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NATIONAL METROLOGY VERIFICATION REGULATION OF THE PEOPLE'S REPUBLIC OF CHINA

JJG 1082.1-2013

Verififcation Regulation of Means of Measuring Instrument for Wheel-Diameter of Railway Locomotives and Vehicles. Part 1: Means of Ruler for Wheel-Diameter

铁路机车车辆轮径量具检具 第1部分：轮径尺检具

(English Translation)

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Introduction

JJG 1082 "railway rolling stock wheel diameter measuring gage" consists of two parts.

--- Part 1. round foot diameter gage;

--- Part 2. wheel diameter measuring gage.

When using this procedure in Railway Locomotive wheel diameter measuring gage calibration, this Regulation should be selected according to the type of gage Cheng corresponding portions.

This part of the contents on foot diameter wheel gage verification, according JJF1002-2010 "national verification regulations Cheng write rules ", JJG 1081.1-2013" railway rolling stock wheel diameter measuring Part 1. round foot diameter "and to Seeking compiled.

This procedure was first formulated.

Railway rolling stock wheel diameter measuring gages test procedures Part 1. round foot diameter gage

1 Scope

The order applies to railway rolling stock wheel foot diameter gage initial verification, use

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and subsequent verification check.

2 Overview

Indication foot diameter wheel railway vehicles Gage (hereinafter referred to as round foot diameter gage) is used to test Locomotive wheel diameter feet Error and center of the probe positioned at a distance to the surface, where the left and right wheel diameter measuring tape to measure the scale center of the probe to the vertical positioning block Straight from the positioning surface. Wheel diameter gage foot structure is shown in Figure 1.

Figure 1 foot diameter gage structure diagram

1- floor; 2,3,4,5-foot diameter wheel positioning block; 6- the right foot box; 7- left foot box; 8- left measuring tape; 9- left cursor;

10,13,17- dipstick positioning block; 11- left locking screw; 12- right locking screw; 14- and right cursor; 15- the right measuring tape;

16- dipstick; 18- limit screw 3 metering performance requirements 3.1 surface roughness Face positioning block surface roughness Ra measuring tape and the upper limit is 0.8μm. Surface roughness measuring rod end face Ra upper limit is 0.4μm.

Straightness of 3.2 dipstick Straightness measuring rod should be less than 0.1mm.

3.3 measuring tape jaws two parallel measuring surface Measuring tape jaws two parallel measuring surface should be less than 0.01mm.

3.4 mark width measuring tape Measuring tape main scale and vernier mark width of 0.08mm ~ 0.18mm, the width of the difference should be less than 0.05mm.

3.5 indication error measuring tape Left and Right indication error measuring tape should not exceed ± 0.04mm.

3.6 the amount of rod length and the amount of change Given the amount of the actual value of the length of the rod. Its length fluctuation amount dipstick should meet the requirements in Table 1.

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