HEIDENHAIN

SALES & SERVICE:

A Tech Authority, Inc.
13745 Stockton Ave.
Chino CA 91710
909-614-4522
sales@atechauthority.com

Length Gauges

May 2004

Incremental length gauges from HEIDENHAIN offer high accuracy over long measuring ranges. These sturdily made gauges are available in application-oriented versions.

They have a wide range of applications in production metrology, in multipoint inspection stations, measuring equipment monitoring, and as position measuring devices.

This catalog supersedes all previous editions, which thereby become invalid. The basis for ordering from HEIDENHAIN is always the catalog edition valid when the contract is made.

Standards (ISO, EN, etc.) apply only where explicitly stated in the catalog.

* After linear length-error compensation in the evaluation electronics

Range of Applications

Metrology and Production Control

Incremental length gauges from HEIDENHAIN play a role in incoming goods inspection, fast dimension checking during production, statistical process control in production or quality assurance, or in any application where fast, reliable and accurate length measurement is required. Their large measuring lengths are a particular advantage: whether the part measures 5 or 95 millimeters, it is measured directly with one and the same length gauge.

Whatever the application, HEIDENHAIN has the appropriate length gauge for the required accuracy. The **HEIDENHAIN-CERTO** length gauges offer a very high accuracy of ± 0.1 µm/± 0.05 µm*/ ± 0.03 µm* for extremely precise measurement. Length gauges from the **HEIDENHAIN-METRO** program have accuracy grades as fine as ± 0.2 µm, while the **HEIDENHAIN-SPECTO** length gauges, with ± 1 µm accuracy, offer particularly compact dimensions.

* After linear length-error compensation in the evaluation electronics

Gauge Block Calibration and Measuring Device Inspection

The usual inspection of measuring equipment called for by standards, and the inspection of gauge blocks in particular, necessitate a large number of reference standard blocks if the comparative measurement is performed using inductive length gauges. The problem is the small measuring range of inductive gauges: they can measure length differences of only up to 10 µm. Incremental length gauges, which offer large measuring ranges together with high accuracy, greatly simplify the calibration of measuring devices required to ensure traceability.

The length gauges of the **HEIDENHAIN-CERTO** program with measuring ranges of 25 mm with ± 0.1 µm/± 0.03 µm* accuracy and 60 mm with ± 0.1 µm/± 0.05 µm* accuracy are especially well suited for this task. It permits a significant reduction in the required number of reference standard blocks, and recalibrating becomes much simpler.

Thickness gauging of silicon wafers

Tolerance gauging of nozzle bodies

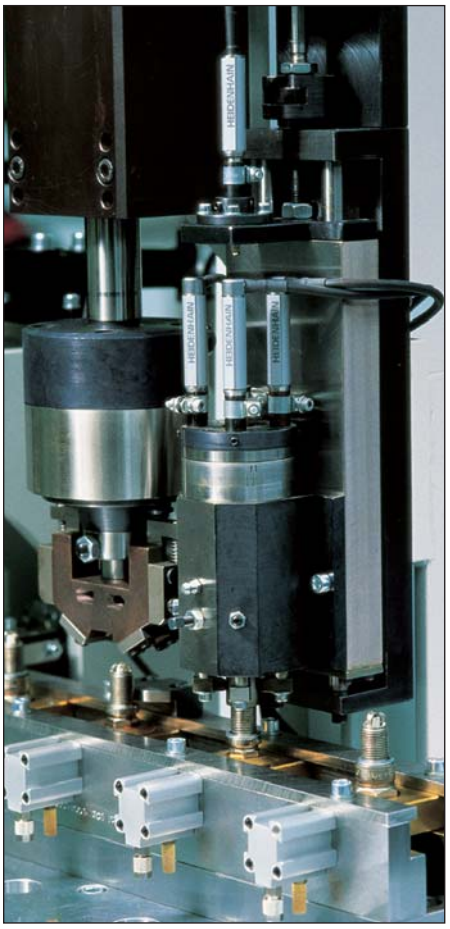
Calibration of gauge blocks

Multipoint Inspection Devices

Multipoint inspection devices require durable length gauges with small dimensions. They should also have relatively large measuring ranges of several millimeters with consistent linear accuracy in order to simplify the construction of inspection devices—for example by enabling the construction of one device for several masters. A large measuring length also provides benefits in master production, because simpler masters can be used.

With their small dimensions and measuring ranges of 12 mm or 30 mm and ± 1 µm accuracy, the **HEIDENHAIN-SPECTO** incremental length gauges are specifically designed for multipoint inspection devices. Higher accuracy requirements up to ± 0.2 µm can be met with similarly compact **HEIDENHAIN-METRO** length gauges.

Unlike inductive gauges, HEIDENHAIN-SPECTO length gauges provide stable measurement over long periods—eliminating recalibration.



Inspection station in spark plug manufacture

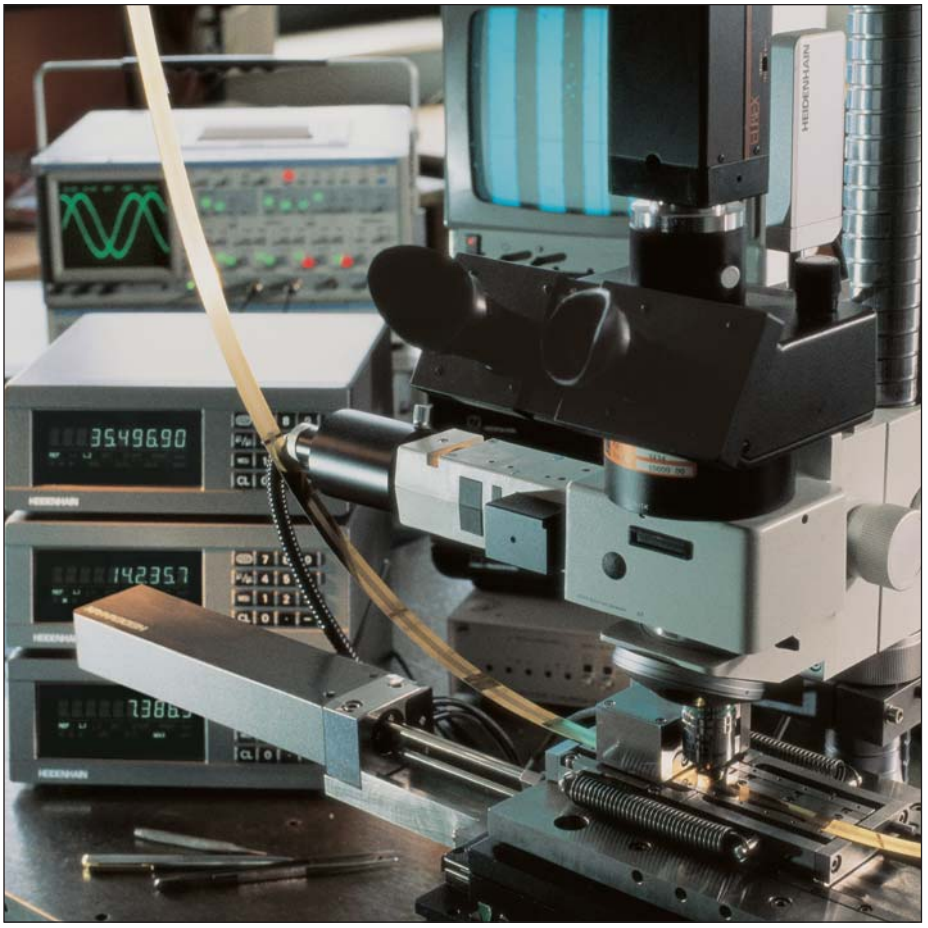
Position Measurement

Incremental length gauges from HEIDENHAIN are also ideal for position measurement on precision linear slides or X-Y tables. Working with measuring microscopes, for example, becomes much easier thanks to the digital readout and the flexible datum setting.

Here, length gauges from the **HEIDENHAIN-METRO** and **HEIDENHAIN-SPECTO** program come into use with large measuring ranges of 30 mm, 60 mm or 100 mm at consistently high accuracy grades of ± 0.5 µm or ± 1 µm.

In this application as linear measuring device, the length gauge's fast installation in accordance with the Abbe measuring principle by its clamping shank or planar mounting surface is of special benefit.

Measuring the error of linear guides



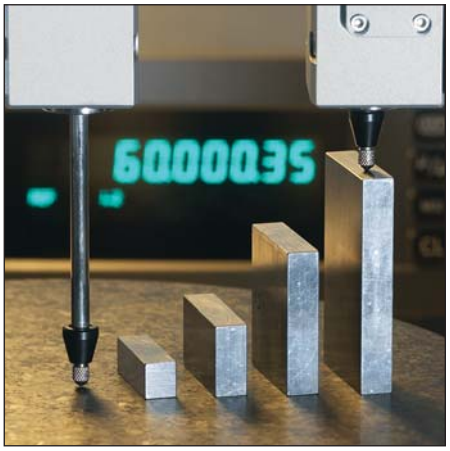
Position measurement on a microscope with X-Y table and adjustable height

Length Gauges from HEIDENHAIN

A number of arguments speak for HEIDENHAIN length gauges. These include not only their technical features, but also their high quality standard and the worldwide presence of HEIDENHAIN.

Large measuring ranges

HEIDENHAIN length gauges are available with measuring lengths of 12 mm, 25 mm, 30 mm, 60 mm or 100 mm. so that you can measure very different parts in one measuring setup and avoid frequently changing setups with expensive gauge blocks or masters.



High accuracy

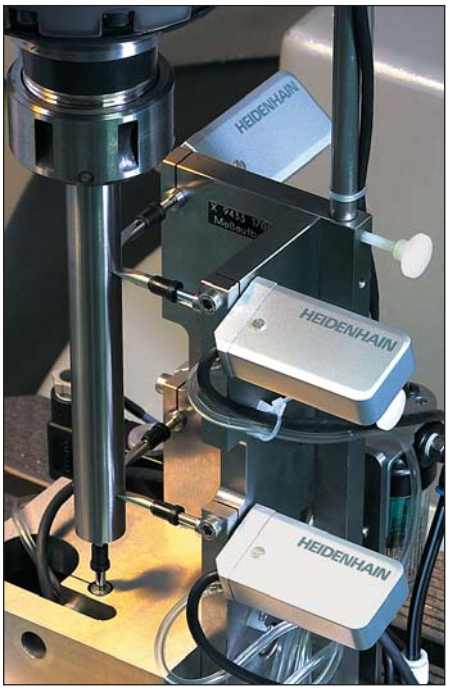
The high accuracy specified for HEIDENHAIN length gauges applies over the entire measuring length. Whether the part measures 10 or 100 mm, its actual dimension is always measured with the same high quality. The high repeatability of HEIDENHAIN length gauges comes into play during comparative measurements, for example in series production.

Robust design

HEIDENHAIN length gauges are built for an industrial environment. They feature consistently high accuracy over a long period of time as well as high thermal stability. They can therefore be used in production equipment and machines.

Wide range of applications

HEIDENHAIN length gauges are suited for many applications. Automatic inspection equipment, manual measuring stations or positioning equipment—wherever lengths, spacing, thickness, height or linear motion are to be measured, HEIDENHAIN length gauges function quickly, reliably and accurately.



Know-how

The high quality of HEIDENHAIN length gauges is no coincidence. HEIDENHAIN has been manufacturing high-accuracy scales for over 70 years, and for many years it has developed measuring and testing devices for length and angle measurement for national standards laboratories. This know-how makes HEIDENHAIN an extraordinarily qualified partner for metrological questions.

Worldwide presence

HEIDENHAIN is represented in all important industrial countries—in most of them with wholly owned subsidiaries. Sales engineers and service technicians support the user on-site with technical information and servicing in the local language.

Length Gauge Overview

Accuracy	Measuring range
± 0.1 µm **± 0.05 µm***) **± 0.03 µm***)	**HEIDENHAIN-CERTO**
	Plunger actuation by motor
	Motor-driven or by external coupling
± 0.2 µm	**HEIDENHAIN-METRO**
	Plunger actuation by cable lifter or measured object
	Pneumatic plunger actuation
± 0.5 µm **± 1 µm**	**HEIDENHAIN-METRO**
	Plunger actuation by motor
	Motor-driven or by external coupling
± 1 µm	**HEIDENHAIN-SPECTO**
	Plunger actuation by measured object
	Pneumatic plunger actuation

*) After linear length-error compensation in the evaluation electronics

MT 101 **MT 60** **MT 2500** **MT 1200**

12 mm	25 mm/ 30 mm	60 mm	100 mm	Page
				18
	CT 2501 ∿ 11 μA_{PP} **CT 2502** ∿ 11 μA_{PP}	**CT 6001** ∿ 11 μA_{PP} **CT 6002** ∿ 11 μA_{PP}		
				20
MT 1201 ∿ 11 μA_{PP} **MT 1271** ⊓⊔ TTL **MT 1281** ∿ 1 V_{PP} **MT 1287** ∿ 1 V_{PP}	**MT 2501** ∿ 11 μA_{PP} **MT 2571** ⊓⊔ TTL **MT 2581** ∿ 1 V_{PP} **MT 2587** ∿ 1 V_{PP}			
				22
		MT 60 M ∿ 11 μA_{PP} **MT 60 K** ∿ 11 μA_{PP}	**MT 101 M** ∿ 11 μA_{PP} **MT 101 K** ∿ 11 μA_{PP}	
				24
ST 1208 ∿ 11 μA_{PP} **ST 1278** ⊓⊔ TTL **ST 1288** ∿ 1 V_{PP} **ST 1207** ∿ 11 μA_{PP} **ST 1277** ⊓⊔ TTL **ST 1287** ∿ 1 V_{PP}	**ST 3008** ∿ 11 μA_{PP} **ST 3078** ⊓⊔ TTL **ST 3088** ∿ 1 V_{PP} **ST 3007** ∿ 11 μA_{PP} **ST 3077** ⊓⊔ TTL **ST 3087** ∿ 1 V_{PP}			

CT 6000

CT 2500

ST 3000

ST 1200

Functional Principle

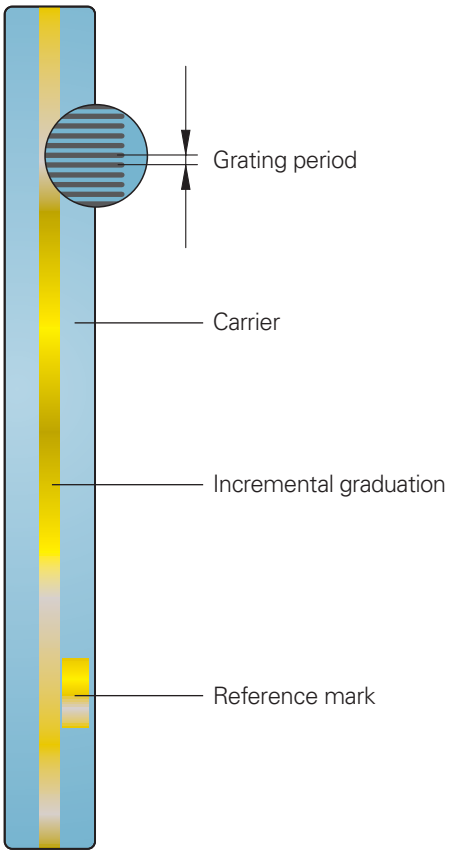
HEIDENHAIN length gauges are characterized by long measuring ranges and consistently high accuracy. The basis for both is the measuring principle of photoelectrically scanning an incremental scale.

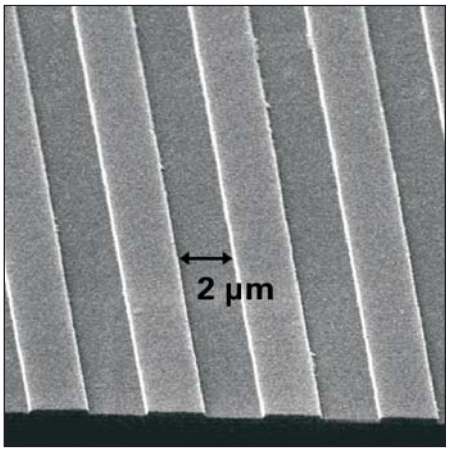
HEIDENHAIN linear encoders use material measuring standards consisting of **incremental graduations** on substrates of glass or glass ceramic. These measuring standards permit large measuring ranges, are insensitive to vibration and shock, and have a defined thermal behavior. Changes in atmospheric pressure or relative humidity have no influence on the accuracy of the measuring standard—which is the prerequisite for the **high long-term stability** of HEIDENHAIN length gauges.

The masters for these graduations are fabricated on dividing engines developed and built by HEIDENHAIN. High thermal stability during the manufacturing process ensures that the graduations have **high accuracy** over the measuring length. The master graduation is applied to the carrier using the **DIADUR** copying processes developed by HEIDENHAIN, which produces very thin but durable graduation structures of chromium.

The incremental graduation is **photoelectrically scanned** without mechanical contact and therefore without wear. Light passes through the structured scanning reticle and over the scale onto photovoltaic cells. The photovoltaic cells produce sinusoidal output signals with a small signal period (see page 36). Interpolation in the subsequent electronics makes very small measuring steps into the nanometer range possible. The scanning principle, together with the extremely fine graduation lines and their high edge definition ensure the quality of the output signals as well as the **small position error within one signal period.** This applies particularly to HEIDENHAIN length gauges, which use a DIADUR phase grating as measuring standard. The interferential scanning method produces sinusoidal incremental signals with a period of only 2 µm.

Reference mark
Photoelectric scanning of grid structures results in an incremental, i.e. counting, measurement. To ascertain positions, an absolute reference is required. The reference mark enables the exact reestablishment of the most recently defined datum, for example after an interruption in power. It is photoelectrically scanned and is permanently associated with exactly one measuring step, regardless of the direction or velocity of traverse.





DIADUR phase grating with approx. 0.25 µm grating height

DIADUR graduation

Mechanical Design

HEIDENHAIN length gauges function according to the **Abbe measuring principle,** i.e. the measuring standard and the plunger are exactly aligned. All components comprising the **measuring loop,** such as the measuring standard, plunger, holder and scanning head are designed in terms of their mechanical and thermal stability for the highest possible accuracy of the length gauge.

HEIDENHAIN length gauges feature a defined **thermal behavior.** Since temperature variations during measurement can result in changes in the measuring loop, HEIDENHAIN uses special materials with low α_{therm} coefficients of expansion for the components of the measuring loop, for example in the CERTO length gauges. The scale is manufactured of ZERODUR® ($\alpha_{therm} \approx 0\ K^{-1}$), and the plunger and holder are of Invar ($\alpha_{therm} \approx 1 \cdot 10^{-6}\ K^{-1}$). This makes it possible to guarantee its high measuring accuracy over a relatively large temperature range.

Length gauges from HEIDENHAIN feature a **sturdy design.** Even high vibration and shock loads have no negative influence on the accuracy documented in the calibration chart.

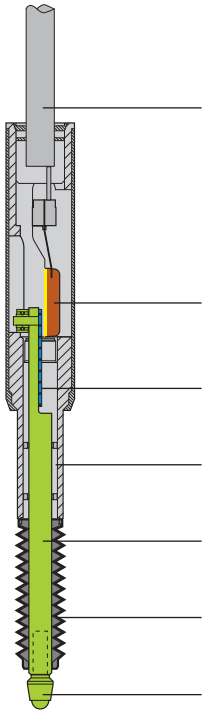
The **ball-bush guided plunger** tolerates high radial forces and moves with very low friction. It has an M2.5 thread to hold measuring contacts.

