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

JJG 1082.2-2013

Verification Regulation of Means of Measuring Instrument for Wheel-Diameter of Railway Locomotives and Vehicles. Part 2: Means of Measuring Tools for Wheel-Diameter

铁路机车车辆轮径量具检具 第2部分：轮径测量器检具

(English Translation)

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5.5 Test cycle (5)

Appendix A Locomotive wheel diameter measuring gage calibration record sheet (6)

Appendix B calibration certificate and test results in the notice page format (7)

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 subject should be selected according to the type of gage Procedures set the appropriate section.

This section is about the contents of wheel diameter measuring gage measurement verification, according JJF1002-2010 "National Measurement Unit Setting rules to write rules ", JJG 1081.2-2013" railway rolling stock wheel diameter measuring diameter measurement - Part 2 "And other requirements compiled.

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This procedure was first formulated.

Railway rolling stock wheel diameter measuring gages test procedures Part 2. wheel diameter measuring gage

1 Scope

The order applies to railway rolling stock wheel diameter measuring gage initial verification, use and subsequent verification check.

2 Overview

Railway rolling stock wheel diameter measuring gage (hereinafter referred to as "measuring gage") for verification Locomotive wheel diameter Indication error of measuring devices, including standard arc two forms and seized a quantity of a combination of block-type gage.

Standard arc type gages by an arcuate circular surface, lateral positioning surface and base composition.

The combined amount of the seizure by a precision-block cylinder chord gauge blocks, bow high in blocks, spacers, and base plate and other combinations to make. It works for the V-groove diameter measuring method, the diagram shown in Figure 1.

Figure 1 - Block seized a combined amount of work Schematic

3 metering performance requirements

3.1 Measurement combination formula Gage Block

3.1.1 Surface roughness 3.1.1.1 surface roughness Ra of the upper cylinder precision cylindrical surface is 0.4μm.

3.1.1.2 surface roughness Ra of the upper gauge block measuring surface is 0.08μm.

3.1.2 Precision cylinder diameter and cylindricity Cylindricity Precision Cylindrical should be less than 0.002mm.

The nominal value of two precision cylindrical diameter of d0 = 61mm, given its actual value, the diameter difference should be less than 0.004mm.

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