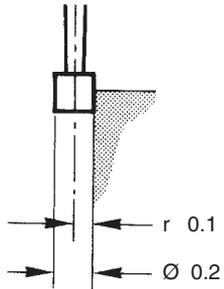


PATENT NOTICE

The Job Contact Probe is protected by the following patents
DE 2347633 IT 1003537 JP 1266244 US 4270275 JP 1388652

Renishaw plc. New Mills,
Wotton-under-Edge, Glos GL12 8JR, UK.
Tel 01453 524 524 Fax 01453 524 901

1. Description



When the probe contacts the workpiece, the red LED lights up.

Stylus position repeatability (maximum 2σ):
0.00004 inch

The stylus radius (0.1 inch) must be taken into account when necessary.

I.D. : Measured distance + 0.2 inch
O.D. : Measured distance - 0.2 inch

The stylus has 0.59 inch overtravel in X and Y axes, and 0.19 inch in the Z axis.

Overtravel must not be exceeded or damage will result.

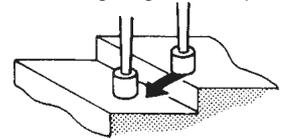
IMPORTANT
The probe must not be spun under spindle power

Application examples

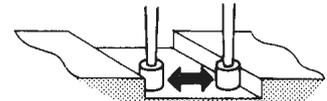
Nos 1-4 **Direct measurement of steps, slots, external features, and contours of workpiece datum surfaces or edges.**

No. 5 **Defining bore centres in line with spindle centre line.**
Contact the sides of the bore with the stylus (1 and 2), then halve the measurement between 1 and 2 to obtain the axis centre.
Touch on points 3 and 4, then halve the measurement between 3 and 4 to obtain the bore centre.

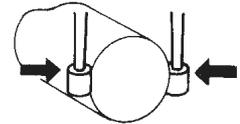
1. Measuring height and depth



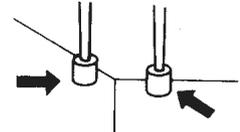
2. Measuring internal features



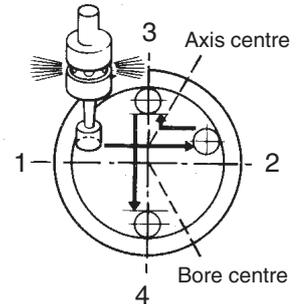
3. Measuring external features



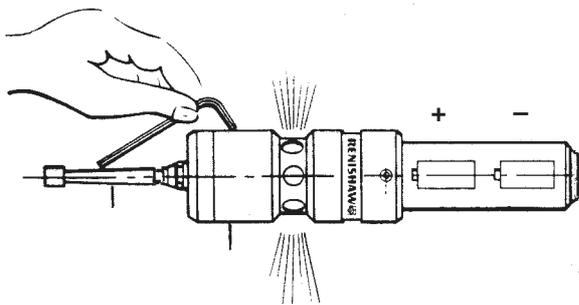
4. Measuring datum edges



5. Centering and measuring bores



2. Batteries



To change the batteries

Unscrew the cap.
Note polarity.
Remove exhausted batteries.
Insert new batteries.
Replace cap.

Order information for spare batteries :
IEC No. LR 1 1.5V

To check the battery power

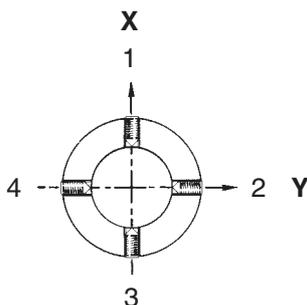
Make a contact between points A and B with a metal object (e.g. hexagon key).
LEDs will light up if batteries are correctly fitted.

3. Installation on taper shanks and adjustment for out of roundness

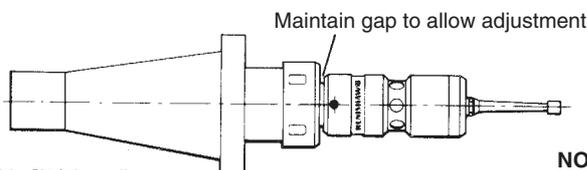
The shank adaptor and stylus must be adjusted when assembled to achieve concentricity of 0.004 inch.

Adjustment

1. To move the stylus in X direction loosen adjusting screws 2 and 4.
2. Move the stylus into the measuring position by adjusting screws 1 and 3 with the two centering tools provided.
3. Similar adjustment is used to move the stylus in the Y direction.
4. Ensure all screws are tightened after adjustment is complete.



Milling collet chuck with Ø3/4in collet



NOTE : Ensure probe is not splashed with coolant