Expendable parts
HEIDENHAIN length gauges contain components that are subject to wear, depending on the application and manipulation. These include in particular the following parts:

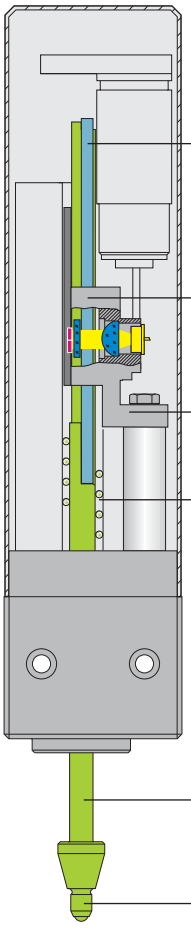
- LED light source
- Guideway (tested for at least 5 million strokes*)
- Cable link for CT, MT 60 and MT 101 (tested for at least 1 million strokes*)
- Scraper rings
- Rubber bellows on ST

* On CT, MT 60 M and MT 101 M only with actuation by switch box

Design of ST 1200



Design of CT 6000 MT 60



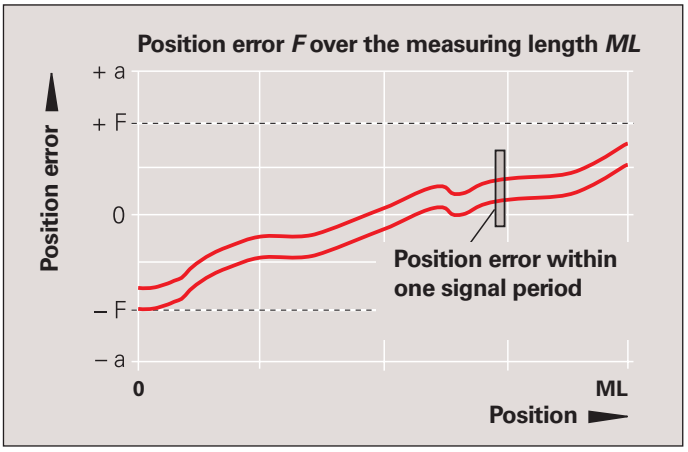
Measuring Accuracy

The accuracy of position measurement with length gauges is mainly determined by the following factors:

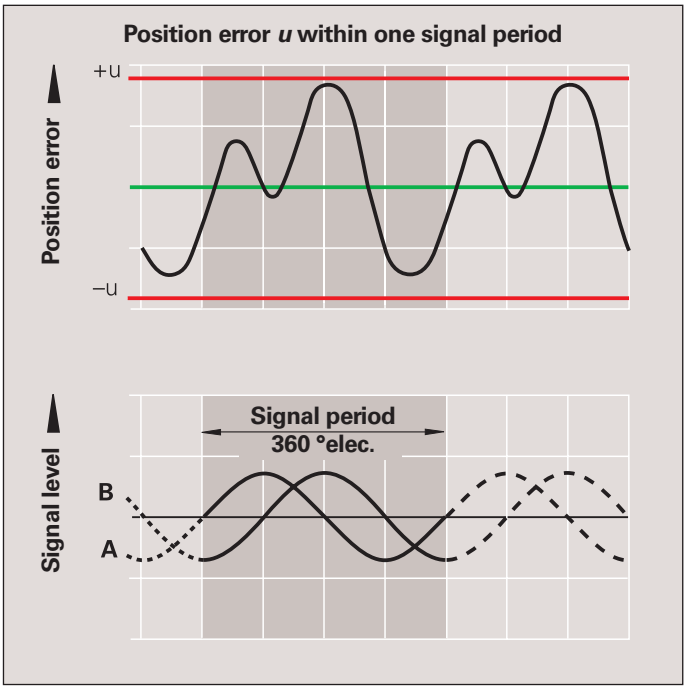
- The quality of the graduation
- The quality of the scanning process
- The quality of the signal processing electronics
- The error from the scale guideway over the scanning unit

A distinction is made between position error over relatively large paths of traverse—for example the entire measuring range—and that within one signal period.

Position error over the measuring range
Length gauge accuracy is specified as system accuracy, which is defined as follows:
*The extreme values of the **total error F** — with reference to their mean value—lie over the entire measuring length within the system accuracy ± a. They are measured during the final inspection and documented in the calibration chart.*



Position error within one signal period
The **position error *u*** within one signal period is determined by the signal period of the length gauge, as well as the quality of the graduation and the scanning thereof. At any position over the entire measuring length, it does not exceed approx. ± 1 % of the signal period. The smaller the signal period, the smaller the position error within one signal period. In the calibration chart of the HEIDENHAIN-CERTO, this position error within one signal period is shown as a tolerance band.



	Signal period of the scanning signals	Max. position error *u* within one signal period
CT 2500 **CT 6000**	2 µm	Approx. 0.02 µm
MT 1200 **MT 2500**	2 µm	Approx. 0.02 µm
MT 60 **MT 101**	10 µm	Approx. 0.1 µm
ST 1200 **ST 3000**	20 µm	Approx. 0.2 µm

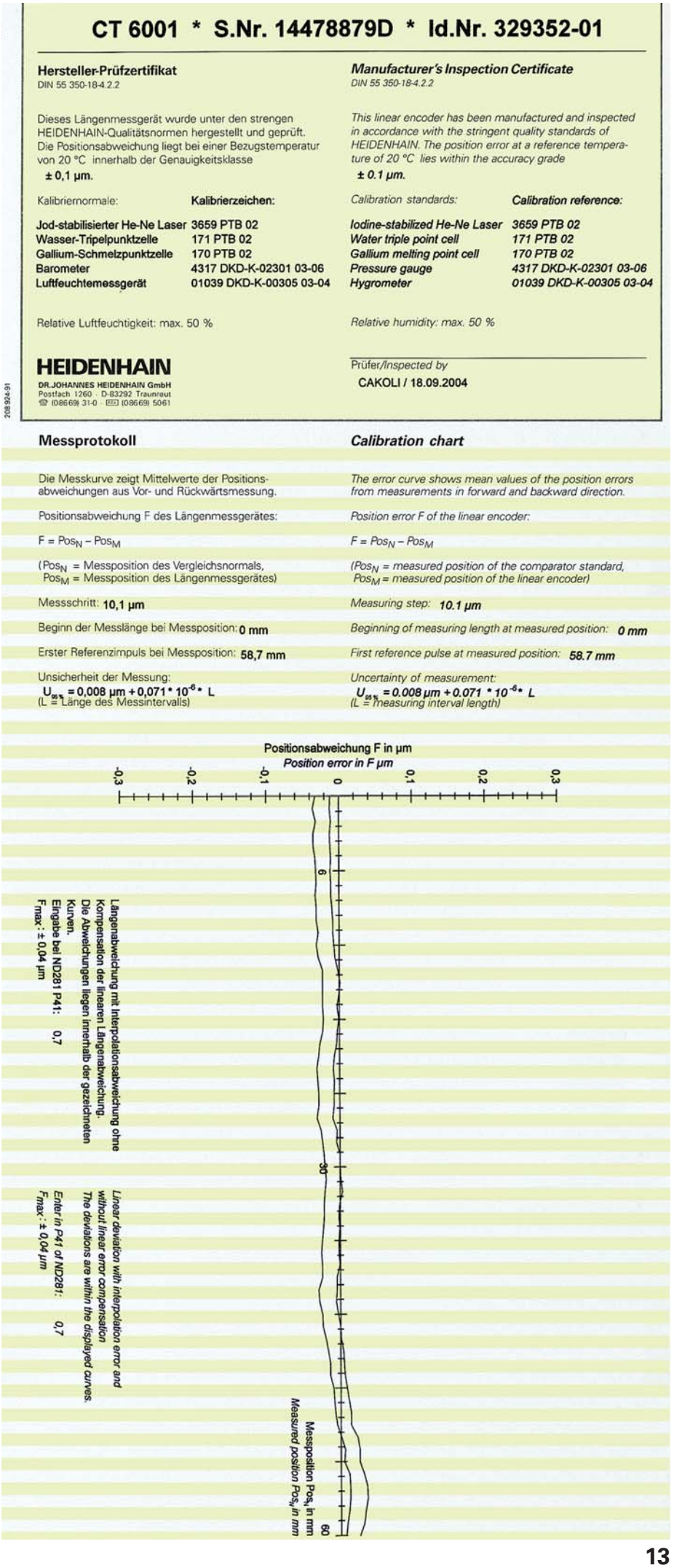
All HEIDENHAIN length gauges are inspected before shipping for accuracy and proper function.

They are calibrated for accuracy during retraction and extension of the plunger. For the HEIDENHAIN-CERTO, the number of measuring positions is selected to ascertain very exactly not only the long-range error, but also the position error within one signal period.

The **manufacturer's inspection certificate** confirms the specified system accuracy of each length gauge. The **calibration standards** ensure the traceability—as required by ISO 9001—to recognized national or international standards.

For the length gauges of the HEIDENHAIN-METRO and HEIDENHAIN-CERTO series, a **calibration chart** documents the position error over the measuring range and also states the measuring step and measuring uncertainty of the measurement.

Temperature range
The length gauges are inspected at a **reference temperature** of 20 °C. The system accuracy given in the calibration chart applies at this temperature. The **operating temperature** indicates the ambient temperature limits between which the length gauges will function properly. The **storage temperature range** of –20 °C to 60 °C applies for the device in its packaging.



CT 6001 * S.Nr. 14478879D * Id.Nr. 329352-01

Hersteller-Prüfzertifikat
DIN 55 350-18-4.2.2

Dieses Längenmessgerät wurde unter den strengen HEIDENHAIN-Qualitätsnormen hergestellt und geprüft. Die Positionsabweichung liegt bei einer Bezugstemperatur von 20 °C innerhalb der Genauigkeitsklasse
± 0,1 µm.

Kalibriernormale:	Kalibrierzeichen:
Jod-stabilisierter He-Ne Laser	3659 PTB 02
Wasser-Tripelpunktzelle	171 PTB 02
Gallium-Schmelzpunktzelle	170 PTB 02
Barometer	4317 DKD-K-02301 03-06
Luftfeuchtemessgerät	01039 DKD-K-00305 03-04

Relative Luftfeuchtigkeit: max. 50 %

Manufacturer's Inspection Certificate
DIN 55 350-18-4.2.2

This linear encoder has been manufactured and inspected in accordance with the stringent quality standards of HEIDENHAIN. The position error at a reference temperature of 20 °C lies within the accuracy grade
± 0.1 µm.

Calibration standards:	***Calibration reference:***
Iodine-stabilized He-Ne Laser	*3659 PTB 02*
Water triple point cell	*171 PTB 02*
Gallium melting point cell	*170 PTB 02*
Pressure gauge	*4317 DKD-K-02301 03-06*
Hygrometer	*01039 DKD-K-00305 03-04*

Relative humidity: max. 50 %

HEIDENHAIN
DR.JOHANNES HEIDENHAIN GmbH
Postfach 1260 · D-83292 Traunreut
☎ (08669) 31-0 · FAX (08669) 5061

Prüfer/*Inspected by*
CAKOLI / 18.09.2004

Messprotokoll

Die Messkurve zeigt Mittelwerte der Positionsabweichungen aus Vor- und Rückwärtsmessung.

Positionsabweichung F des Längenmessgerätes:

$F = Pos_N - Pos_M$

(Pos_N = Messposition des Vergleichsnormals, Pos_M = Messposition des Längenmessgerätes)

Messschritt: **10,1 µm**

Beginn der Messlänge bei Messposition: **0 mm**

Erster Referenzimpuls bei Messposition: **58,7 mm**

Unsicherheit der Messung:
$U_{95\%} = 0{,}008\ \mu m + 0{,}071 * 10^{-6} * L$
(L = Länge des Messintervalls)

Calibration chart

The error curve shows mean values of the position errors from measurements in forward and backward direction.

Position error F of the linear encoder:

$F = Pos_N - Pos_M$

(Pos_N = measured position of the comparator standard, Pos_M = measured position of the linear encoder)

Measuring step: ***10.1 µm***

Beginning of measuring length at measured position: ***0 mm***

First reference pulse at measured position: ***58.7 mm***

Uncertainty of measurement:
$U_{95\%} = 0.008\ \mu m + 0.071 * 10^{-6} * L$
(*L = measuring interval length*)

Positionsabweichung F in µm
Position error in F µm
-0,3 -0,2 -0,1 0 0,1 0,2 0,3
6
30
60
Messposition Pos_M in mm
Measured position Pos_M in mm

Längenabweichung mit Interpolationsabweichung ohne Kompensation der linearen Längenabweichung.
Die Abweichungen liegen innerhalb der gezeichneten Kurven.
Eingabe bei ND281 P41: 0,7
F_{max}: ± 0,04 µm

Linear deviation with interpolation error and without linear error compensation
The deviations are within the displayed curves.
Enter in P41 of ND281: 0,7
F_{max}: ± 0,04 µm

Gauging Force—Plunger Actuation

Gauging force
Gauging force is the force that the plunger exercises on the measured object. An excessively large gauging force can cause deformation of the measuring contact and the measured object. If the gauging force is too small, an existing dust film or other obstacle may prevent the plunger from fully contacting the measured object. The gauging force depends on the type of plunger actuation.

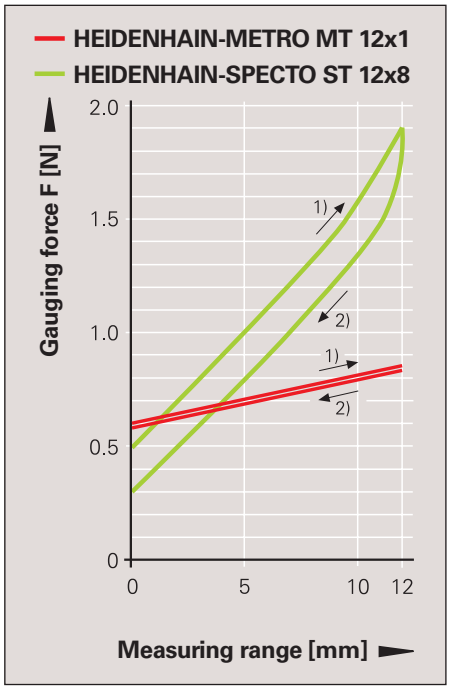
Plunger actuation by spring
For the MT 12x1, MT 25x1, ST 12x8 and ST 30x8, the integral spring extends the plunger to the measuring position and applies the **gauging force.** In its resting position, the plunger is extended. The gauging force depends on the following criteria:

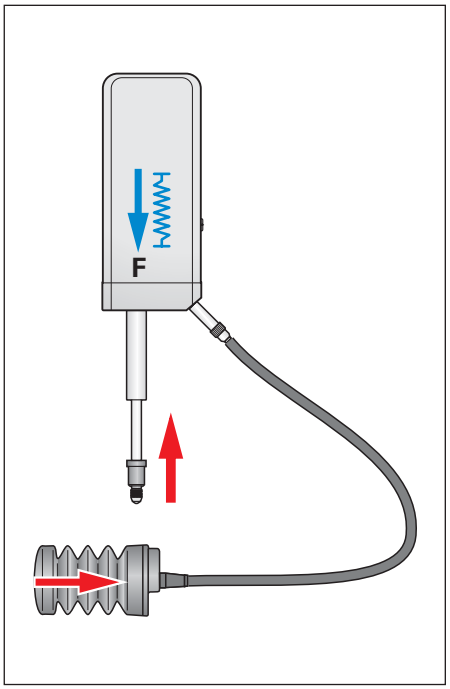
- The operating attitude
- The plunger position, because the gauging force changes over the measuring range
- The measuring direction, i.e., whether the gauge measures with extending or retracting plunger

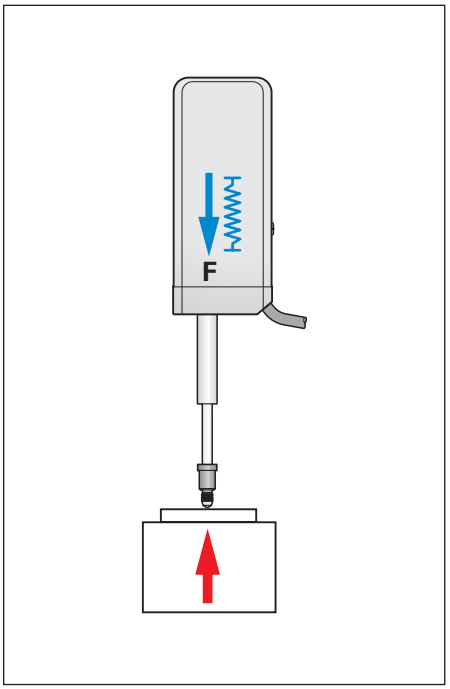
There are several ways of actuating the length gauge plunger:

Plunger actuation by cable-type lifter
Through a cable mechanism, the plunger is retracted by hand and then extended onto the measured object. The measurement is made with extending plunger.

Plunger actuation by measured object
The complete length gauge is moved relative to the measured object. The measurement is made with retracting plunger.







[1] Plunger retraction
[2] Plunger extension

Pneumatic plunger actuation
The pneumatically actuated plungers of the MT 1287, MT 2587, ST 12x7 and ST 30x7 length gauges are extended by the application of compressed air. When the air connection is ventilated, the integral spring retracts the plunger to a protected resting position within the housing.

The gauging force can be adjusted to the measuring task through the level of air pressure. At constant pressure, it depends on the operating attitude and the plunger position.

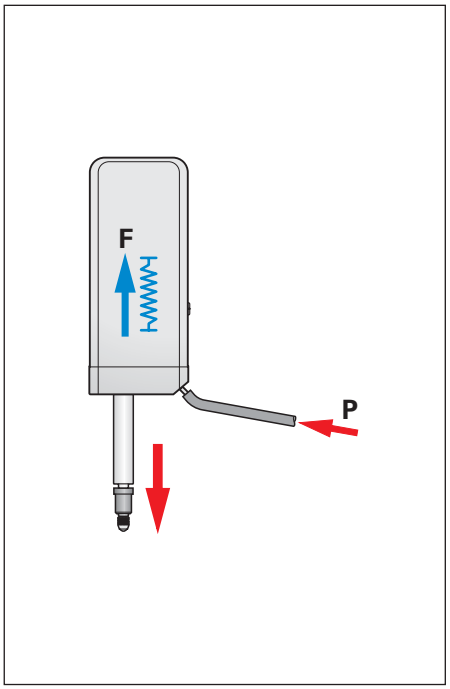
The vertically downward position with retracted plunger, for example, has the greatest **gauging force,** and the vertically upward position with extended plunger the lowest. The data given in the specifications are approximate and are subject to variation due to tolerances and to wear in the seal.

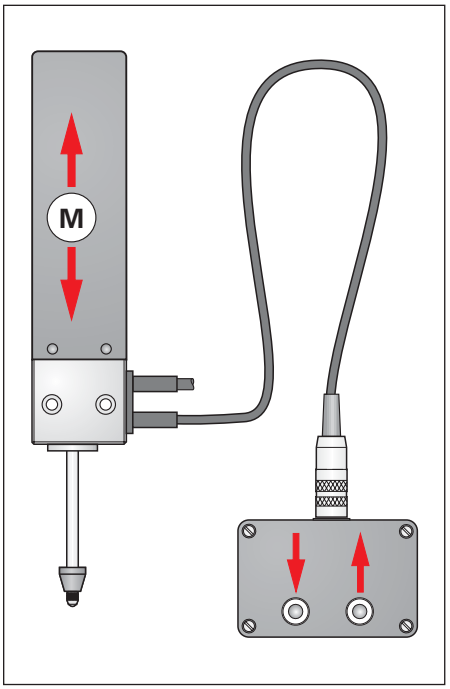
The length gauges with pneumatic plunger actuation are particularly well suited for automated measuring systems.

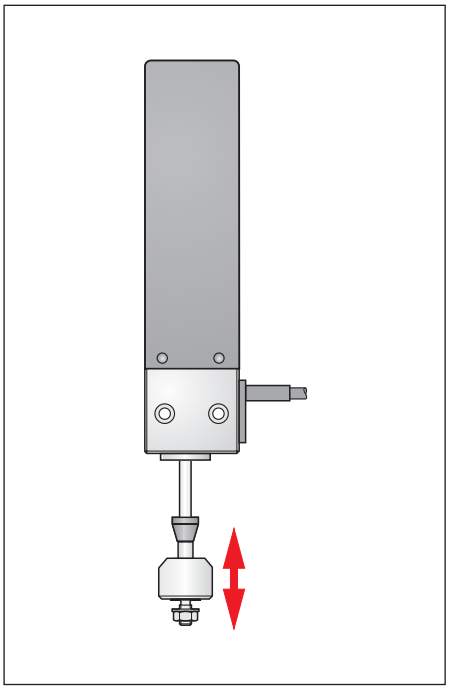
Motorized plunger actuation
The CT 2501, CT 6001, MT 60 M and MT 101 M length gauges feature an integral motor that moves the plunger. It is operated through the switch box either by push button or over the connection for external operation. The plungers of the CT 2501, CT 6001, and MT 60 M length gauges must not be moved by hand if the switch box is connected.

