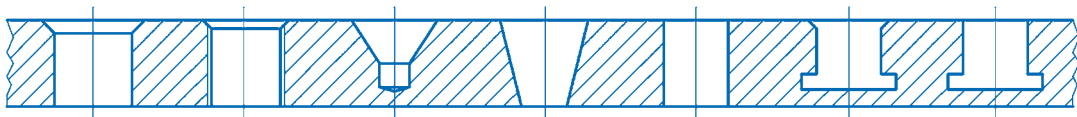


Fig. 2



Some examples for IKT-applications

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Order Code	Taper	Range mm
* IKT90-1	90°	0,5 - 20
IKT90-1-2	90°	10 - 30
IKT90-2	90°	20 - 40
IKT90-3	90°	40 - 60
IKT90-4	90°	60 - 80
IKT90-5	90°	80 - 100
IKT90-6	90°	100 - 120
IKT90-1-OS	90°	0,5 - 20
IKT90-2-OS	90°	20 - 40
		Range inch
IKT90-Z-1	90°	.02 - .8
IKT90-Z-2	90°	.8 - 1.6
IKT90-Z-3	90°	1.6 - 2.4
IKT90-Z-4	90°	2.4 - 3.2

Order Code	Taper	Range mm
* IKT60-1	60°	0,5 - 12
IKT60-2	60°	10 - 21
IKT60-3	60°	20 - 31
IKT60-4	60°	30 - 41
IKT60-5	60°	40 - 51
IKT60-6	60°	50 - 61
IKT60-7	60°	60 - 71
IKT60-8	60°	70 - 81
IKT60-9	60°	80 - 91
IKT60-10	60°	90 - 101
IKT60-11	60°	100 - 111
IKT60-12	60°	110 - 121
IKT60-1-OS	60°	0,5 - 12
IKT60-2-OS	60°	10 - 21
* IKT127-1	127°	0,5 - 20
IKT127-2	127°	20 - 40
IKT127-3	127°	40 - 60
IKT127-4	127°	60 - 80
IKT127-5	127°	80 - 100
IKT127-6	127°	100 - 120
* IKT127-1-OS	127°	0,5 - 20

\*Setting master order code: IKT60-1-EM (Ø 8,0),  
IKT90-1-EM (Ø 10,0), IKT127-1-EM (Ø 12,0).

Other setting masters on request.

IKT gauges are also available with digital indicator (MUM1086W)  
as an option.