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JJF

**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

JJF 1088-2015

Replacing JJF 1088-2002

**Calibration Specification for Large Dimension Outside
Micrometers
(English Translation)**

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Introduction

JJF 1071-2010 "National Calibration Specifications writing rules", JJF 1001-2011 "common terminology and measurement Definitions ", JJF 1059.1-2012" Evaluation and Expression of Uncertainty in Measurement "together constitute the support of the calibration code revision Basic series of normative work.

The code revision, the main reference standard JB/T 10007-2012 "Great outside micrometer (measuring range 1000mm ~ 3000mm) "and GB/T 1216-2004" outside micrometer ", this specification replace JJF 1088-2002 "outside micrometer (measuring range 500mm ~ 3000mm) calibration specification." Compared with JJF 1088-2002, in addition to editorial changes, the main technical specification of the changes are as follows.

--- Name specification to "large outside micrometer calibration specification."

--- Large size outside micrometer overview has been modified.

--- Remove the "radial and axial movement of the micrometer screw swing" and "groove width and a width between" the two index.

--- Increased by gantry measuring "return error indication table" approach jog.

--- Anvil surface and measuring the relative offsets micrometer screw measuring surface index has been modified.

- Increase with large table outside micrometer anvil activity indicator measuring the force at the contact plane and spherical, and measure Changes within their means giving provisions.
- Surface roughness measuring surface according to the type of material, the shape of the surface can vary somewhat.
- For measuring surface flatness index has been modified.
- Indicators parallelism of two micrometer diameter measuring surface has been modified.
- Indication error indicators micrometer head has been modified.
- Large size outside micrometer indicators and calibration method error of indication has been modified.
- Indicators proofreading amount Rod Size deviation has been modified.
- Canceled proofing dipstick parallel index requirements.
- Face of two parallel calibration method were refined.
- The amount of block size micrometer indication when using error correction were perfect with GB recommended values of unity.
- Re-measurement of Uncertainty about Indication Error assessed.

JJF 1088 of previously issued as follows.

JJF 1088-2002 "outside micrometer (measuring range 500mm ~ 3000mm) calibration standard" JJG193-1987 micrometer (measuring range 500mm ~ 3000mm) (Trial) Large outside micrometer calibration specification

1 Scope

This instruction applies to indexing is 0.01mm, respectively measuring range (500 ~ 1000) mm, (1000 ~

3000) mm large size micrometer diameter calibration.

2. References

This specification refers to the following documents.

JB/T 10007-2012 large outside micrometer (measuring range 1000mm ~ 3000mm) GB/T 1216 outside micrometer for dated references, only the dated edition applies to this specification; undated reference documents Member, the latest edition (including any amendments) applies to this specification.

3 Overview

Large outside micrometer screw vice principle is the use of two measuring foot rack

between surfaces separated by distance measurement External dimensions measuring instruments. Anvil can be changed or large size adjustable micrometer diameter shown in Figure 1, with a large table outside micrometer

Figure 2, the amount of proofreading rod in Figure 3.

Figure 1 anvil can be changed or large size adjustable outside micrometer

1- foot frame; 2- anvil; 3- anvil fastening bolts; 4- force measuring device; 5- differential cylinder; 6- fixed casing;

7- spindle locking device; 8- micrometer screw; 9- thermal insulation