The **gauging force** of the CT 2501, CT 6001 and MT 60 M motorized length gauges is adjustable in three stages through the switch box. The force remains constant over the measuring range but depends on the operating attitude. Regardless of the operating attitude—whether it measures vertically downward (with the SG 101 V switchbox) or horizontally (with the SG 101 H switch box)—the MT 101 M exercises a constant gauging force.

External plunger actuation by coupling
For the CT 2502, CT 6002, MT 60 K, MT 101 K and special versions (without spring) of the MT 1200 and MT 2500, the plunger is freely movable. For position measurement, the plunger is connected by a coupling with a moving machine element. The force needed to move the plunger is specified as the required **moving force.** It depends on the operating attitude.







Mounting

In addition to the length gauge itself, the mechanical design of the measuring setup also plays a role in defining the quality of measurement.

Abbe principle
HEIDENHAIN length gauges enable you to work according to the Abbe measuring principle: The measured object and scale must be in alignment to avoid additional measuring error.

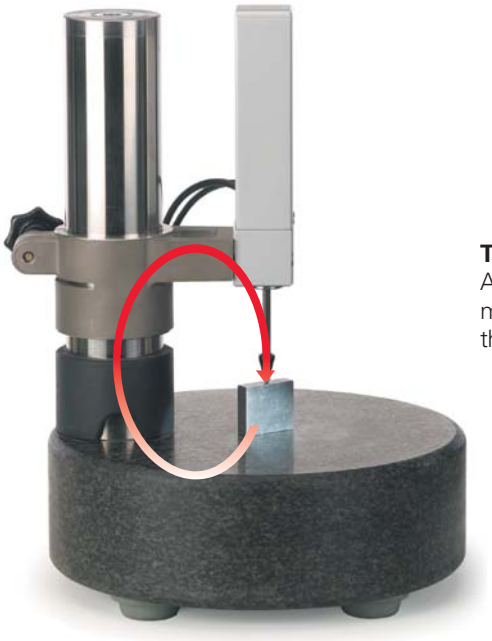
Measuring loop
All components included in the measuring loop such as the holder for the measured object, the gauge stand with holder, and the length gauge itself influence the result of measurement. Expansion or deformation of the measuring setup through mechanical or thermal influences adds directly to the error.

Mechanical design
A stable measuring assembly must be ensured. Long lateral elements within the measuring loop are to be avoided. HEIDENHAIN offers a stable gauge stand as an accessory.

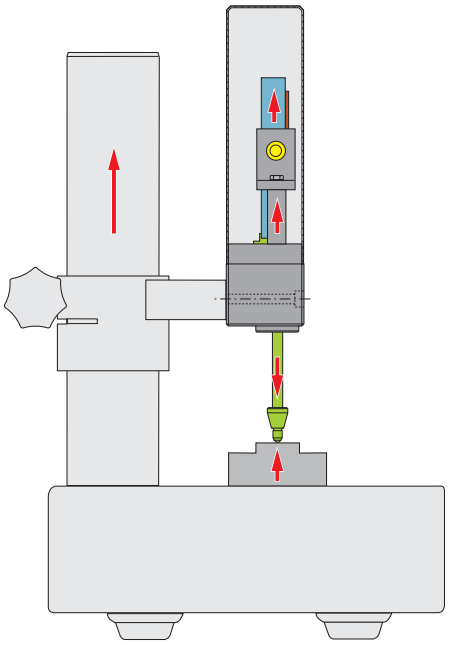
The force resulting from the measurement must not cause any measurable deformation of the measuring loop. Incremental length gauges from HEIDENHAIN operate with small gauging force and have very little influence on the measuring setup.

Thermal behavior
Temperature variations during measurement cause changes in length or deformation of the measuring setup. After a change in temperature of 5 K, a steel bar of 200 mm length expands by 10 µm.
Length changes resulting from a uniform deviation from the reference temperature can largely be compensated by resetting the datum on the measuring plate or a master; only the expansion of the scale and measured object go into the result of measurement. Temperature changes during measurement cannot be ascertained mathematically.

For critical components, HEIDENHAIN therefore uses special materials with low coefficients of expansion, such as are found in the HEIDENHAIN-CERTO gauge stand. This makes it possible to guarantee the high accuracy of HEIDENHAIN-CERTO even at ambient temperatures of 19 to 21 °C and variations of ± 0.1 K during measurement.



The measuring loop:
All components involved in the measuring assembly, including the length gauge



Thermally induced length change:
Expansion of the measuring loop components as a result of heat

Acceleration
Shock and vibration of any kind is to be avoided during measurement so as not to impair the high accuracy of the length gauge. The maximum values given in the specifications apply to the effect of external acceleration on the length gauge. They describe only the mechanical stability of the length gauge, and imply no guarantee of function or accuracy.

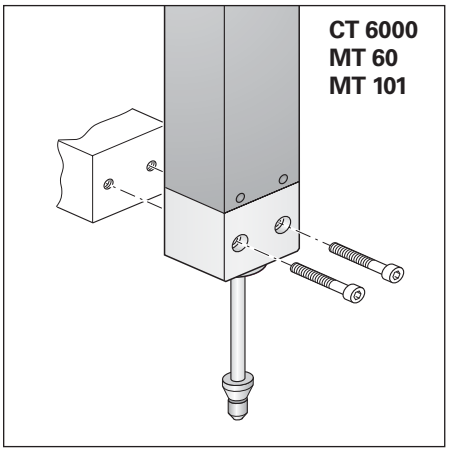
In the length gauge itself, unchecked extension of the spring-driven or non-coupled moving plunger can cause high acceleration onto the measured object or measuring plate surface. For the MT 1200 and MT 2500 series length gauges, use the cable-type lifter whenever possible (see *Accessories*). The cable lifter features adjustable pneumatic damping to limit the extension velocity to an uncritical value.

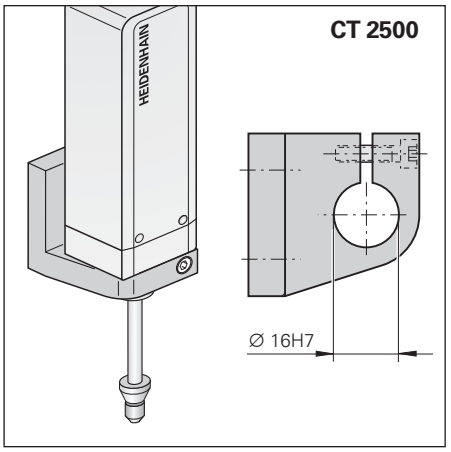
Fastening
The **CT 6000, MT 60** and **MT 101** length gauges are fastened by two screws onto a plane surface. This ensures a mechanically stable installation of even these large length gauges. Special holders are available for fastening the MT 60 and MT 101 to the MS 100 gauge stand for the HEIDENHAIN-METRO (see *Accessories*).

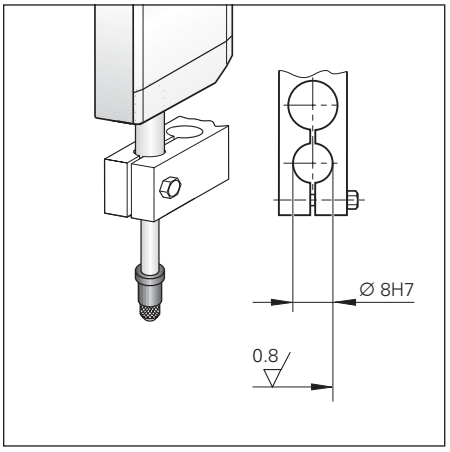
The **CT 2500** is mounted by its standard clamping shank with 16h8 diameter.
A holder is available for fastening the HEIDENHAIN-CERTO to the gauge stand (see *Accessories*).

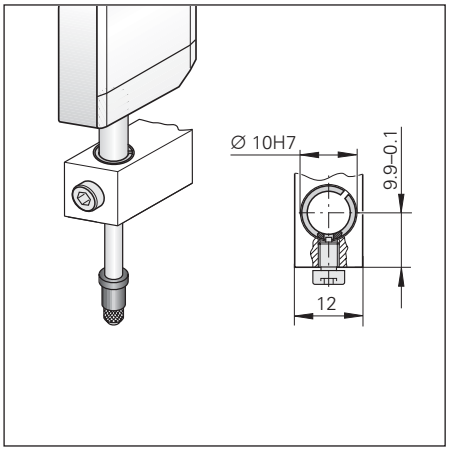
The **ST, MT 1200** and **MT 2500** length gauges feature a standard clamping shank with 8h6 diameter. These HEIDENHAIN length gauges can therefore easily be used with existing measuring fixtures and stands.

As an accessory, HEIDENHAIN offers a special clamping sleeve and screw. It facilitates fastening the length gauge securely without overstressing the clamping shank.
Clamping sleeve Id. Nr. 386 811-01



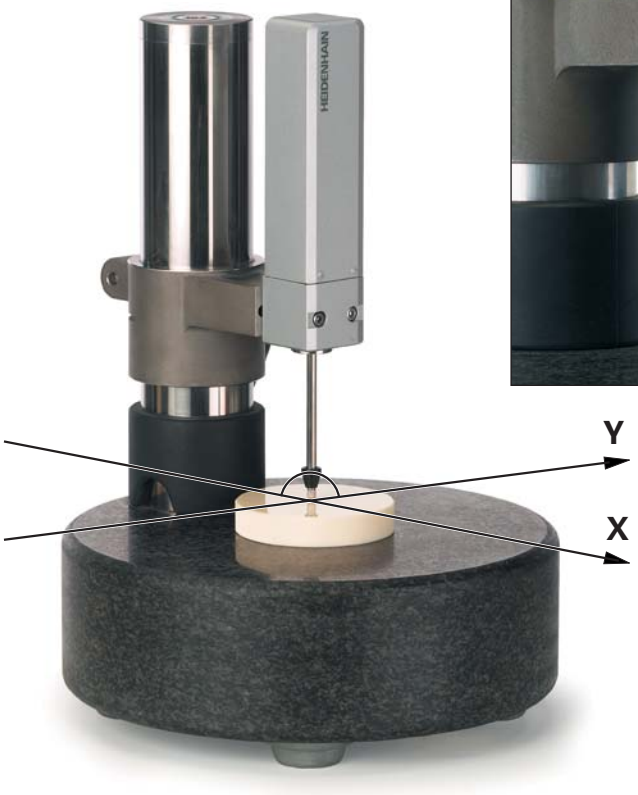






Orthogonal mounting
The length gauge is to be mounted so that its plunger is exactly orthogonal to the measured object or the surface on which it rests. Deviations result in error.

The accessory HEIDENHAIN gauge stands with holders for an **8 mm clamping shank** ensure orthogonal mounting. Length gauges that provide **planar mounting surfaces** are to be adjusted in the direction parallel to the mounting surface (Y) to be perpendicular to the measuring plate. A quick and reliable adjustment is possible with the aid of a gauge block or a parallel block. The perpendicularity to the measuring table (X) is already ensured by the gauge stand.



HEIDENHAIN-CERTO

Length Gauges with ± 0.1 µm/± 0.05 µm*/± 0.03 µm* Accuracy

- **For very high accuracy**
- **For inspection of measuring equipment and gauge blocks**

HEIDENHAIN-CERTO length gauges feature a large measuring range, provide high linear accuracy and offer resolution in the nanometer range. They are used predominantly for production quality control of high-precision parts and for the monitoring and calibration of reference standards. Length gauges reduce the number of working standards required to calibrate gauge blocks.

Accuracy
The total error of HEIDENHAIN-CERTO length gauges lies within **± 0.1 µm.** After linear length error compensation in the evaluation electronics of the ND 281 B, for example, HEIDENHAIN guarantees accuracy of **± 0.03 µm** for the CT 2500 and **± 0.05 µm** for the CT 6000. These accuracy grades apply over the entire measuring range at ambient temperatures between 19 and 21 °C and with a temperature variation of ± 0.1 K during measurements using the CS 200 gauge stand for HEIDENHAIN-CERTO.

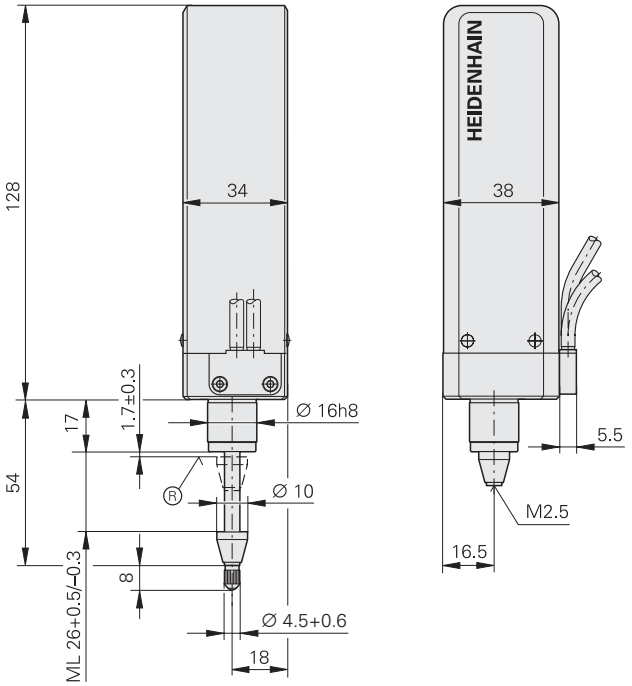
Plunger actuation
The plunger of the **CT 2501** and **CT 6001** is extended and retracted by an integral motor. It can be actuated by the associated switch box, which can also be controlled by external signal. The **CT 2502** and **CT 6002** have no plunger drive. The freely movable plunger is connected by a separate coupling with the moving machine element.

Mounting
The CT 2500 length gauge is fastened by its 16-mm diameter clamping shank. The CT 6000 is fastened with two screws on a plane surface. The CS 200 gauge stand (see *Accessories*) was conceived specially for HEIDENHAIN-CERTO length gauges. It fulfills the requirements of high precision measurement with respect to thermal behavior, stability, orthogonality and flatness of the measuring plate surface. A special holder is available as an accessory for mounting the CT 2500.

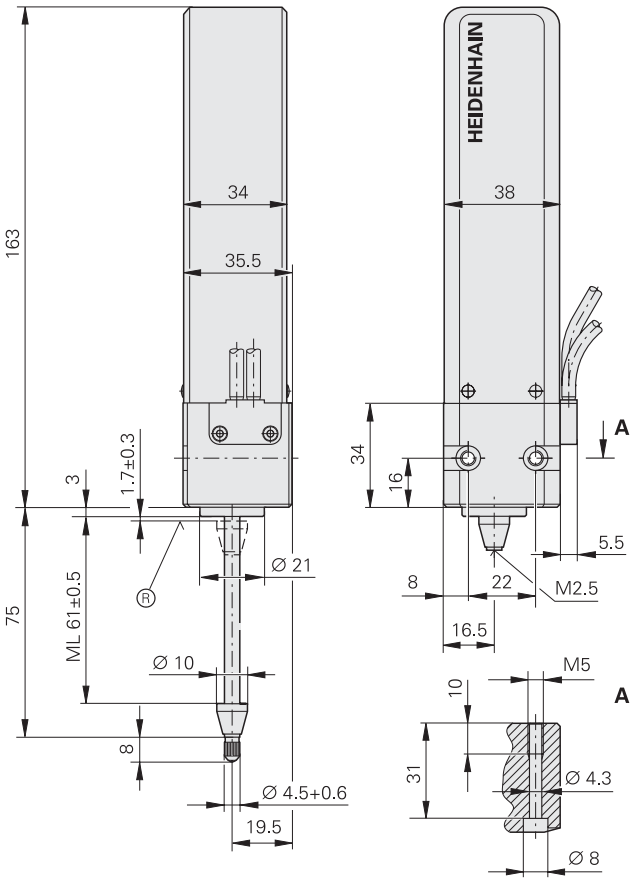
Output signals
The HEIDENHAIN-CERTO length gauges provide ∿ 11 μA_{PP} current signals for HEIDENHAIN subsequent electronics.

* After linear length-error compensation in the evaluation electronics

CT 2500



CT 6000



mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm
Ⓡ = Reference mark position

Specifications	CT 2501 CT 6001	CT 2502 CT 6002
Plunger actuation	Motorized	Plunger connected via separate coupling with moving machine part
Measuring standard	DIADUR phase grating on Zerodur® glass ceramic Grating period 4 µm	
System accuracy at 19 to 21 °C *CT 2500* *CT 6000*	± 0.1 µm without compensation; ± 0.03 µm after linear length error compensation ± 0.05 µm after linear length error compensation	
Recommd. meas. step	0.01 µm/0.005 µm (5 nm) with ND 281 B	
Reference mark	Approx. 1.7 mm below upper stop	
Meas. range *CT 2500* *CT 6000*	25 mm 60 mm	
Gauging force Vertically downward Vertically upward Horizontal	1 N/1.25 N/1.75 N – /– /0.75 N – /0.75 N/1.25 N	–
Required moving force	–	0.1 N to 0.6 N (depending on the operating attitude)
Permissible radial force	≤ 0.5 N	
Operating attitude	Any	
Vibration 55 to 2000 Hz **Shock** 11 ms	≤ 100 m/s^2 (IEC 60 068-2-6) ≤ 1000 m/s^2 (IEC 60 068-2-27)	
Protection IEC 60 529	IP 50	
Operating temperature	10 to 40 °C; ref. temperature 20 °C	
Fastening *CT 2500* *CT 6000*	Clamping shank Ø 16h8 Plane surface	
Weight *CT 2500* without cable *CT 6000*	520 g 700 g	480 g 640 g
Incremental signals	~ 11 µA$_{PP}$; signal period 2 µm	
Measuring velocity	≤ 24 m/min (depending on the subsequent electronics) ≤ 12 m/min with the ND 281 B measured value display unit	
Electrical connection Cable length	Cable 1.5 m with M23 connector (male) 9-pin; Interface electronics integrated in connector ≤ 30 m with HEIDENHAIN cable	
Power supply	5 V ± 5 %/< 180 mA	5 V ± 5 %/< 120 mA

Required accessories	For CT 2501	For CT 6001
Switch box	SG 25 M Id. Nr. 317 436-01	SG 60 M Id. Nr. 317 436-02

CT 2500

CT 6000

HEIDENHAIN-METRO

Length Gauges with ± 0.2 µm Accuracy

- **High repeatability**
- **Plunger actuation by cable release, by the workpiece or pneumatically**

With their high system accuracy and small signal period, the HEIDENHAIN-METRO MT 1200 and MT 2500 length gauges are ideal for precision measuring stations and testing equipment. They feature ball-bush guided plungers and therefore permit high radial forces.

Plunger actuation
The length gauges of the **MT 12x1** and **MT 25x1** series feature a spring-tensioned plunger that is extended at rest. In a special version without spring it exercises particularly low force on the measured object. In the pneumatic length gauges **MT 1287** and **MT 2587,** the plunger is retracted to its rest position by the integral spring. It is extended to the measuring position by the application of compressed air.

Mounting
The MT 1200 and MT 2500 length gauges are fastened by their 8h6 standard clamping shank. A mounting bracket is available as an accessory to mount the length gauges to plane surfaces or to the MS 200 from HEIDENHAIN.

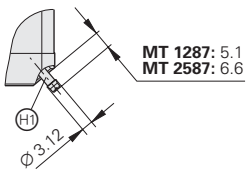
Output signals
The MT 1200 and MT 2500 length gauges are available with three different output signals.

The **MT 1201** and **MT 2501** versions supply sinusoidal current signals with **11 µA$_{PP}$** levels for HEIDENHAIN subsequent electronics.

The **MT 128x** and **MT 258x** length gauges provide sinusoidal voltage signals with **1 V$_{PP}$** levels, which permit high interpolation.

