

ICS 17.040
CCS A 52

JJG

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

JJG 938-2012

Replacing JJG 938-1998

**Verification Regulation of Tool Presetting and Measuring
Instrument
(English Translation)**

Issued on: January 1, 1970

Implemented on: January 1, 1970

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine**

Table of Contents

Introduction (II)

1 Scope (1)

2. References (1)

3 Overview (1)

4 Metering performance requirements (1)

4 Metering performance requirements (1)

Projection magnification 4.1 (1)

5.4 Two reticle superposition (3)

The relative position of the spindle and the object plane of the projection system 5.5 (3)

6.3 Verification Methods (4)

Processing 6.4 Verification Results (7)

6.5 Test cycle (7)

Appendix A tool presetting measurement uncertainty of measurement instrument indication error of assessment (8)

Appendix B test mandrel and the test disc (10)

Appendix C calibration certificate/test results in the notice page and format (12)

Introduction

JJF1002-2010 "national verification procedures write rules", JJF1001-2011 "common terminology and measurement Definitions ", JJF1059-1999" Evaluation and Expression of Uncertainty in Measurement ", JJG 938-1998" measuring tool presetting Instrument "(hereinafter referred to as" the original Regulations ") together constitute the basic norms of the present series of regulations revision.

This regulation, the term modified according to GB/T 22096-2008 "tool presetting measuring instrument" Terminology and unity.

This procedure is revised on the basis of the original procedure. Compared with the original regulations, in addition to editorial changes, the main technical change of the following.

--- According to GB/T 22096-2008 "tool presetting measuring instrument", the new increase precision, ordinary type and Jane Yi-based technical requirements.

--- Remove the spindle taper and test rods taper shape error and error in the technical parameters and form.

--- According to GB/T 22096-2008 "tool presetting measuring instrument" on the sighting device along the radial motion of the spindle Squareness measurement repeatability and other technical requirements adopted tabular representation.

--- According to GB/T 22096-2008 "tool presetting measuring instrument", the spindle radial runout, aiming device Parallel to the direction of axial movement of the spindle, showing error such as the use of the formula.

--- Amendments to the original protocol section of the metering apparatus name, "the relative position of the object plane of the projection system and the spindle," "Lord Shaft axial movement, "" radial shaft runout "project" Calibration stick "to" mandrel test "," aiming device axis in the direction of movement of the spindle parallelism "project" test stick "to" mandrel test "," aiming device radially Vertical movement of the spindle of the "project" dedicated gage "to" test disc, "" measurement repeatability "project the "Calibration stick" to "test rods."

--- According to GB/T 22096-2008 "tool presetting measuring instrument" to delete the original statutes "slide axially transport Moving pendulum angle "and" radial angle skateboarding pendulum, "the two test projects.

Tool presetting measuring instrument verification regulation

1 Scope

The order applies to the measurement range (0 ~ 1000) mm tool presetting measuring instrument (hereinafter referred to as "knife adjustment Instrument ") of the initial verification, use and subsequent verification check.

2. References

This procedure references the following documents.

GB/T 22096-2008 tool presetting measuring instrument for dated references, only the dated edition applies to this procedure; undated reference documents Member, the latest edition (including any amendments) applies to this procedure.

3 Overview

Presetter mainly used in CNC machine tools, machining centers and flexible manufacturing cell used in the cutting edge of the radial and axial Size measurement. Presetter into precision type, ordinary type and Simple. Presetter is shown in Figure 1.

Figure 1 schematic presetter

1- base; 2- radial slide; 3- column; 4- slide axially;

5- display device; 6- sighting device; 7- test mandrel; 8- spindle 4 metering performance requirements 4.1 projection magnification