

# Installation manual for measuring tables DIATEST-System COME



This manual is valid for all versions C2, C2-AL and C2-JS as well as C3, C3-AL and C3 JS. Installation is shown based on measuring table DIA-COME C2, but this manual can be used the same way for other measuring tables!

### Installation of dial indicator

For most of dial indicators, an extension of measuring pin is necessary. In most cases, the included extension for dial indicators (MUZ) with length L=20mm (MUZ20) is sufficient. It has to be checked in function of dial indicator, if an extension (MUZ) is necessary or not. Dial indicator extensions with other lengths can be supplied by DIATEST.

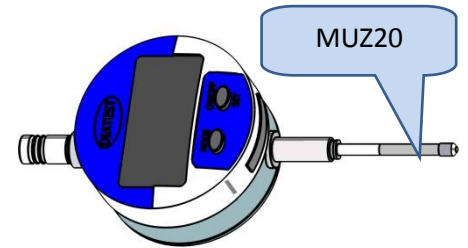


Fig. 1: dial indicator with MUZ20

**Advice:** clamping of mobile measuring insert No. 4 by clamping screw Nr. 5 is only possible if dial indicator is not mounted into the holder.

We would recommend to use an indicator for measuring outside diameters!

### Setting of measuring direction and measuring force

By turning the setting wheel (Nr. 13) you can adjust on one hand the measuring direction and on the other hand the measuring pressure continuously. The more you turn the setting wheel to the left or to the right, the more the measuring force increases. Especially for thin-walled pieces, please ensure a correct setting. If requested measuring direction and force are set, lock the setting wheel by clamping screw (Nr. 14).

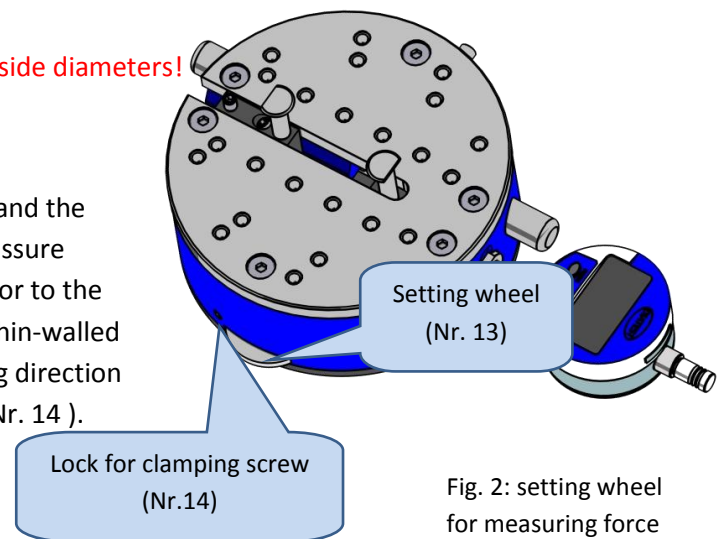


Fig. 2: setting wheel for measuring force

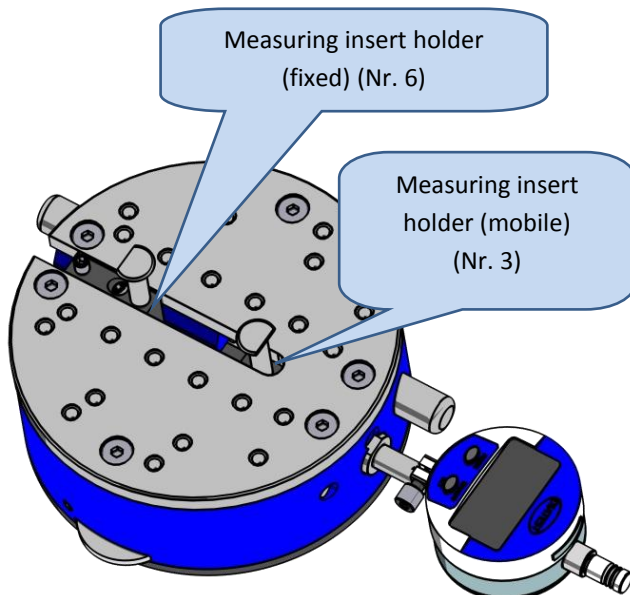


Abb. 3: Messeinsatzhalter

### Installation of measuring inserts

Make sure that alignment and height are correct by installing the inserts (Nr. 4 and Nr.7). One of the measuring inserts (Nr. 7) will be mounted on the fixed insert holder (Nr. 6), the other (Nr. 4) on the mobile insert holder (Nr. 3).

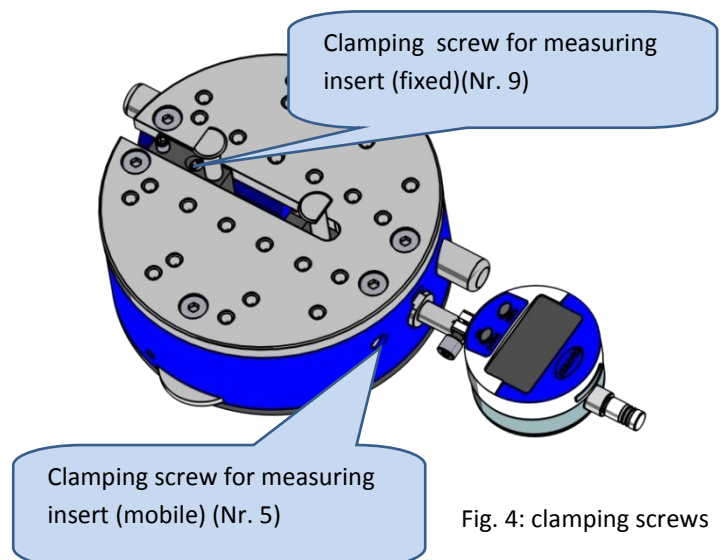


Fig. 4: clamping screws

Both of clamping screws (Nr. 5 and Nr. 9) have to be tightened to lock the measuring inserts.