The **MT 1271** and **MT 2571** feature integrated digitizing and interpolation electronics with 5-fold or 10-fold interpolation (as ordered) and square-wave signals in **TTL levels.**

MT 1287
MT 3087

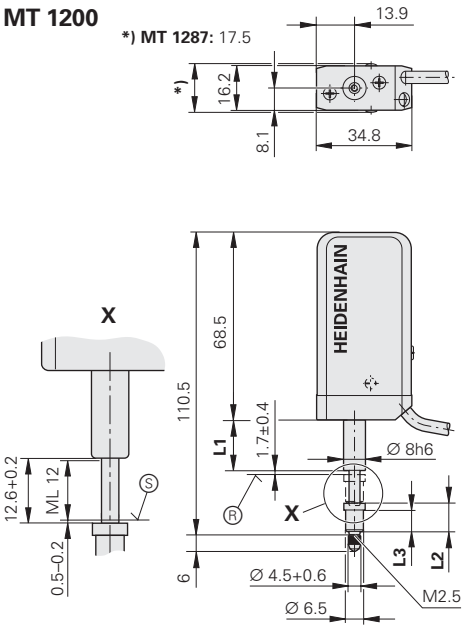


mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

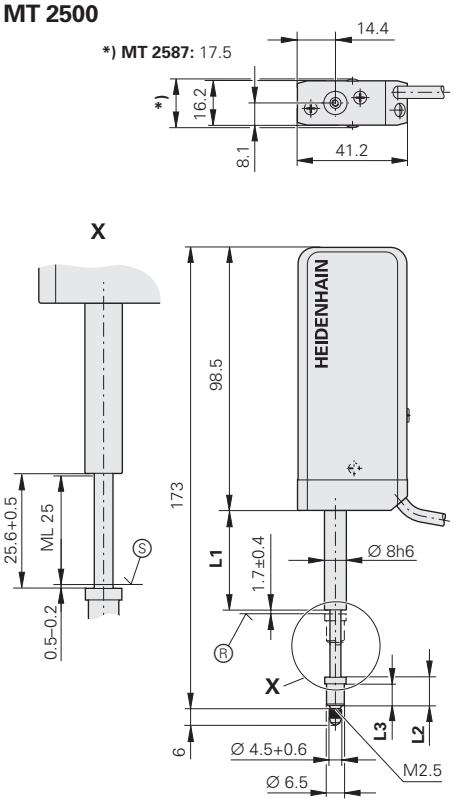
Ⓡ = Reference mark position
Ⓢ = Beginning of measuring length
Ⓗ = Air connection for 2 mm tube

MT 1200



	MT 12x1	MT 1287
L1	18.5	22.0
L2	10.1	6.2
L3	8.1	4.2

MT 2500



	MT 25x1	MT 2587
L1	37.0	41.0
L2	10.1	6.2
L3	8.1	4.2

Mechanical Data
Plunger actuation Position of plunger at rest
Measuring standard
System accuracy
Reference mark
Measuring range
Gauging force[1)] Vertically downward Vertically upward Horizontal *Version without spring* Vertically downward
Permissible radial force
Operating attitude
Vibration 55 to 2000 Hz **Shock** 11 ms
Protection IEC 60529
Operating temperature
Fastening
Weight without cable

Electrical Data *For length Gauges*
Incremental signals* **Signal period**
Recommd. meas. step
Mech. permissible traversing speed
Edge separation *a* at scanning frequency*/traverse speed 200 kHz ≤ 24 m/min 100 kHz ≤ 12 m/min 50 kHz ≤ 6 m/min 25 kHz ≤ 3 m/min
Electrical connection*
Cable length
Power supply

***** Please select when ordering

MT 1201 ∿ 11 μA_{PP} **MT 1271** ⊓⊔ TTL **MT 1281** ∿ 1 V_{PP}	**MT 2501** ∿ 11 μA_{PP} **MT 2571** ⊓⊔ TTL **MT 2581** ∿ 1 V_{PP}	**MT 1287** ∿ 1 V_{PP}	**MT 2587** ∿ 1 V_{PP}
By cable or measured object Extended		Pneumatic Retracted	
DIADUR phase grating on Zerodur® glass ceramic; grating period: 4 µm			
± 0.2 µm			
Approx. 1.7 mm below upper stop			
12 mm	25 mm	12 mm	25 mm
0.6 to 0.85 N 0.35 to 0.6 N 0.48 to 0.73 N 0.12 N	0.6 N 0.28 N 0.44 N 0.16 N	0.2 to 0.9 N 0.2 to 0.6 N 0.2 to 0.7 N	0.2 to 1.2 N 0.2 to 0.9 N 0.2 to 1.1 N
≤ 0.8 N			
Any; *for version without spring:* vertically downward			
≤ 100 m/s^2 (IEC 60 068-2-6) ≤ 1000 m/s^2 (IEC 60 068-2-27)			
IP 50		IP 64	
10 to 40 °C; ref. temperature 20 °C			
Clamping shank ∅ 8h6			
100 g	180 g	110 g	190 g

∿ 11 μA_{PP} *MT 1201* *MT 2501*	**⊓⊔ TTL** *MT 1271* *MT 2571*		**∿ 1 V_{PP}** *MT 128x* *MT 258x*
∿ 11 μA_{PP} 2 µm	⊓⊔ TTL x 5 0.4 µm	⊓⊔ TTL x 10 0.2 µm	∿ 1 V_{PP} 2 µm
0.1 µm/0.05 µm	0.1 µm[2)]	0.05 µm[2)]	0.1 µm/0.05 µm
≤ 30 m/min			
–	≥ 0.23 µs ≥ 0.48 µs ≥ 0.98 µs –	– ≥ 0.23 µs ≥ 0.48 µs ≥ 0.98 µs	–
Cable 1.5 m, with M23 connector	Cable 1.5 m with D-sub connector (with integral interface electronics)		Cable, 1.5 m with • M23 connector • D-sub connector
≤ 30 m with HEIDENHAIN cable			
5 V ± 5 %/< 50 mA	5 V ± 5 %/< 120 mA		5 V ± 5 %/< 50 mA

[1)] See also *Gauging Force—Plunger Actuation*
[2)] After 4-fold evaluation

MT 1200

MT 2500

HEIDENHAIN-METRO

Length Gauges with ± 0.5 µm/± 1 µm Accuracy

- **Large measuring ranges**
- **For dimensional and positional measurement**

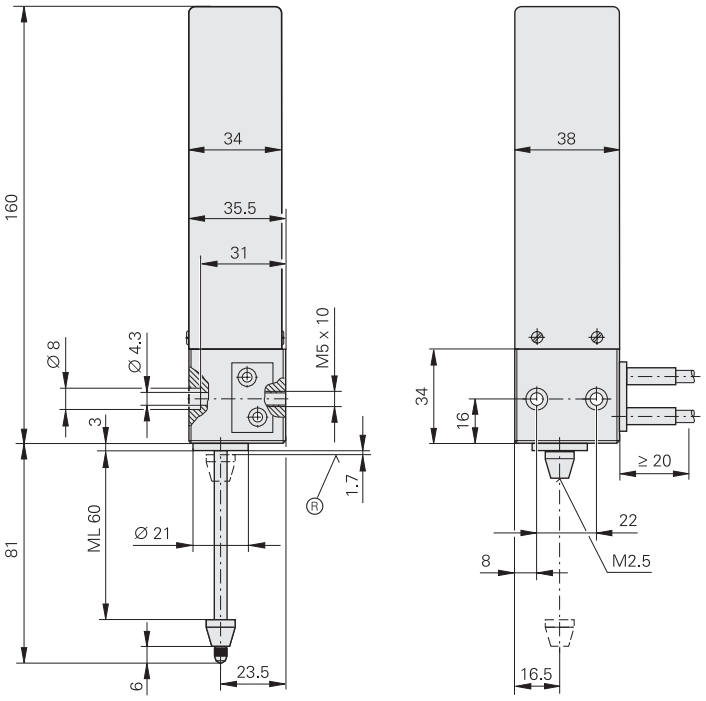
Large measuring ranges together with their high accuracy make the MT 60 and MT 101 HEIDENHAIN-METRO length gauges attractive for incoming inspection, production monitoring, quality control, or anywhere parts with very different dimensions are measured. But they are also easy to mount as highly accurate position encoders, for example on sliding devices or X-Y tables.

Plunger actuation
M version length gauges feature an integral motor that retracts and extends the plunger. While the MT 101 M operates at a constant gauging force, the MT 60 M allows you to select from three gauging force levels. **K version** gauges have no integral plunger actuation. The plunger is freely movable. It can be connected to moving elements such as linear slides and X-Y table by a coupling (see *Accessories*).

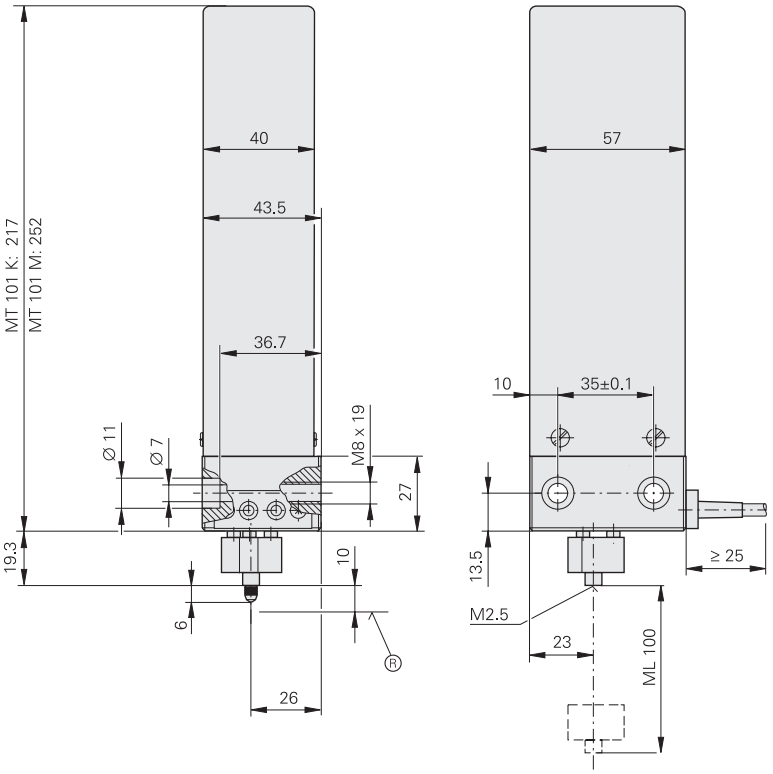
Mounting
The length gauges are mounted onto a flat surface by two screws. The M versions can also be mounted in the MS 100 and MS 200 gauge stands.

Output signals
The MT 60 and MT 101 provide
~ 11 μA_{PP} current signals for
HEIDENHAIN subsequent electronics.

MT 60



MT 101



mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm
Ⓡ = Reference mark position

Specifications		MT 60 M MT 60 K	MT 101 M MT 101 K
Plunger actuation	*MT xx M* *MT xx K*	Motorized Plunger connected via separate coupling with moving machine part	
Measuring standard		DIADUR grating on silica glass; grating period 10 µm	
System accuracy		± 0.5 µm	± 1 µm
Recommd. meas. step		1 µm to 0.1 µm	
Reference mark		Approx. 1.7 mm from top	Approx. 10 mm from top
Measuring range		60 mm	100 mm
Gauging force Vertically downward Vertically upward Horizontal		With MT 60 M 1 N/1.25 N/1.75 N – /– /0.75 N – /0.75 N/1.25 N	With MT 101 M 0.7 N with SG 101 V – 0.7 N with SG 101 H
Required moving force for MT xxK		0.1 to 0.6 N (depending on the operating attitude)	0.5 to 2 N (depending on the operating attitude)
Permissible radial force		≤ 0.5 N	≤ 2 N
Operating attitude	*MT xx M* *MT xx K*	Any Any	Vertically downward with SG 101 V Horizontal with SG 101 H Any
Vibration 55 to 2000 Hz **Shock** 11 ms		≤ 100 m/s^2 (IEC 60 068-2-6) ≤ 1000 m/s^2 (IEC 60 068-2-27)	
Protection IEC 60 529		IP 50	
Operating temperature		10 to 40 °C; ref. temperature 20 °C	
Fastening		Plane surface	
Weight without cable	*MT xx M* *MT xx K*	700 g 600 g	1400 g 1200 g
Incremental signals		∿ 11 µA$_{PP}$; signal period 10 µm	
Measuring velocity[1]		≤ 18 m/min	≤ 60 m/min
Electrical connection Cable length		Cable 1.5 m with M23 connector (male) 9-pin; ≤ 30 m with HEIDENHAIN cable	
Power supply	*MT xx M* *MT xx K* *Switch box*	5 V ± 5%/< 180 mA 5 V ± 5%/< 120 mA –	5 V ± 5%/< 180 mA 5 V ± 5%/< 120 mA Via power adapter

Required accessories		For MT 60 M	For MT 101 M
Switch box		SG 60 M	Vertical position: SG 101 V Horizontal position: SG 101 H
Power adapter	For 230 V For 110 V	– –	Id. Nr. 290 262-01 Id. Nr. 231 019-01

[1] Depending on the subsequent electronics

MT 60 M

MT 101 M

HEIDENHAIN-SPECTO

Length Gauges with ± 1 µm Accuracy

- **Very compact dimensions**
- **Splash-proof**

Thanks to their very small dimensions, the HEIDENHAIN-SPECTO length gauges are the product of choice for multipoint inspection apparatus and testing equipment.

Plunger actuation
The length gauges of the **ST 12x8** and **ST 30x8** series feature a spring-tensioned plunger that is extended at rest.

In the pneumatic length gauges **ST 12x7** and **ST 30x7** the plunger is retracted to its rest position by the integral spring. It is extended to the measuring position by the application of compressed air.

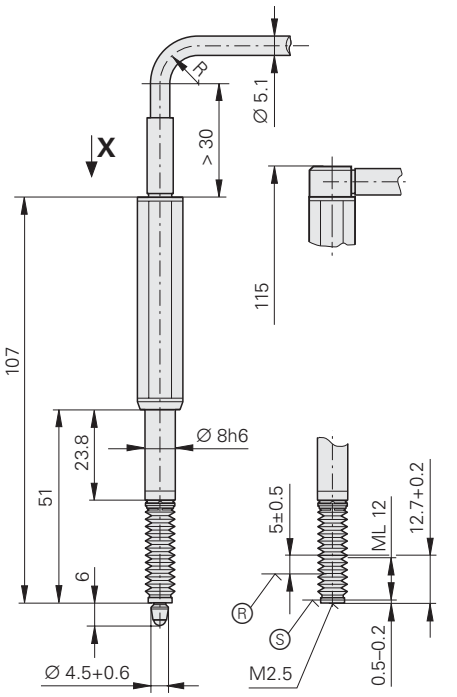
Mounting
The HEIDENHAIN-SPECTO length gauges are fastened by their 8h6 standard clamping shank.

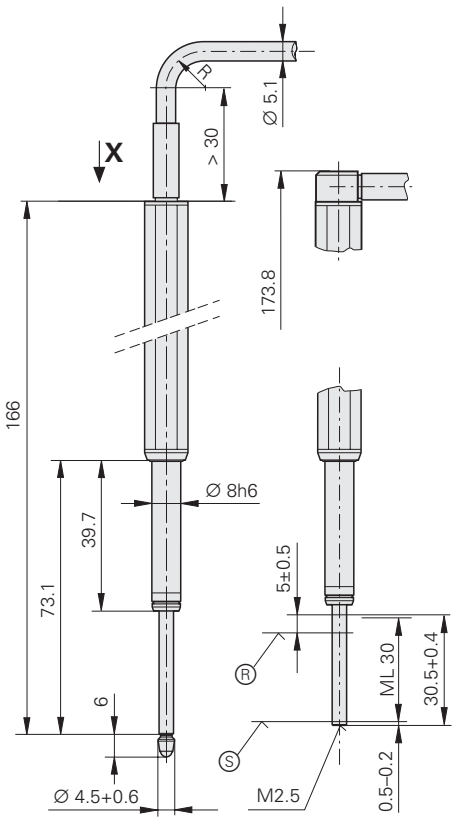
Output signals
The HEIDENHAIN-SPECTO length gauges are available with three different output signals.

The **ST 120x** and **ST 300x** versions supply sinusoidal current signals with **11 µA$_{PP}$** levels for HEIDENHAIN subsequent electronics.

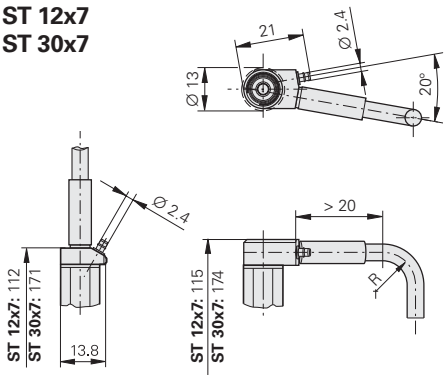
The **ST 128x** and **ST 308x** length gauges provide sinusoidal voltage signals with **1 V$_{PP}$** levels, which permit high interpolation.

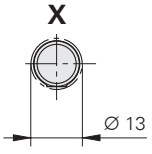
The **ST 127x** and **ST 307x** feature integrated digitizing and interpolation electronics with 5-fold or 10-fold interpolation (as ordered) and square-wave signals in **TTL** levels.





