

Adjustable Angle Gauge (53-150-000)

Specifications

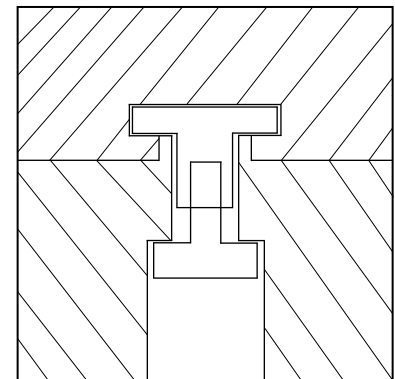
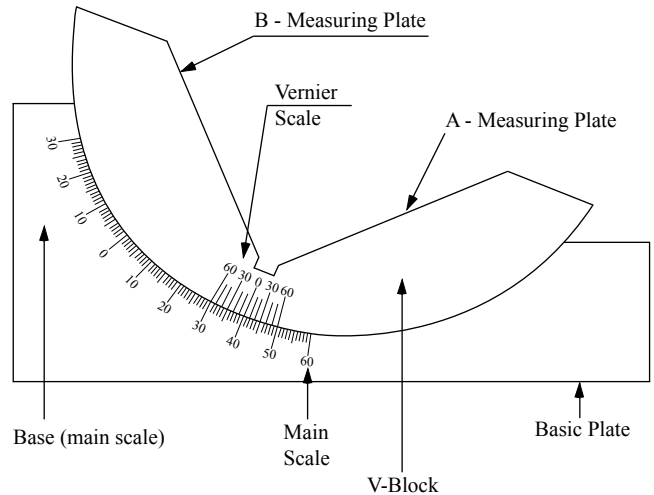
- Manufactured from chrome steel hardened and micro lapped
- 90° vee located in precision tee slot
- Vee movement:- 60° anti clockwise, 30° clockwise
- Vernier scale on vee reads in 10 sec. divisions
- Vee locked in place by 2 tee nuts
- Length:- 102mm, height 48mm, width 30mm

Application

After adjusting cutting tools, marking and matching other fixture to fix work on the miller, planer, grinding and drilling machine with adjustable angular gauges, workpiece can be processed, such as inclined face processing inclined hole drilling etc.

Using Method

1. Relax the screw, and move V-Block along the guide of the base to rotate it, then seek for aiming angular.
2. Read by the principle of vernier, the graduation of main division is 1 and vernier graduation is 10. Fitting the vernier mark "0" into the mark "0" on the main division indicates that A measuring plate is parallel with basic plate and B measuring plate is vertical to basic plate.
 - When vernier mark "0" is on the right of the main division mark "0", the degree can be read by vernier mark "0" (similar to vernier caliper). The degree and minute show involving angular of A. B measuring in reverted direction.
 - When vernier mark "0" is on the left of main division mark "0" the degree can also be read by vernier mark "0" and minute read by the division on the left of vernier mark "0". Now the degree and minute show involving angle of A. B measuring plate in clockwise direction.
 - Fasten the screw to fix the V-Block and the base after the angle is adjusting to the aiming value.



Major Technical Functional Index

1. When the basic plate is parallel with the measuring A and vertical to B, the un-coincidence between vernier mark "0" and main mark "0" is not M.T3, and it's also not M.T5 between vernier end division and main division mark 11. On the contrary, after fastening the screw to fit main division mark "0" into vernier mark "0", the parallelism between A measuring plate and basic plate is not more than 0.01mm, and the squareness between measuring B and plate is not more than 0.01mm.
2. In the fastening condition the resolution of adjustable angular gauges is not more than ±10.
3. The hardness of the two measuring plate and basic plate listed below:

Material	Hardness
Alloytool steel	≥58HRC
CrMn	≥58HRC