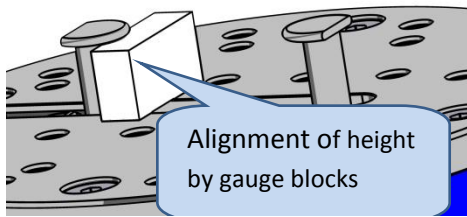


Fig. 5: Alignment of height of measuring inserts

To align heights of measuring inserts, you can use gauge blocks for instance.

### Adaptation of measuring inserts and stroke

A setting master is the most appropriate gauge for correct adaptation of distance between measuring inserts and measuring stroke.

To adjust the distance, release the clamping screw (Nr. 8) for fixed measuring insert (Nr. 6) and unscrew both of stop screws (Nr. 16) of retracting lever (Nr. 15) sufficiently to get total travel of mobile measuring insert.

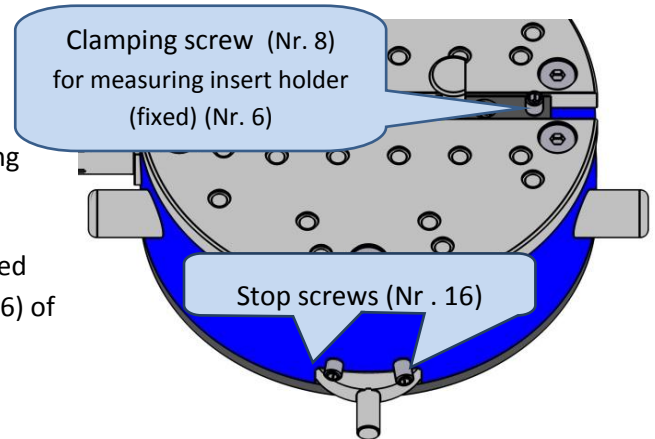


Fig. 6: clamping screws for measuring insert holder and stop screws

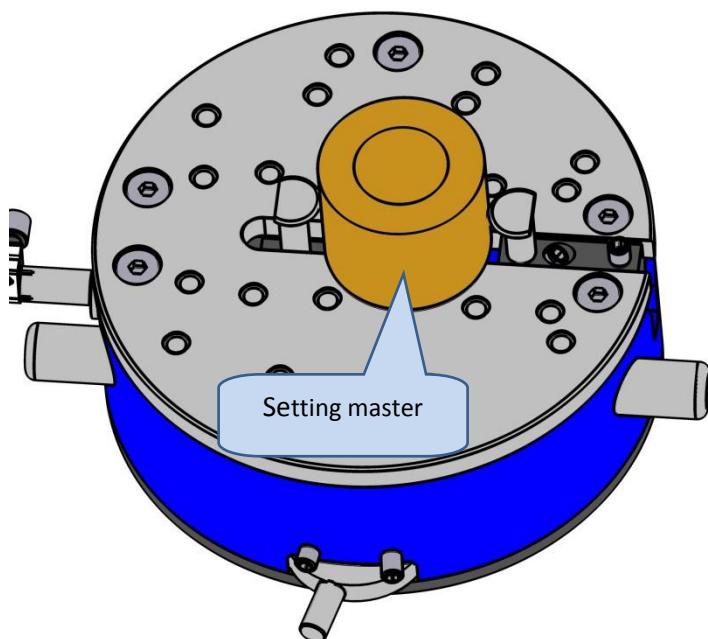


Fig. 7: use setting master to adjust

Position setting master in a way that mobile measuring insert (Nr. 4) is approximately on half of stroke. Near measuring insert (Nr. 7) to setting master. Then lock measuring insert holder (Nr. 6) by clamping screw (Nr. 8). Now, both of stop screws (Nr. 16) for the mobile measuring insert (Nr. 4) can be screwed in sufficiently by hexagon socket wrench to use only a small stroke of retracting lever (Nr. 15) to measure. The exact position of stop screws has to be adapted to special needs of operator and can be corrected at any time!

### DIA-COME C3 Measuring tables

The third measuring insert or measuring insert holder will be adjusted the same way as the fixed measuring insert mentioned below (see „Installation of measuring inserts“ or Fig. 3 and 4). Setting has to be done according to workpiece.

1. base
2. table top
3. measuring insert holder CO-MH, mobile
4. measuring insert CO-MI, mobile
5. stop screw to lock CO-MI (Nr. 4)
6. measuring insert holder CO-MH, fixed
7. measuring insert CO-MI, fixed
8. clamping screw to lock CO-MH (Nr. 6)
9. clamping screw to lock CO-MI (Nr. 7)
10. clamping piece CO-CP
11. insert holder
12. dial indicator or probe
13. setting wheel for measuring direction and force (for CO-MI Nr. 4)
14. clamping screw to lock setting wheel (Nr. 13)
15. retracting lever for CO-MI (Nr. 4)
16. stop screws to limit measuring range (for Nr. 15)
17. sealing caps