ST 12x7
ST 30x7





mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

Ⓡ = Reference mark position
Ⓢ = Beginning of measuring length

Mechanical Data
Plunger actuation Position of plunger at rest
Measuring standard
System accuracy
Reference mark
Measuring range
Gauging force with retracting plunger[1)] Vertically downward Vertically upward Horizontal
Permissible radial force
Operating attitude
Vibration 55 to 2000 Hz **Shock** 11 ms
Protection IEC 60529
Operating temperature
Fastening
Weight without cable

Electrical Data *For length Gauges*
Incremental signals* **Signal period**
Recommended measuring step
Mech. permissible traversing speed
Edge separation *a* at scanning frequency*/traverse speed 100 kHz ≤ 72 m/min[3)] 50 kHz ≤ 60 m/min 25 kHz ≤ 30 m/min
Electrical connection*
Cable outlet*
Cable length
Power supply

***** Please indicate when ordering
[1)] See also *Gauging Force—Plunger Actuation*

ST 1208 ∿ 11 μA_{PP} **ST 1278** ⊓⊔ TTL **ST 1288** ∿ 1 V_{PP}	**ST 3008** ∿ 11 μA_{PP} **ST 3078** ⊓⊔ TTL **ST 3088** ∿ 1 V_{PP}	**ST 1207** ∿ 11 μA_{PP} **ST 1277** ⊓⊔ TTL **ST 1287** ∿ 1 V_{PP}	**ST 3007** ∿ 11 μA_{PP} **ST 3077** ⊓⊔ TTL **ST 3087** ∿ 1 V_{PP}
By measured object Extended		Pneumatic Retracted	
DIADUR grating on glass; grating period 20 µm			
± 1 µm			
Approx. 5 mm below upper stop			
12 mm	30 mm	12 mm	30 mm
0.6 to 2.4 N 0.4 to 2.2 N 0.5 to 2.3 N	0.6 to 1.4 N 0.4 to 1.2 N 0.5 to 1.3 N	0.4 to 3.0 N depending on pressure and position	0.4 to 3.0 N depending on pressure and position
≤ 0.8 N			
Any			
≤ 100 m/s^2 (IEC 60 068-2-6) ≤ 1000 m/s^2 (IEC 60 068-2-27)			
IP 64 (for connecting elements see *Connecting Elements and Cables*)			
10 to 40 °C; ref. temperature 20 °C			
Clamping shank ∅ 8h6			
40 g	50 g	40 g	50 g

∿ 11 μA_{PP} *ST 120x* *ST 300x*	**⊓⊔ TTL** *ST 127x* *ST 307x*		**∿ 1 V_{PP}** *ST 128x* *ST 308x*
∿ 11 μA_{PP} 20 µm	⊓⊔ TTL x 5 4 µm	⊓⊔ TTL x 10 2 µm	∿ 1 V_{PP} 20 µm
1 µm/0.5 µm	1 µm[2)]	0.5 µm[2)]	1 µm/0.5 µm
≤ 72 m/min			
–	≥ 0.48 µs ≥ 0.98 µs ≥ 1.98 µs	≥ 0.23 µs ≥ 0.48 µs ≥ 0.98 µs	–
Cable 1.5 m with M23 connector	Cable 1.5 m with D-sub connector (with integral interface electronics)		Cable, 1.5 m with • M23 connector • D-sub connector
Axial or radial			
≤ 30 m with HEIDENHAIN cable			
5 V ± 10 %/< 35 mA	5 V ± 10 %/< 90 mA		5 V ± 10 %/< 40 mA

[2)] After 4-fold evaluation
[3)] Mechanically limited

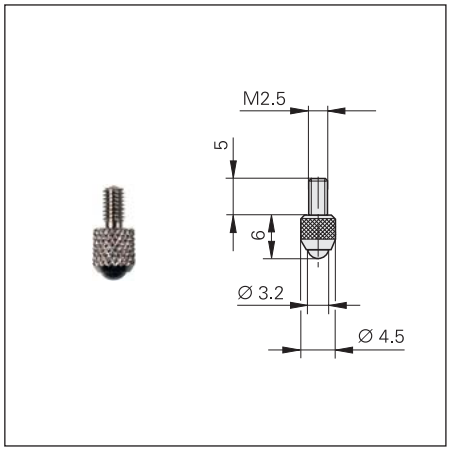
ST 1200

ST 3000

Accessories
Measuring Contacts

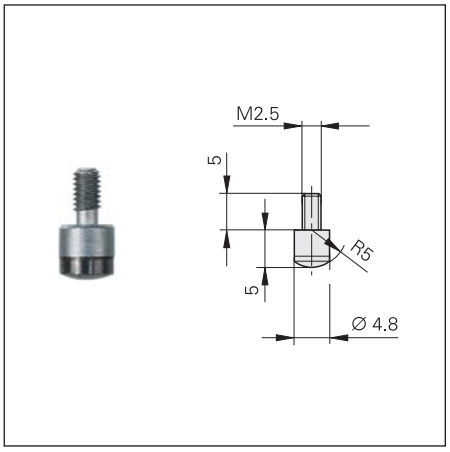
Ball-type contact

Steel	Id. Nr. 202504-01
Carbide	Id. Nr. 202504-02
Ruby	Id. Nr. 202504-03



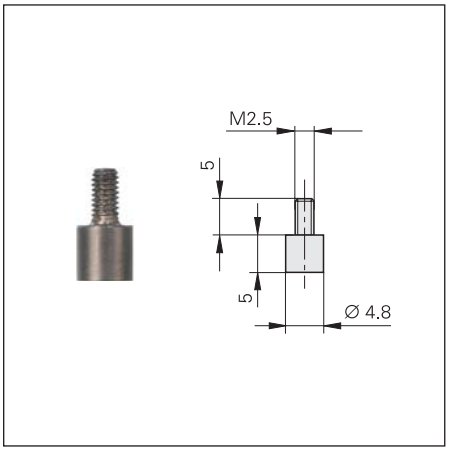
Domed contact

Carbide	Id. Nr. 229232-01



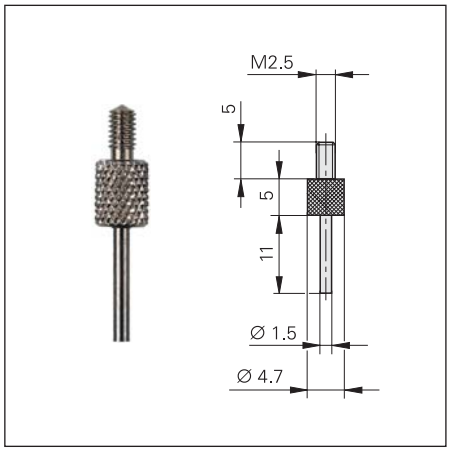
Flat contact

Steel	Id. Nr. 270922-01
Carbide	Id. Nr. 202506-01



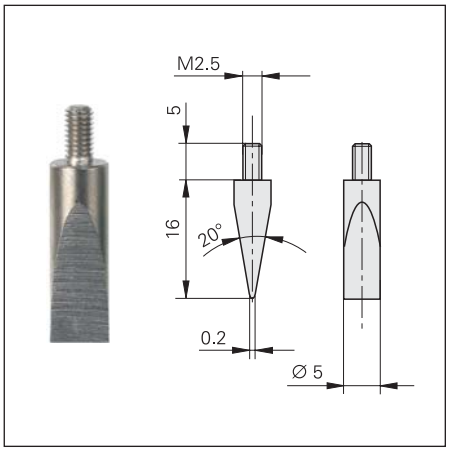
Pin-type contact

Steel	Id. Nr. 202505-01



Knife-edge contact

Steel	Id. Nr. 202503-01

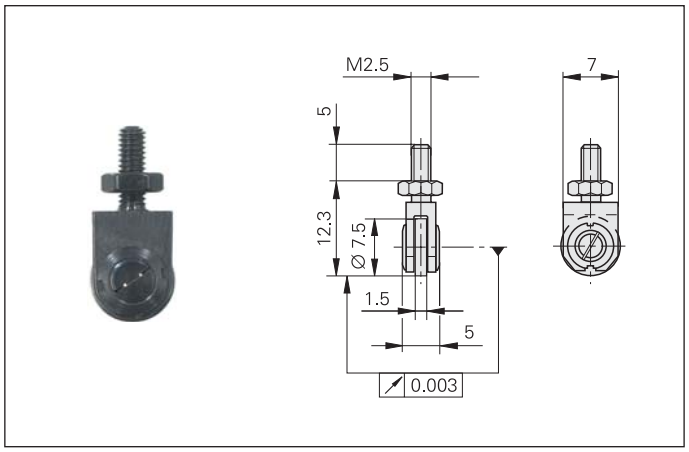


mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

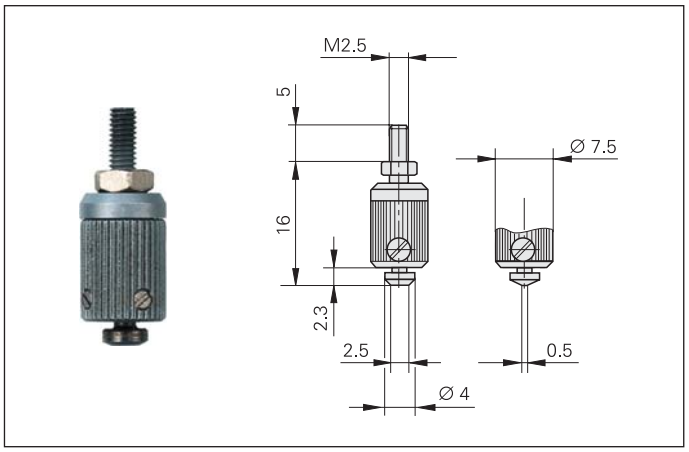
Roller contact, steel
For a low-friction contact with moving surfaces

Crowned	Id. Nr. 202502-03
Cylindrical	Id. Nr. 202502-04



Adjustable contact, carbide
For exact parallel alignment to the measuring plate surface

Flat	Id. Nr. 202507-01
Knife-edged	Id. Nr. 202508-01



Switch Boxes, Coupling

Switch boxes for CT 2501, CT 6001, MT 60 M, MT 101 M
Switch boxes are required for length gauges with motorized plunger actuation. The plunger is controlled through two push buttons or by external signal. The gauging force is adjustable at the SG 25 M and SG 60 M switch boxes in three stages.

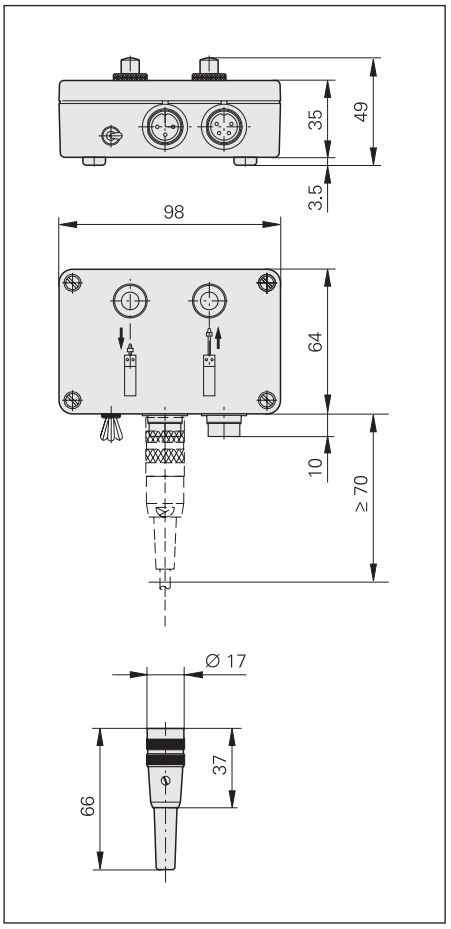
SG 25 M
Id. Nr.: 317 436-01

SG 60 M
Id. Nr.: 317 436-02

SG 101 V
For the MT 101 M in vertical operation
Id. Nr.: 361 140-01

SG 101 H
For the MT 101 M in horizontal operation
Id. Nr.: 361 140-02

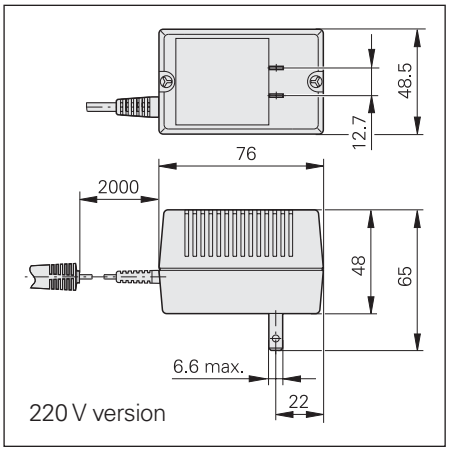
Connector (female) 3-pin
For external operation of the switch box
Id. Nr.: 340 646-05



Power adapter for SG 101 V/H
A power adapter connected to the switch box powers the MT 101 M.

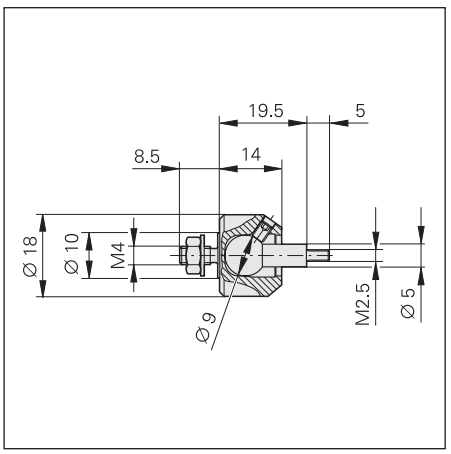
Power adapter 230 V
Id. Nr.: 290 262-01

Power adapter 110 V
Id. Nr.: 231 019-01



Coupling
For connecting the plunger of the length gauge (MT 60 K and MT 101 K) to a moving machine element

Id. Nr. 206 310-01



mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

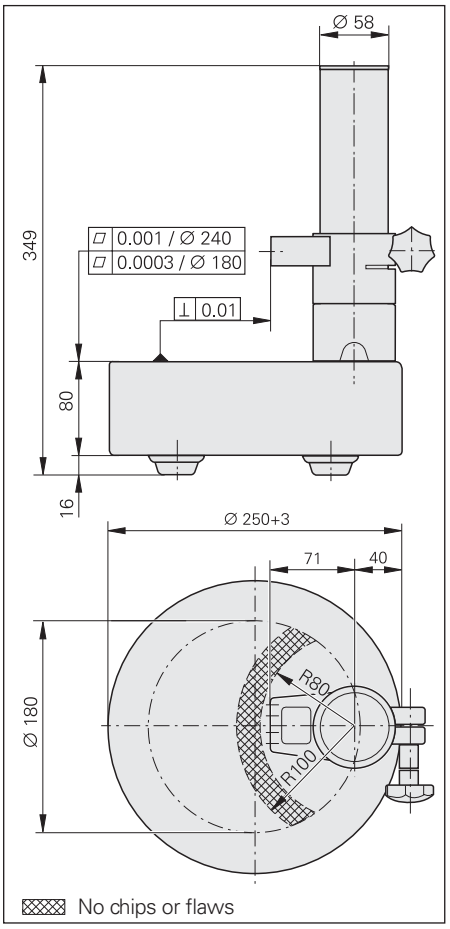
Accessories for HEIDENHAIN-CERTO
Gauge Stand

CS 200 Gauge Stand
For length gauges CT 2501*
CT 6001

Id. Nr.: 221310-01

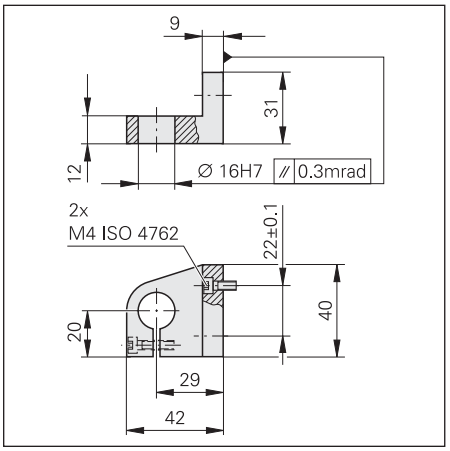
Total height	349 mm
Measuring plate	Ø 250 mm
Column	Ø 58 mm
Weight	15 kg

*) with special holder



Holder for CS 200
For the CT 2501 with
Ø 16 mm clamping shank

Id. Nr.: 324391-01



mm

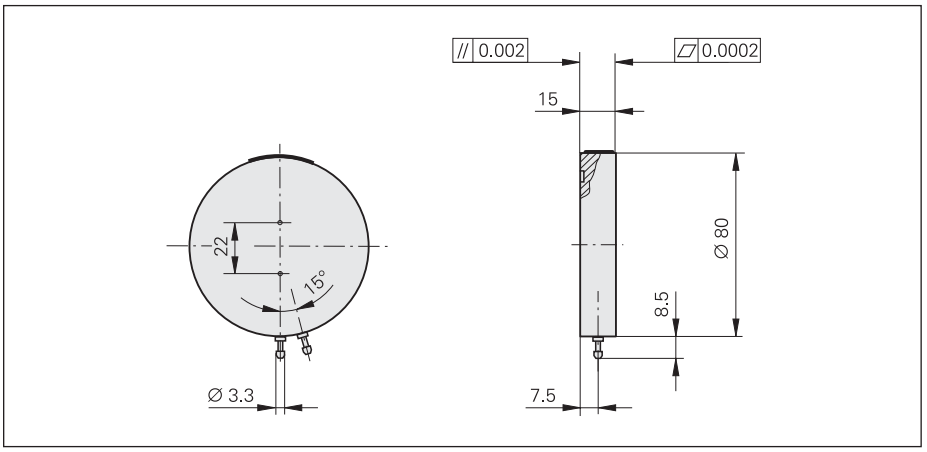
Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

Ceramic Suction Plate, Diaphragm Compressor

Ceramic suction plate
Wear-resistant working surface with high surface quality specifically for inspecting gauge blocks

Id. Nr.: 223 100-01

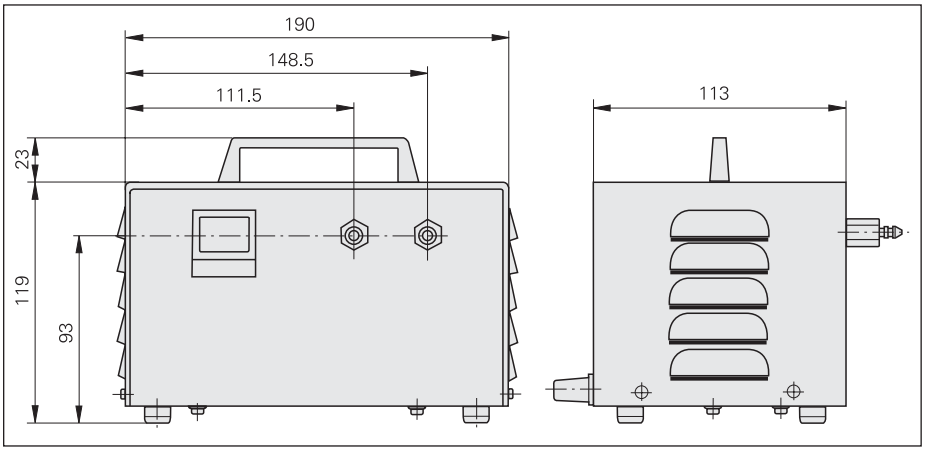
The gauge block (class 1 or 2)—or any other object with a plane surface—is drawn by suction onto the top of the ceramic plate. The ceramic plate is likewise drawn to the granite base and held in place through negative gauge pressure.



Diaphragm compressor
Source of suction for drawing the measured object and ceramic suction plate

Id. Nr.: 227 967-01

Line voltage	230 V/50 Hz
Power consumption	20 W
Weight	2.3 kg



Set of parts
Parts for connecting the ceramic suction plate with the diaphragm compressor.

Id. Nr.: 233 501-ZY

Compressed air tube, 3 m
T-joint
Connecting piece

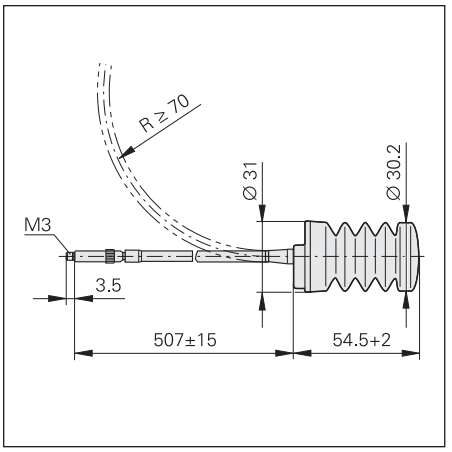
mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

Accessories for HEIDENHAIN-METRO and HEIDENHAIN-SPECTO
Cable-Type Lifter, Gauge Stands

Cable lifter
For manual plunger actuation of MT 1200 and MT 2500. The integral pneumatic damping reduces the plunger extension speed to prevent rebounding, for example on very hard materials.

Id. Nr. 257 790-01



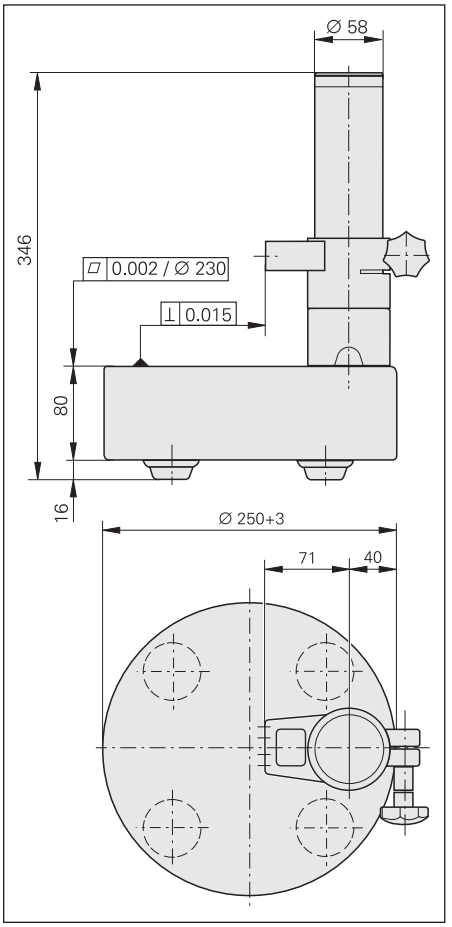
MS 200 Gauge Stand

For the models	ST*
	MT 1200*
	MT 2500*
	MT 60 M
	MT 101 M

Id. Nr.: 244 154-01

Total height	346 mm
Measuring plate	Ø 250 mm
Column	Ø 58 mm
Weight	18 kg

*) with special holder



Holder for MS 200
For mounting the length gauges with Ø 8 mm clamping shank, e.g. ST, MT 1200, MT 2500

Id. Nr. 324 391-02

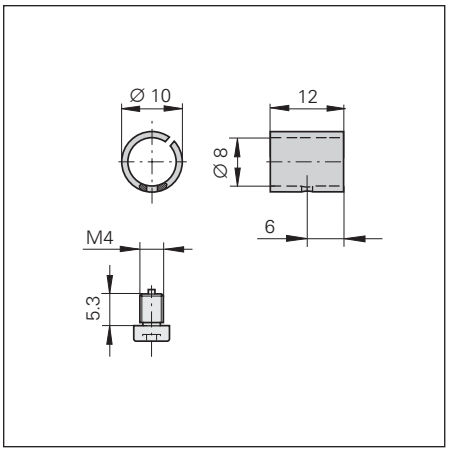
Clamping sleeve

For length gauges	ST
	MT 1200
	MT 2500

For fixing the length gauge reliably without overloading the 8h6 clamping shank.
Consisting of:
Sleeve, clamping screw
Id. Nr. 386 811-01 (1 pieces)
Id. Nr. 386 811-02 (10 pieces)

mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

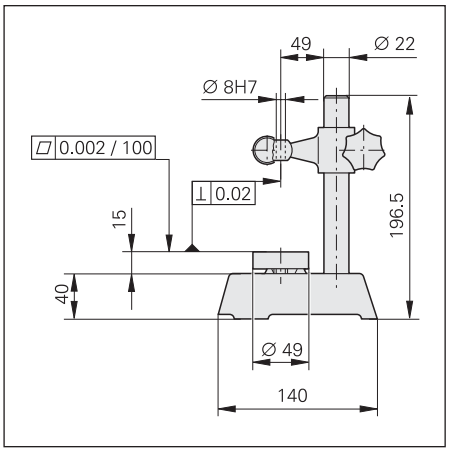


MS 45 Gauge Stand

For length gauges	ST MT 1200 MT 2500

Id. Nr.: 202 162-02

Total height	196.5 mm
Measuring plate	Ø 49 mm
Column	Ø 22 mm
Weight	2.2 kg



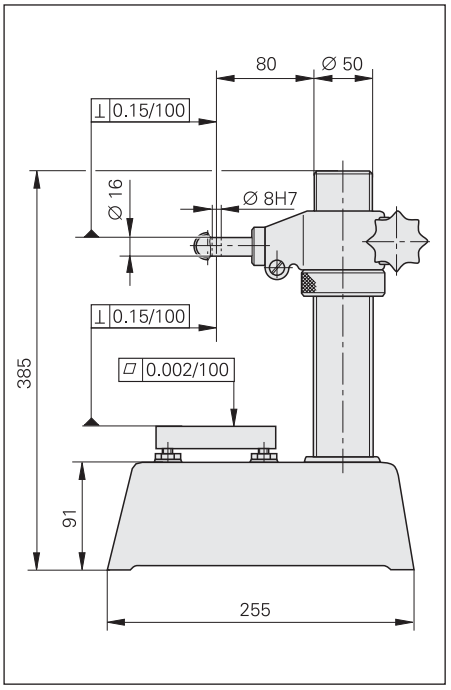
MS 100 Gauge Stand

For length gauges	ST MT 1200 MT 2500 MT 60 M* MT 101 M*

Id. Nr.: 202 164-02

Total height	385 mm
Measuring plate	100 mm x 115 mm
Column	Ø 50 mm
Weight	18 kg

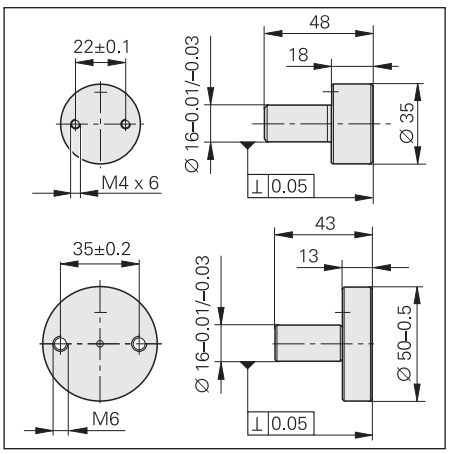
*) with special holder



Holder for MS 100

For mounting the MT 60 M
Id. Nr. 207 479-01

For mounting the MT 101 M
Id. Nr. 206 260-01



mm

Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

Measured Value Display Units
ND 200 B Series

The ND 200 B series offers display units for length gauges with sinusoidal output signals at 11 μA_{PP} levels. The ND 281 B can also support length gauges with sinusoidal 1 V_{PP} signals.

Features
The ND 281 B and ND 282 B provide functions for **sorting and tolerance checking** or for **minimum/maximum finding** from a series of measurements. The ND 231 B with **sum/difference display** can display the output from two length gauges. With their **switching inputs and outputs,** these length gauges are also ideal for simple automation tasks.

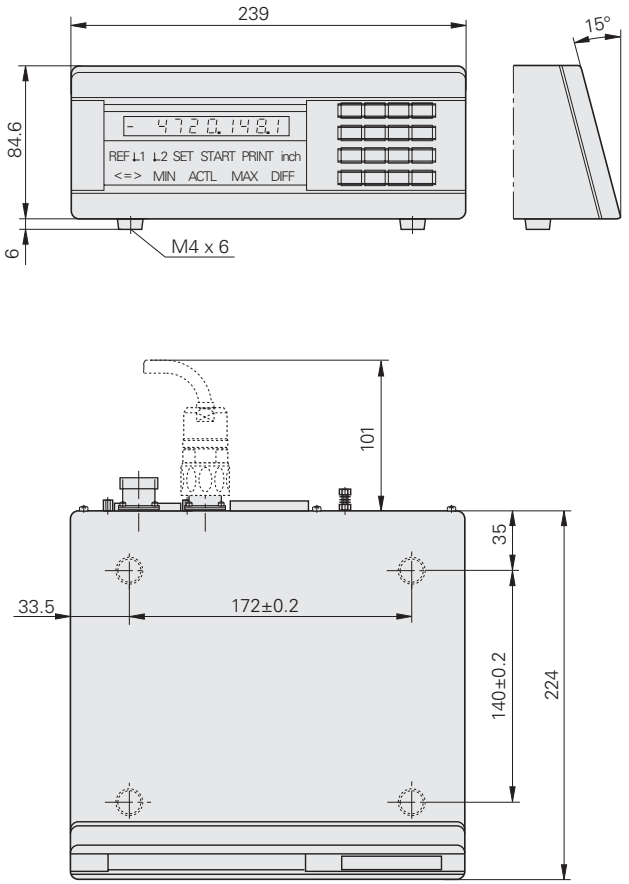
Data interfaces
To transmit the results of measurements at inspection stations through a data interface to a printer or to a PC for further processing, the length gauges feature a serial **RS-232-C/V.24** data interface or a parallel **BCD** output.

RS-232-C/V.24
The ND 221 B, ND 231 B and ND 281 B are equipped with the **serial** RS-232-C interface according to EIA standards, also known as the V.24 interface according to CCITT recommendation. The data transfer rate is adjustable from 110 to 38 400 baud.

Accessories:
Data transfer cable RS-232-C
Wired with a 25-pin D-sub male connector and a 9-pin D-sub female connector
Id. Nr. 368 017-xx

BCD
The ND 282 B transmits the measured value **parallel** in binary-coded decimal code (BCD) in TTL levels.

The **data output** can be started at the ND keyboard, through an external command, through the RS-232-C/V.24 software command Ctrl B, or with BCD over an adjustable internal clock. This places the measured value in a buffer memory and then transmits it.



mm
Tolerancing ISO 8015
ISO 2768 - m H
< 6 mm: ±0.2 mm

ND 221 B	ND 281 B	ND 282 B	ND 231 B
1 x ∿ 11 μA_{PP}	1 x ∿ 11 μA_{PP} or 1 x ∿ 1 V_{PP} selectable	1 x ∿ 11 μA_{PP}	2 x ∿ 11 μA_{PP}
≤ 100 kHz	*11 μA_{PP}:* ≤ 100 kHz *1 V_{PP}:* ≤ 500 kHz	≤ 50 kHz	≤ 100 kHz
Up to 1024-fold		Up to 200-fold	Up to 1024-fold
0.002 µm to 5 µm		0.1 µm to 5 µm	0.002 µm to 5 µm
Position values in 9 decades plus sign; REF, inch, datum 1/datum 2, SET datum setting			
Scaling factor (SCL)	PRINT, MIN/MAX/DIFF/ACTL, START, sorting (< = >), scaling factor (SCL)		
• REF reference mark evaluation for distance-coded or single reference marks • Two reference points; fast zero reset			
–	• Sorting and tolerance check mode • Minimum/maximum value storage		• Sorting and tolerance check mode • Sum/difference display
Linear and nonlinear over 64 points			
RS-232-C/V.24		BCD	RS-232-C/V.24
110 to 38 400 baud		0.2 µs to 25.6 µs[2]	110 to 38 400 baud
–	• Zero crossover • Switching points 1 and 2 • Sorting signals "<" and ">" • Error		
–	• Zero reset, preset • Measured value output, display freeze if necessary (pulse or contact) • Pass over reference point • Inhibit reference pulse X1		
	• External MIN/MAX selection • MIN display • MAX display • DIFF display • Start measurement series		• X1 or X2 display • Sum display • Difference display • Inhibit reference pulse X2
	–	Deactivate BCD	–
Primary-clocked power supply 100 Vac to 240 Vac (–15% to +10%) 50 Hz to 60 Hz (±2 Hz)			
8 W			
0 °C to 45 °C			
IP 40, front panel IP 54			
1.5 kg			

[1] Depends on the signal period of the connected length gauge
[2] Latch rate with fast concurrent BCD output

Features of the Display Units

The display units feature user-oriented functions that, together with a length gauge, form a stand-alone measuring station.

REF reference mark evaluation
When the power is turned off or unintentionally interrupted, the assignment of display values to plunger positions as last established by a zero reset or datum setting becomes lost. With the aid of the reference mark evaluation feature (REF), the assignment can be recovered simply by crossing over the reference mark.

Reference points
The ND 200 series display units allow you to set two datum points. A simple touch of a key switches from one datum point to the other.

Changing the counting direction
You can assign the positive counting direction to plunger retraction or extension as desired.

Changing the display step
The display step can be easily switched to adjust to the respective application.

Switching outputs
Switching outputs are available for semi-automatic positioning tasks. These can be used, for example, for deceleration and limit stop activation.

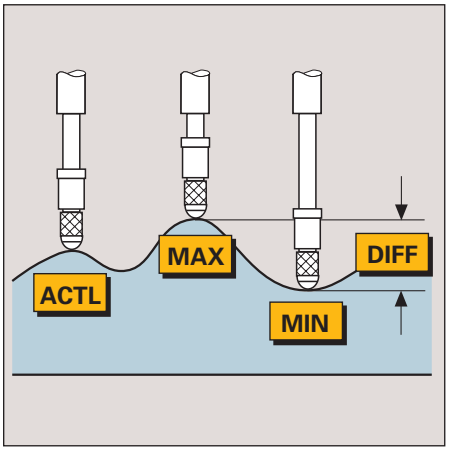
Maximum/minimum value storage
The **ND 281 B** and **ND 282 B** displays can store the maximum and minimum value from a series of measurements. A measurement series is started either on the keypad or by a switching input at the D-sub connection.

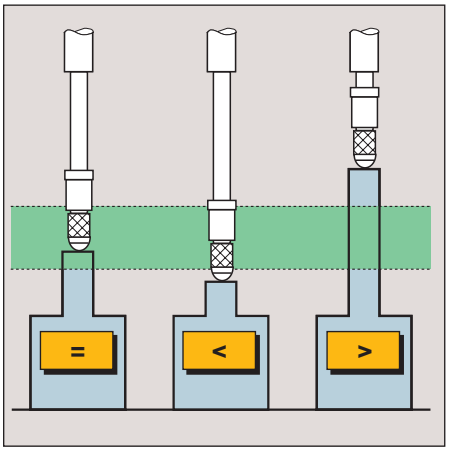
At the beginning of a measuring series the display unit saves the first measured value in its minimum/maximum value memory. Every 0.5 ms the display then compares the current measured value with the values in memory; it stores a new value if the measurement is greater than the stored maximum or less than the stored minimum value.

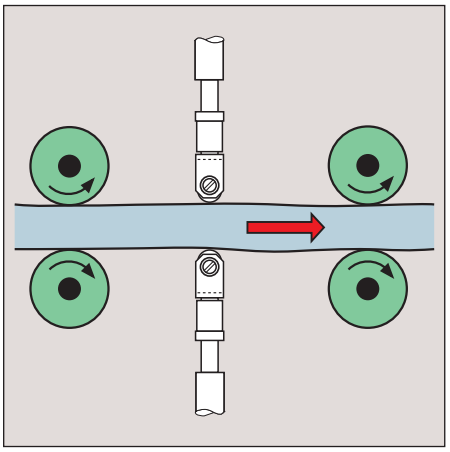
The minimum, the maximum, the difference between the two values, or the current measured value can be called either via the keypad or through a switching input of the D-sub connection.

Sorting and tolerance check mode
The **ND 231 B, ND 281 B** and **ND 282 B** displays can check parts for dimensional accuracy and sort them into classes. To sort the parts, the display unit compares the displayed measured value with an upper and lower limit value previously entered with the keypad. The result of the evaluation (whether the measured value is below, above or within tolerance) is indicated in the status display with one of the symbols <, = or >. In addition, a corresponding signal is available at the switching outputs (D-sub).

Sum/difference display
The **ND 231 B** has two length gauge inputs. The ND 231 B calculates the sum or difference of the two measured values and displays the result. The measured values from the two length gauges can also be displayed individually.







Counter Cards

IK 220
Universal PC counter card
The IK 220 is an expansion board for AT-compatible PCs for recording the measured values of **two incremental or absolute linear or angle encoders.** The subdivision and counting electronics **subdivide** the **sinusoidal input signals** up to **4096-fold.** A driver software package is included in delivery.

For more information, see the *IK 220 Product Information sheet*.

	IK 220			
Input signals (switchable)	~ 1 V_{PP}	~ 11 μA_{PP}	EnDat 2.1	SSI
Encoder inputs	Two D-sub connectors (15-pin), male			
Input frequency	≤ 500 kHz	≤ 33 kHz	–	
Cable length	≤ 60 m		≤ 10 m	
Signal subdivision (signal period: meas. step)	Up to 4096-fold			
Data register for measured values (per channel)	48 bits (44 bits used)			
Internal memory	For 8192 position values			
Interface	PCI bus (plug and play)			
Driver software and demonstration program	**For WINDOWS 98/NT/2000/XP** In VISUAL C++, VISUAL BASIC and BORLAND DELPHI			
Dimensions	Approx. 190 mm × 100 mm			

Interfaces
Incremental Signals ∿ 1 V_{PP}

HEIDENHAIN encoders with ∿ 1 V_{PP} interface provide voltage signals that can be highly interpolated.

The sinusoidal **incremental signals** A and B are phase-shifted by 90° elec. and have an amplitude of typically 1 V_{PP} . The illustrated sequence of output signals—with B lagging A—applies for the direction of motion shown in the dimension drawing.

The **reference mark signal** R has a usable component *G* of approx. 0.5 V. Next to the reference mark, the output signal can be reduced by up to 1.7 V to a quiescent value *H*. This must not cause the subsequent electronics to overdrive. Even at the lowered signal level, signal peaks with the amplitude *G* can also appear.

The data on **signal amplitude** apply when the power supply given in the specifications is connected to the encoder. They refer to a differential measurement at the 120 ohm terminating resistor between the associated outputs. The signal amplitude decreases with increasing frequency. The **cutoff frequency** indicates the scanning frequency at which a certain percentage of the original signal amplitude is maintained:

- –3 dB cutoff frequency: 70 % of the signal amplitude
- –6 dB cutoff frequency: 50 % of the signal amplitude

Interpolation/resolution/measuring step
The output signals of the 1 V_{PP} interface are usually interpolated in the subsequent electronics in order to attain sufficiently high resolutions. For **velocity control,** interpolation factors are commonly over 1000 in order to receive usable velocity information even at low speeds.

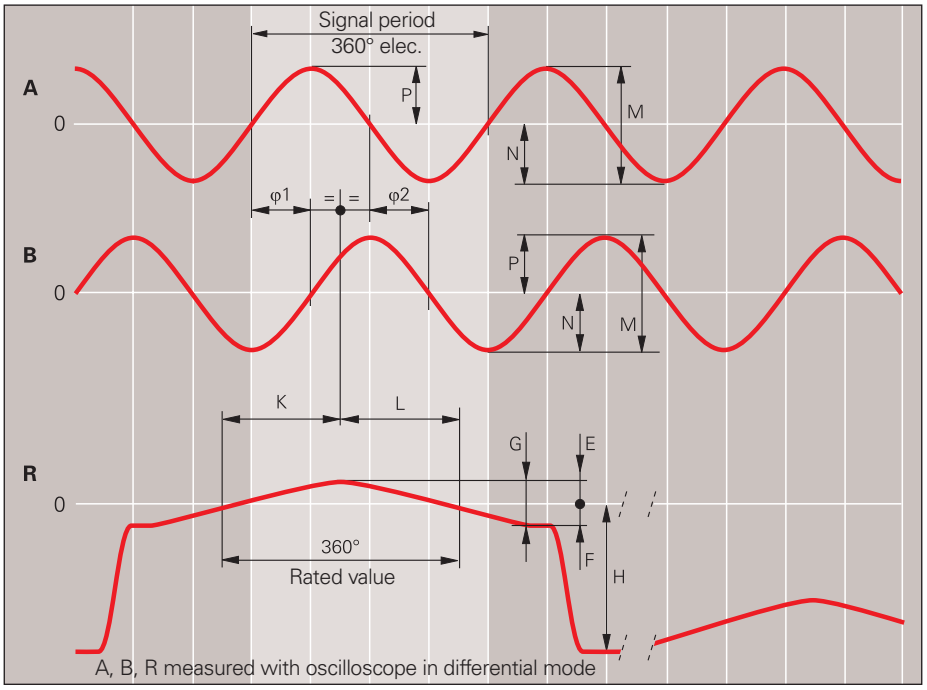
Measuring steps for **position measurement** are recommended in the specifications. For special applications, other resolutions are also possible.

Short-circuit stability
A temporary short circuit of one output to 0 V or U_P does not cause encoder failure, but it is not a permissible operating condition.

Short circuit at	20 °C	125 °C
One output	< 3 min	< 1 min
All outputs	< 20 s	< 5 s

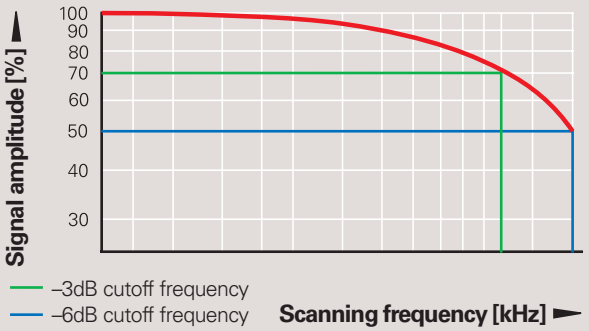
Interface	Sinusoidal voltage signals ∿ **1 V_{PP}**
Incremental signals	**2 nearly sinusoidal signals A and B** Signal amplitude M: 0.6 to 1.2 V_{PP}; typically 1 V_{PP} Asymmetry |P – N|/2M: ≤ 0.065 Amplitude ratio M_A/M_B: 0.8 to 1.25 Phase angle |φ1 + φ2|/2: 90° ± 10° elec.
Reference mark signal	**1 or more signal peaks R** Usable component G: 0.2 to 0.85 V Quiescent value H: 0.04 V to 1.7 V Switching threshold E, F: ≥ 40 mV Zero crossovers K, L: 180° ± 90° elec.
Connecting cable Cable length Propagation time	HEIDENHAIN cable with shielding PUR [4(2 x 0.14 mm²) + (4 x 0.5 mm²)] Max. 150 m distributed capacitance 90 pF/m 6 ns/m

Any limited tolerances in the encoders are listed in the specifications.



A, B, R measured with oscilloscope in differential mode

Cutoff frequency
Typical signal amplitude curve with respect to the scanning frequency



Input circuitry of the subsequent electronics

Dimensioning
Operational amplifier MC 34074
Z_0 = 120 Ω
R_1 = 10 kΩ and C_1 = 100 pF
R_2 = 34.8 kΩ and C_2 = 10 pF
U_B = ±15 V
U_1 approx. U_0

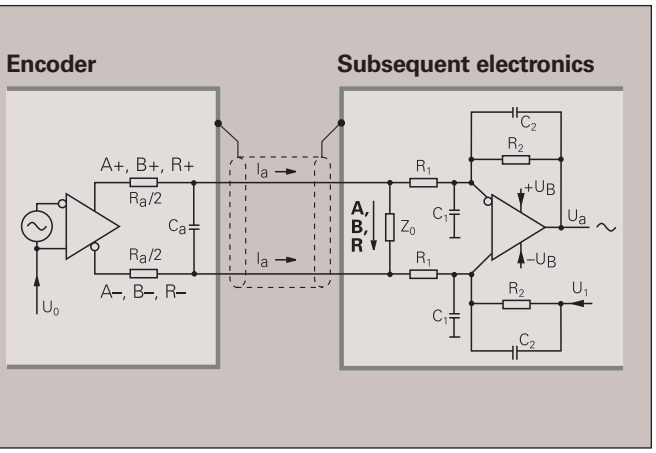
–3dB cutoff frequency of circuitry
Approx. 450 kHz
Approx. 50 kHz with C_1 = 1000 pF
and C_2 = 82 pF
The circuit variant for 50 kHz does reduce the bandwidth of the circuit, but in doing so it improves its noise immunity.

Circuit output signals
U_a = 3.48 V_{PP} typical
Gain 3.48

Signal monitoring
A threshold sensitivity of 250 mV_{PP} is to be provided for monitoring the 1 V_{PP} incremental signals.

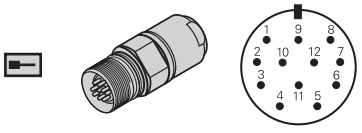
Incremental signals
Reference mark signal

R_a < 100 Ω,
typically 24 Ω
C_a < 50 pF
ΣI_a < 1 mA
U_0 = 2.5 V ± 0.5 V
(relative to 0 V of the power supply)

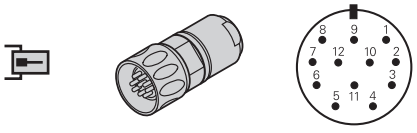


Pin Layout

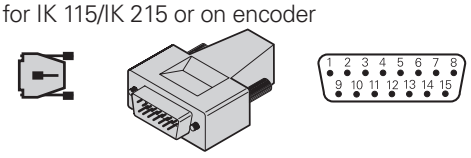
12-pin coupling M23



12-pin connector M23



15-pin D-sub connector
for IK 115/IK 215 or on encoder



	Power supply				Incremental signals						Other signals		
	12	**2**	**10**	**11**	**5**	**6**	**8**	**1**	**3**	**4**	**9**	**7**	**/**
	4	**12**	**2**	**10**	**1**	**9**	**3**	**11**	**14**	**7**	**5/8/13/15**	**14**	**/**
	U_P	**Sensor** U_P	**0 V**	**Sensor** 0 V	**A+**	**A–**	**B+**	**B–**	**R+**	**R–**	**Vacant**	**Vacant**	**Vacant**
	Brown/ Green	Blue	White/ Green	White	Brown	Green	Gray	Pink	Red	Black	/	Violet	Yellow

Shield on housing; **U_P** = power supply voltage
Sensor: The sensor line is connected internally with the corresponding power line

Interfaces
Incremental signals ⊓⊔ TTL

HEIDENHAIN encoders with ⊓⊔ TTL interface incorporate electronics that digitize sinusoidal scanning signals with or without interpolation.

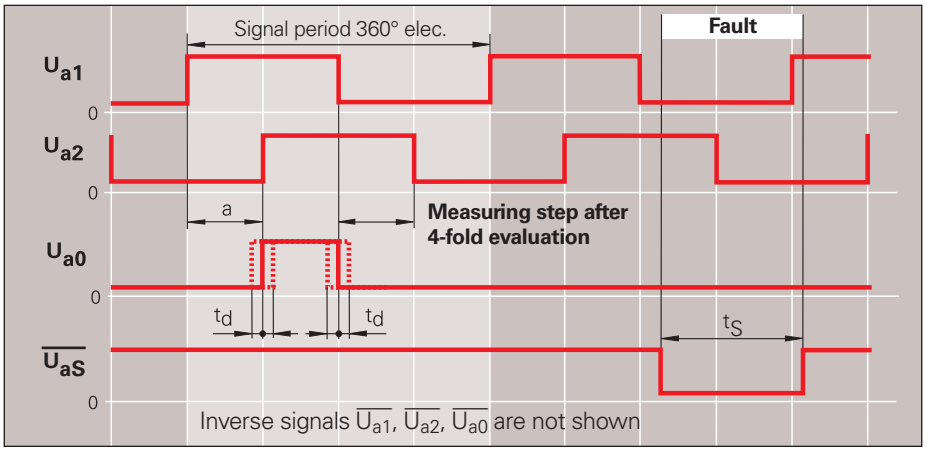
The **incremental signals** are transmitted as the square-wave pulse trains U_{a1} and U_{a2}, phase-shifted by 90° elec. The **reference mark signal** consists of one or more reference pulses U_{a0}, which are gated with the incremental signals. In addition, the integrated electronics produce their **inverse signals** $\overline{U_{a1}}$, $\overline{U_{a2}}$ and $\overline{U_{a0}}$ for noise-proof transmission. The illustrated sequence of output signals—with U_{a2} lagging U_{a1}—applies for the direction of motion shown in the dimension drawing.

The **fault-detection signal** $\overline{U_{aS}}$ indicates fault conditions such as breakage of the power line or failure of the light source. It can be used for such purposes as machine shut-off during automated production.

The distance between two successive edges of the incremental signals U_{a1} and U_{a2} through 1-fold, 2-fold or 4-fold evaluation is one **measuring step.**

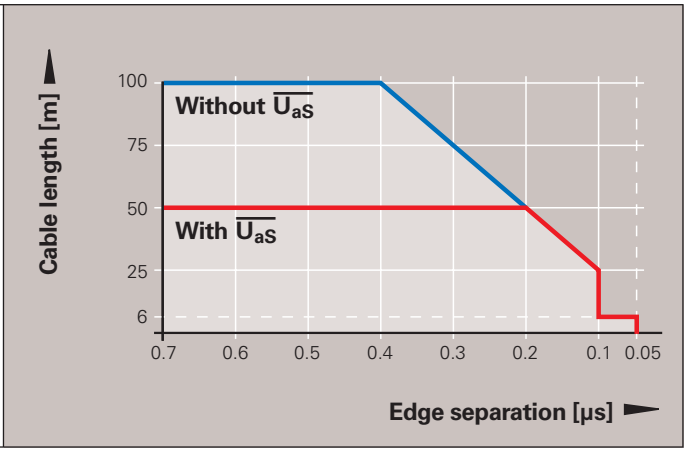
The subsequent electronics must be designed to detect each edge of the square-wave pulse. The minimum **edge separation *a*** listed in the *Specifications* applies for the illustrated input circuitry with a cable length of 1 m, and refers to a measurement at the output of the differential line receiver. Propagation-time differences in cables additionally reduce the edge separation by 0.2 ns per meter of cable length. To prevent counting error, design the subsequent electronics to process even as little as 90% of the resulting edge separation. The max. permissible **shaft speed** or **traversing velocity** must never be exceeded.

Interface	Square-wave signals ⊓⊔ **TTL**
Incremental signals	**2 TTL square-wave signals U_{a1}, U_{a2}** and their inverted signals **$\overline{U_{a1}}$, $\overline{U_{a2}}$**
Reference mark signal Pulse width Delay time	**1 or more square-wave pulses U_{a0}** and their inverted pulses **$\overline{U_{a0}}$** 90° elec. (other widths available on request); *LS 323:* ungated $\lvert t_d \rvert \leq 50$ ns
Fault detection signal Pulse width	**1 TTL square-wave pulse $\overline{U_{aS}}$** Improper function: LOW (upon request: U_{a1}/U_{a2} at high impedance) Proper function: HIGH $t_S \geq 20$ ms
Signal level	Differential line driver as per EIA standard RS-422 $U_H \geq 2.5$ V at $-I_H = 20$ mA $U_L \leq 0.5$ V at $I_L = 20$ mA
Permissible load	$Z_0 \geq 100\ \Omega$ between associated outputs $\lvert I_L \rvert \leq 20$ mA max. load per output $C_{load} \leq 1000$ pF with respect to 0 V Outputs protected against short circuit to 0 V
Switching times (10% to 90%)	t+ / t– ≤ 30 ns (typically 10 ns) with 1 m cable and recommended input circuitry
Connecting cable Cable length Propagation time	HEIDENHAIN cable with shielding PUR [4(2 × 0.14 mm²) + (4 × 0.5 mm²)] Max. 100 m ($\overline{U_{aS}}$ max. 50 m) distributed capacitance 90 pF/m 6 ns/m



The permissible **cable length** for transmission of the TTL square-wave signals to the subsequent electronics depends on the edge separation *a*. It is max. 100 m, or 50 m for the fault detection signal. This requires, however, that the power supply (see *Specifications*) be ensured at the encoder. The sensor lines can be used to measure the voltage at the encoder and, if required, correct it with an automatic system (remote sense power supply).

Permissible cable length
with respect to the edge separation

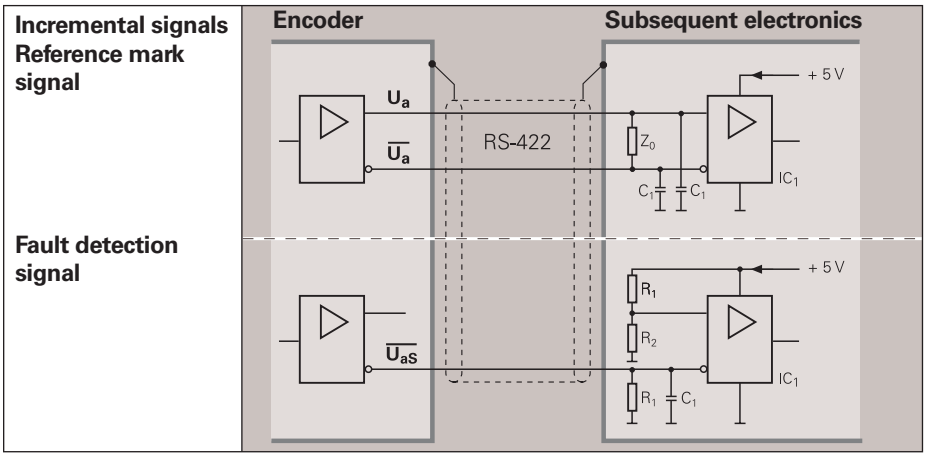


Input circuitry of the subsequent electronics

Dimensioning

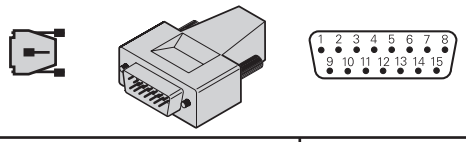
IC_1 = Recommended differential line receiver
DS 26 C 32 AT
Only for $a > 0.1$ µs:
AM 26 LS 32
MC 3486
SN 75 ALS 193

R_1 = 4.7 kΩ
R_2 = 1.8 kΩ
Z_0 = 120 Ω
C_1 = 220 pF (serves to improve noise immunity)

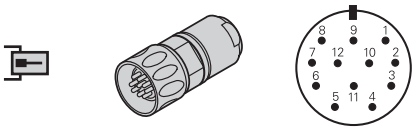


Pin Layout

15-pin D-sub connector at encoder



12-pin HEIDENHAIN connector



	Power supply				Incremental signals						Other signals		
	12	**2**	**10**	**11**	**5**	**6**	**8**	**1**	**3**	**4**	**7**	**/**	**9**
	4	**12**	**2**	**10**	**1**	**9**	**3**	**11**	**14**	**7**	**13**	**5/6/8**	**15**
	U_P	**Sensor** U_P	**0 V**	**Sensor** 0 V	**U_{a1}**	**$\overline{U_{a1}}$**	**U_{a2}**	**$\overline{U_{a2}}$**	**U_{a0}**	**$\overline{U_{a0}}$**	**$\overline{U_{aS}}$** [1]	**Vacant**	**Vacant** [2]
	Brown/ Green	Blue	White/ Green	White	Brown	Green	Gray	Pink	Red	Black	Violet	–	Yellow

Shield on housing; **U_P** = Power supply
Sensor: The sensor line is connected internally with the corresponding power line
[1] **LS 323:** Vacant [2] **Exposed linear encoders:** Switchover TTL/11 μA_{PP} for PWT

Interfaces
Incremental Signals ∿ 11 μA_{PP}

HEIDENHAIN encoders with ∿11 μA_{PP} interface provide current signals. They are intended for connection to ND measured value display units or EXE pulse-shaping electronics from HEIDENHAIN.

The sinusoidal **incremental signals** I_1 and I_2 are phase-shifted by 90° elec. and have signal levels of approx. 11 μA_{PP}.
The illustrated sequence of output signals—I_2 lagging I_1—applies for the retracting plunger.

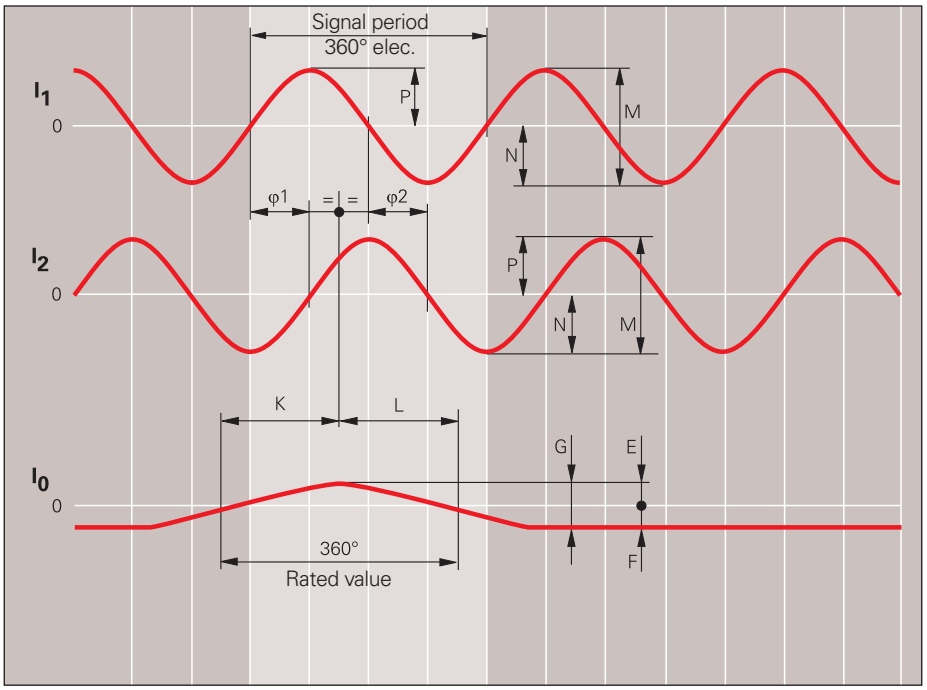
The **reference mark signal** I_0 has a usable component *G* of approx. 5.5 µA.

The data on **signal amplitude** apply when the power supply given in the *Specifications* is connected at the encoder. They refer to a differential measurement between the associated outputs. The signal amplitude decreases with increasing frequency. The **cutoff frequency** indicates the scanning frequency at which a certain percentage of the original signal amplitude is maintained:
- –3 dB cutoff frequency:
  70 % of the signal amplitude
- –6 dB cutoff frequency:
  50 % of the signal amplitude

Interpolation/resolution/measuring step
The output signals of the 11 μA_{PP} interface are usually interpolated in the subsequent electronics in order to attain sufficiently high resolutions.

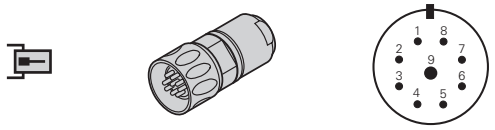
Measuring steps for **position measurement** are recommended in the *Specifications*. For special applications, other resolutions are also possible.

Interface	Sinusoidal current signals ∿ **11 μA_{PP}**
Incremental signals	**2 nearly sinusoidal signals I_1 and I_2** Signal amplitude M: 7 to 16 μA_{PP}/typically 11 μA_{PP} Asymmetry IP – NI/2M: ≤ 0.065 Amplitude ratio M_A/M_B: 0.8 to 1.25 Phase angle Iφ1 + φ2I/2: 90° ± 10° elec.
Reference mark signal	**1 or more signal peaks I_0** Usable component G: 2 to 8.5 µA Switching threshold E, F: ≥ 0.4 µA Zero crossovers K, L: 180° ± 90° elec.
Connecting cable Cable length Propagation time	HEIDENHAIN cable with shielding PUR [3(2 · 0.14 mm^2) + (2 · 1 mm^2)] Max. 30 m distributed capacitance 90 pF/m 6 ns/m



Pin Layout

9-pin HEIDENHAIN connector



	Power supply				Incremental signals					
	3	**4**	**Housing**	**9**	**1**	**2**	**5**	**6**	**7**	**8**
	U_P	**0 V**	**External shield**	**Inside shield**	**I_1 +**	**I_1 –**	**I_2 +**	**I_2 –**	**I_0 +**	**I_0 –**
	Brown	White	–	White/ Brown	Green	Yellow	Blue	Red	Gray	Pink

U_P = power supply voltage
Vacant pins or wires must not be used!

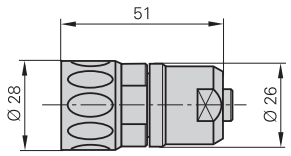
Shield on housing
Color assignment applies only to extension cable.

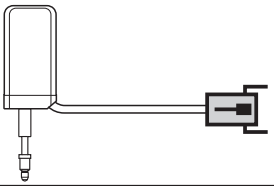
Connecting Elements and Cables

Connector insulated: Connecting element with coupling ring, available with male or female contacts.

Symbols

M23





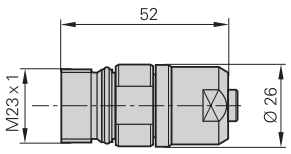
PUR connecting cable for ∿ 1 V_{PP} interface
12-pin: [4(2 × 0.14 mm²) + (4 × 0.5 mm²)] **Ø 8 mm**
M23 connecting element, 12-pin
D-sub connector, 15-pin

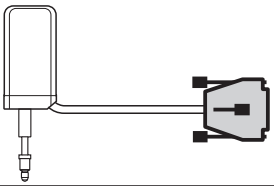
Complete For ND 281 B		298 400-xx
Complete For IK 220, POSITIP, ND 780		309 783-xx
With one connector		298 402-xx

Coupling insulated:
Connecting element with external thread; Available with male or female contacts.

Symbols

M23



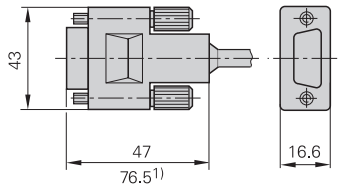


PUR connecting cable for ∿ 1 V_{PP} interface
for ⊓⊔ TTL interface
12-pin: [4(2 × 0.14 mm²) + (4 × 0.5 mm²)] **Ø 8 mm**
M23 connecting element, 12-pin
D-sub connector, 15-pin

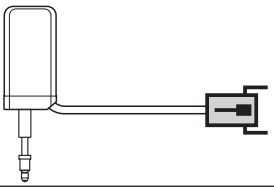
Complete		331 693-xx
Complete For IK 220, POSITIP, ND 780		335 077-xx
With one connector		332 433-xx

D-sub connector: For HEIDENHAIN controls, counters and IK absolute value cards.

Symbols



1) On the length gauge



PUR connecting cable for ∿ 11 μA_{PP} interface
9-pin: [3(2 × 0.14 mm²) + (2 × 1 mm²)] **Ø 8 mm**
M23 connecting element, 9-pin
D-sub connector, 15-pin

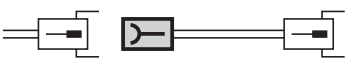
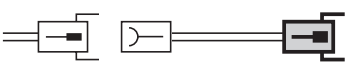
Complete For ND 2xx		309 774-xx
Complete For IK 220, POSITIP, ND 780		368 172-xx
With one connector		309 780-xx

The pins on connectors are **numbered** in the direction opposite to those on couplings or flange sockets, regardless of whether the connecting elements are

male or

female.

When engaged, the connections provide **protection** to IP 67 (D-sub connector: IP 50; IEC 60529). When not engaged, there is no protection.

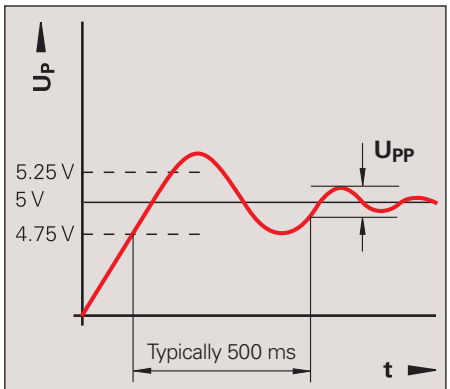
M23 coupling (female) For cable Ø 8 mm		*12-pin* 291 698-02 *9-pin* 291 698-01
M23 connector (male) For cable Ø 8 mm		*12-pin* 291 697-08 *9-pin* 291 697-01
M23 flange socket (female) For mounting on the subsequent electronics		*12-pin* 315 892-08 *9-pin* 315 892-06

General Electrical Information

Power supply

The encoders require a **stabilized dc voltage U_P** as power supply. The respective specifications state the required power supply and the current consumption. The permissible ripple content of the dc voltage is:

- High frequency interference
  U_{PP} < 250 mV with dU/dt > 5 V/µs
- Low frequency fundamental ripple
  U_{PP} < 100 mV



Initial transient response of the supply voltage e.g. 5 V ±5 %

The values apply as measured at the encoder, i.e., without cable influences. The voltage can be monitored and adjusted with the device's **sensor lines.** If a controllable power supply is not available, the voltage drop can be halved by switching the sensor lines parallel to the corresponding power lines.

Calculation of the **voltage drop:**

$$\Delta U = 2 \cdot 10^{-3} \cdot \frac{L_C \cdot I}{56 \cdot A_P}$$

with ΔU: Voltage attenuation in V
L_C: Cable length in m
I: Current consumption of the encoder in mA (see *Specifications*)
A_P: Cross section of power lines in mm²

Electrically permissible speed/ Traversing speed

The maximum permissible shaft speed or traversing velocity of an encoder is derived from

- the **mechanically** permissible shaft speed or traversing velocity (if listed in *Specifications*) and
- the **electrically** permissible shaft speed or traversing velocity.

For encoders with **sinusoidal output signals,** the electrically permissible shaft speed or traversing velocity is limited by the –3dB/ –6dB cutoff frequency or the permissible input frequency of the subsequent electronics.
For encoders with **square-wave signals,** the electrically permissible shaft speed or traversing velocity is limited by

– the maximum permissible scanning frequency f_{max} of the length gauge and
– the minimum permissible edge separation a for the subsequent electronics

For angular or rotary encoders

$$n_{max} = \frac{f_{max}}{z} \cdot 60 \cdot 10^3$$

For linear encoders

$$v_{max} = f_{max} \cdot SP \cdot 60 \cdot 10^{-3}$$

where
n_{max}: Electrically permissible speed in rpm
v_{max}: Electrically permissible speed in m/min
f_{max}: Maximum scanning/output frequency of the encoder or input frequency of the subsequent electronics in kHz
z: Line count of the angle or rotary encoder per 360°
SP: Signal period of the linear encoder in µm

Cable

Lengths
The cable lengths listed in the *Specifications* apply only for HEIDENHAIN cables and the recommended input circuitry of subsequent electronics.

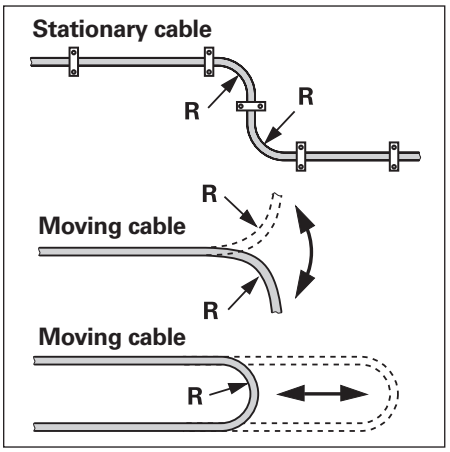
Durability
All encoders have polyurethane (PUR) cables. PUR cables are resistant to oil, hydrolysis and microbes in accordance with **VDE 0472.** They are free of PVC and silicone and comply with UL safety directives. The **UL certification** AWM STYLE 20963 80 °C 30 V E63216 is documented on the cable.

Temperature range
HEIDENHAIN cables can be used:

for stationary cables	–40 to 85 °C
for moving cables	–10 to 85 °C

Cables with limited resistance to hydrolysis and microbes are rated for up to 100 °C.

Bending radius
The permissible bending radii R depend on the cable diameter and the configuration:



HEIDENHAIN cables	Cross section of power supply lines A_P			
	1 V_{PP}/TTL/HTL	11 μA_{PP}	EnDat/SSI 17-pin	EnDat 8-pin
Ø 3.7 mm	0.05 mm²	–	–	–
Ø 4.5/5.1 mm	0.14/0.05[2] mm²	0.05 mm²	0.05 mm²	–
Ø 6/10[1] mm	0.19/0.14[3] mm²	–	0.08 mm²	0.34 mm²
Ø 8/14[1] mm	0.5 mm²	1 mm²	0.5 mm²	1 mm²

[1] Metal armor
[2] Only on length gauges
[3] Only for LIDA 400

HEIDENHAIN cables	Stationary cable	Moving cable
Ø 3.7 mm	R ≥ 8 mm	R ≥ 40 mm
Ø 4.5 mm Ø 5.1 mm	R ≥ 10 mm	R ≥ 50 mm
Ø 6 mm	R ≥ 20 mm	R ≥ 75 mm
Ø 8 mm	R ≥ 40 mm	R ≥ 100 mm
Ø 10 mm[1]	R ≥ 35 mm	R ≥ 75 mm
Ø 14 mm[1]	R ≥ 50 mm	R ≥ 100 mm

Reliable Signal Transmission

Electromagnetic compatibility/ CE compliance
When properly installed, HEIDENHAIN encoders fulfill the requirements for electromagnetic compatibility according to 89/336/EEC with respect to the generic standards for:

- **Noise immunity IEC 61 000-6-2:** Specifically:
  - ESD — IEC 61 000-4-2
  - Electromagnetic fields — IEC 61 000-4-3
  - Burst — IEC 61 000-4-4
  - Surge — IEC 61 000-4-5
  - Conducted disturbances — IEC 61 000-4-6
  - Power frequency magnetic fields — IEC 61 000-4-8
  - Pulse magnetic fields — IEC 61 000-4-9
- **Interference IEC 61 000-6-4:**

Specifically:
- For industrial, scientific and medical (ISM) equipment — IEC 55 011
- For information technology equipment — IEC 55 022

Transmission of measuring signals— electrical noise immunity
Noise voltages arise mainly through capacitive or inductive transfer. Electrical noise can be introduced into the system over signal lines and input or output terminals.
Possible sources of noise are:

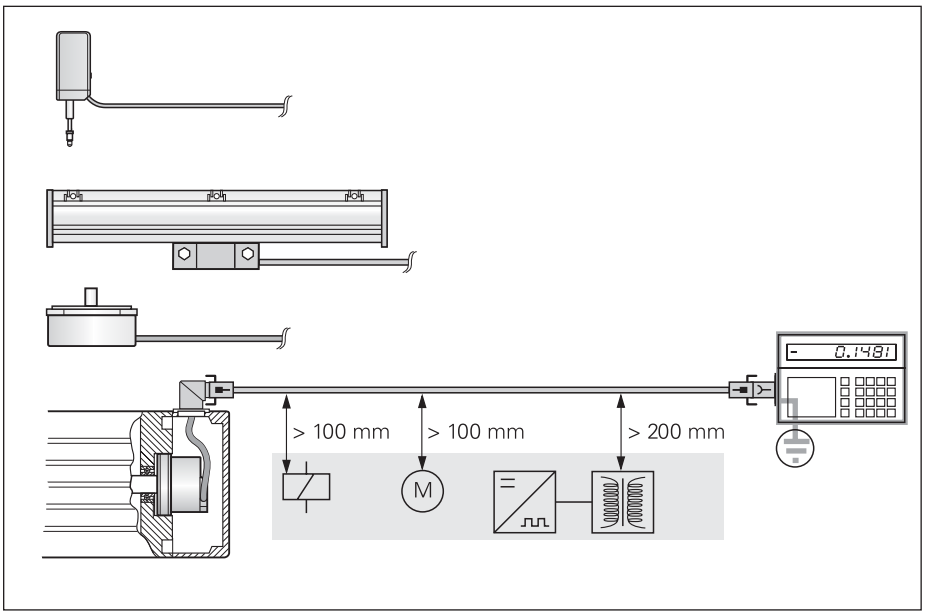
- Strong magnetic fields from transformers and electric motors
- Relays, contactors and solenoid valves
- High-frequency equipment, pulse devices, and stray magnetic fields from switch-mode power supplies
- AC power lines and supply lines to the above devices

Isolation
The encoder housings are isolated against all circuits.
Rated surge voltage: 500 V
(preferred value as per VDE 0110 Part 1)

Protection against electrical noise
The following measures must be taken to ensure disturbance-free operation:

- Use only original HEIDENHAIN cables. Watch for voltage attenuation on the supply lines.
- Use connectors or terminal boxes with metal housings. Do not conduct any extraneous signals.
- Connect the housings of the encoder, connector, terminal box and evaluation electronics through the shield of the cable. Connect the shielding in the area of the cable inlets to be as induction-free as possible (short, full-surface contact).
- Connect the entire shielding system with the protective ground.
- Prevent contact of loose connector housings with other metal surfaces.
- The cable shielding has the function of an equipotential bonding conductor. If compensating currents are to be expected within the entire system, a separate equipotential bonding conductor must be provided.
  See also **EN 50178/**4.98 Chapter 5.2.9.5 regarding "protective connection lines with small cross section."
- Connect HEIDENHAIN position encoders only to subsequent electronics whose power supply is generated through double or strengthened insulation against line voltage circuits. See also **IEC 364-4-41:** 1992, modified Chapter 411 regarding "protection against both direct and indirect touch" (PELV or SELV).
- Do not lay signal cables in the direct vicinity of interference sources (inductive consumers such as contacts, motors, frequency inverters, solenoids, etc.).
- Sufficient decoupling from interference-signal-conducting cables can usually be achieved by an air clearance of 100 mm or, when cables are in metal ducts, by a grounded partition.
- A minimum spacing of 200 mm to inductors in switch-mode power supplies is required. Also see **EN 50 178**/4.98 Chapter 5.3.1.1 regarding cables and lines, and **EN 50 174-2**/09.01, Chapter 6.7 regarding grounding and potential compensation.
- When using **multiturn encoders in electromagnetic fields** greater than 30 mT, HEIDENHAIN recommends consulting with the main facility in Traunreut.

Both the cable shielding and the metal housings of encoders and subsequent electronics have a shielding function. The housings must have the **same potential** and be connected to the main signal ground over the machine chassis or by means of a separate potential compensating line. Potential compensating lines should have a minimum cross section of 6 mm^2 (Cu).



Minimum distance from sources of interference

HEIDENHAIN

DR. JOHANNES HEIDENHAIN GmbH
Dr.-Johannes-Heidenhain-Straße 5
83301 Traunreut, Germany
☏ +49 (8669) 31-0
FAX +49 (8669) 5061
E-Mail: info@heidenhain.de

www.heidenhain.de

DE **HEIDENHAIN Technisches Büro Nord**
12681 Berlin, Deutschland
☏ (030) 54705-240
E-Mail: tbn@heidenhain.de

HEIDENHAIN Technisches Büro Mitte
08468 Heinsdorfergrund, Deutschland
☏ (03765) 69544
E-Mail: tbm@heidenhain.de

HEIDENHAIN Technisches Büro West
58093 Hagen, Deutschland
☏ (02331) 9579-0
E-Mail: tbw@heidenhain.de

HEIDENHAIN Technisches Büro Südwest
72131 Ofterdingen, Deutschland
☏ (07473) 22733
E-Mail: tbsw@heidenhain.de

HEIDENHAIN Technisches Büro Südost
83301 Traunreut, Deutschland
☏ (08669) 31-1345
E-Mail: tbso@heidenhain.de

AR **NAKASE SRL**
B1653AOX Villa Ballester, Argentina
☏ +54 (11) 47684242
E-Mail: nakase@nakase.com

AT **HEIDENHAIN Techn. Büro Österreich**
83301 Traunreut, Germany
☏ +49 (8669) 31-1337
E-Mail: tba@heidenhain.de

AU **FCR Motion Technology Pty. Ltd**
Laverton North 3026, Australia
☏ +61 (3) 93626800
E-Mail: vicsales@fcrmotion.com

BE **HEIDENHAIN NV/SA**
1760 Roosdaal, Belgium
☏ +32 (54) 51 52 10
E-Mail: sales@heidenhain.be

BG **ESD Bulgaria Ltd.**
Sofia 1172, Bulgaria
☏ +359 (2) 9632949
E-Mail: info@esd.bg

BR **DIADUR Indústria e Comércio Ltda.**
04763-070 – São Paulo – SP, Brazil
☏ +55 (11) 5696-6777
E-Mail: diadur@diadur.com.br

BY Belarus → **RU**

CA **HEIDENHAIN CORPORATION**
Mississauga, Ontario L5T 2N2, Canada
☏ +1 (905) 670-8900
E-Mail: info@heidenhain.com

CH **HEIDENHAIN (SCHWEIZ) AG**
8603 Schwerzenbach, Switzerland
☏ +41 (44) 8062727
E-Mail: verkauf@heidenhain.ch

CN **HEIDENHAIN (TIANJIN) OPTICS & ELECTRONICS CO., LTD**
Beijing 101312, China
☏ +86 10-80420000
E-Mail: sales@heidenhain.com.cn

CS Serbia and Montenegro → **BG**

CZ **HEIDENHAIN s.r.o.**
106 00 Praha 10, Czech Republic
☏ +420 272658131
E-Mail: heidenhain@heidenhain.cz

DK **TP TEKNIK A/S**
2670 Greve, Denmark
☏ +45 (70) 100966
E-Mail: tp-gruppen@tp-gruppen.dk

ES **FARRESA ELECTRONICA S.A.**
08028 Barcelona, Spain
☏ +34 934092491
E-Mail: farresa@farresa.es

FI **HEIDENHAIN Scandinavia AB**
02770 Espoo, Finland
☏ +358 (9) 8676476
E-Mail: info@heidenhain.fi

FR **HEIDENHAIN FRANCE sarl**
92316 Sèvres, France
☏ +33 01 41 14 30 00
E-Mail: info@heidenhain.fr

GB **HEIDENHAIN (G.B.) Limited**
Burgess Hill RH15 9RD, United Kingdom
☏ +44 (1444) 247711
E-Mail: sales@heidenhain.co.uk

GR **MB Milionis Vassilis**
17341 Athens, Greece
☏ +30 (210) 9336607
E-Mail: bmilioni@otenet.gr

HK **HEIDENHAIN LTD**
Kowloon, Hong Kong
☏ +852 27591920
E-Mail: service@heidenhain.com.hk

HR Croatia → **SL**

HU **HEIDENHAIN Kereskedelmi Képviselet**
1239 Budapest, Hungary
☏ +36 (1) 4210952
E-Mail: info@heidenhain.hu

ID **PT Servitama Era Toolsindo**
Jakarta 13930, Indonesia
☏ +62 (21) 46834111
E-Mail: ptset@group.gts.co.id

IL **NEUMO VARGUS MARKETING LTD.**
Tel Aviv 61570, Israel
☏ +972 (3) 5373275
E-Mail: neumo@neumo-vargus.co.il

IN **ASHOK & LAL**
Chennai – 600 030, India
☏ +91 (44) 26151289
E-Mail: ashoklal@satyam.net.in

IT **HEIDENHAIN ITALIANA S.r.l.**
20128 Milano, Italy
☏ +39 0227075 1
E-Mail: info@heidenhain.it

JP **HEIDENHAIN K.K.**
Tokyo 102-0073, Japan
☏ +81 (3) 3234-7781
E-Mail: sales@heidenhain.co.jp

KR **HEIDENHAIN LTD.**
Suwon, South Korea, 443-810
☏ +82 (31) 2011511
E-Mail: info@heidenhain.co.kr

MK Macedonia → **BG**

MX **HEIDENHAIN CORPORATION MEXICO**
20235 Aguascalientes, Ags., Mexico
☏ +52 (449) 9130870
E-Mail: info@heidenhain.com

MY **ISOSERVE Sdn. Bhd**
56100 Kuala Lumpur, Malaysia
☏ +60 (3) 91320685
E-Mail: isoserve@po.jaring.my

NL **HEIDENHAIN NEDERLAND B.V.**
6716 BM Ede, Netherlands
☏ +31 (318) 581800
E-Mail: verkoop@heidenhain.nl

NO **HEIDENHAIN Scandinavia AB**
7300 Orkanger, Norway
☏ +47 72480048
E-Mail: info@heidenhain.no

PH **Machinebanks` Corporation**
Quezon City, Philippines 1113
☏ +63 (2) 7113751
E-Mail: info@machinebanks.com

PL **APS**
02-473 Warszawa, Poland
☏ +48 228639737
E-Mail: aps@apserwis.com.pl

PT **FARRESA ELECTRÓNICA, LDA.**
4470 - 177 Maia, Portugal
☏ +351 229478140
E-Mail: fep@farresa.pt

RO Romania → **HU**

RU **Gertner Service GmbH**
113035 Moskau, Russian Federation
☏ +7 (495) 931-9645
E-Mail: heidenhain@gertnergroup.de

SE **HEIDENHAIN Scandinavia AB**
12739 Skärholmen, Sweden
☏ +46 (8) 53193350
E-Mail: sales@heidenhain.se

SG **HEIDENHAIN PACIFIC PTE LTD.**
Singapore 408593,
☏ +65 6749-3238
E-Mail: info@heidenhain.com.sg

SK Slovakia → **CZ**

SL **Posredništvo HEIDENHAIN SAŠO HÜBL s.p.**
2000 Maribor, Slovenia
☏ +386 (2) 4297216
E-Mail: hubl@siol.net

TH **HEIDENHAIN (THAILAND) LTD**
Bangkok 10250, Thailand
☏ +66 (2) 398-4147-8
E-Mail: info@heidenhain.co.th

TR **T&M Mühendislik Mümessillik**
34728 Erenköy-Istanbul, Turkey
☏ +90 (216) 3022345
E-Mail: info@tmmuhendislik.com

TW **HEIDENHAIN Co., Ltd.**
Taichung 407, Taiwan
☏ +886 (4) 23588977
E-Mail: info@heidenhain.com.tw

UA Ukraine → **RU**

US **HEIDENHAIN CORPORATION**
Schaumburg, IL 60173-5337, USA
☏ +1 (847) 490-1191
E-Mail: info@heidenhain.com

VE **Maquinaria Diekmann S.A.**
Caracas, 1040-A, Venezuela
☏ +58 (212) 6325410
E-Mail: purchase@diekmann.com.ve

VN **AMS Advanced Manufacturing Solutions Pte Ltd**
HCM City, Viêt Nam
☏ +84 (8) 9123658 - 8352490
E-Mail: davidgoh@amsvn.com

SALES & SERVICE:
A Tech Authority, Inc.
13745 Stockton Ave.
Chino CA 91710
909-614-4522
sales@atechauthority.com

208 945-26 · 40 · 3/2006 · H · Printed in Germany · Subject to change without notice

Zum Abheften hier falzen! / Fold here for filing!