COMPANY GROUP

Automated Systems for
Inner Diameter Control
Automated systems for Inner Diameter Control

Systems are intended for contactless measuring of inner diameter and profiles of gun barrels, cylindrical and taper pipes, progressive cavity stators, turbodrills and so on.

We offer systems on the base of
TWO WORKING PRINCIPLES

- Multisensor measurement by stationary laser sensors
- Inner surface laser scanning by rotating sensors

SYSTEMS PARAMETERS

- Measured ID – from 9 mm
- Up to several um accuracy
- Up to 32000 measured points on the surface in 2 seconds
- Calculation of ovality and roundness
- Surface defects detection and measurement
- 3D model of inner surface design
- Measured ID (beginning of 2017) – from 5 mm
The basic elements of ID measurement systems

THE SYSTEMS USUALLY CONTAIN:

- Laser measurement module with
  - stationary sensors
  or
  - rotating sensors
- Translation module intended for transportation of measurement module inside the pipe:
  - self propelled or
  - any kind of pulling machine
- Software for PC
- Calibration rings

THE SYSTEMS CAN CONTAIN:

- Centering frame to hold measurement module near pipe axis

OPTIONS:

- Pipe straightness measurement module
- Video inspection module
- Wireless connection (Wi-Fi) module
The measurement module contains:
up to 6 laser triangulation sensors located
circumferentially in one housing at known
fixed angles.

The system operates as follows:
The measurement module is inserted into the
pipe and moved by translation module to the
definite position.
Calibrated laser sensors measure distances to
the inner surface.
Software calculates diameter of the pipe.
Rotating lasers measurement module.

Structure

THE MEASUREMENT MODULE CONTAINS:
laser triangulation sensor 1 (one or several with different measurement range and stand-off distance), mounted on rotating platform 2, which contains motor 3 with electronic driver 4, and rotary encoder 5 coupled to the motor 3. The system also includes a tilt sensor 6, intended for control of inclination of rotating platform during measurement.

Options: in-built Wi-Fi module 7 is used for communication between the system and PC; the system can be powered from internal batteries 8. 2D laser scanner can be installed instead of points sensor.
THE SYSTEM OPERATES AS FOLLOWS:
The measurement module is inserted into the pipe and moved by pulling machine to the definite position.
Rotating laser sensor scans inner surface of the pipe and the module transmits polar coordinates of the surface (distance from rotation axis, measured by triangulation sensor and a corresponding angle, measured by encoder).

Software uses the set of transmitted coordinates to calculate:
- ID of measured pipe
- ovality and roundness to find
- surface defects to design
- full profile in definite section.
- 3D model of the pipe inner surface.
Centering frame is intended to hold measurement module near pipe axis for different pipe diameters. The frame can contain the set of wheels or rails symmetrically moving according the frame axis.

Video demonstration:

https://youtu.be/yfuouvYADtE
ID measurement by stationary sensors systems
APPLICATIONS
Multisensor laser system for fiberglass pipes deformation measurement

- Six triangulation sensors inside
- Diameter range – 500…1250 mm
- Accuracy - +\(-2\) mm
Multisensor laser system for smooth gun barrels control

- Six laser sensors inside
- Diameters: 125…132 mm
- Accuracy +/-2 um
- Barrels straightness measurement accuracy +/-5 um
- Self-propelled system for device translation
VIDEO: Multisensor laser system for smooth gun barrels control

https://youtu.be/y4FR_ow6E3k
Multysensors module.
Four laser sensors inside

- Diameter of the module – 70 mm
- Measured diameters: 95…195 mm (main range), 160…300 mm (extended range)
- Accuracy: 0,05 mm (main range) and 0,2 mm (extended range)

The gage is developed for inner surface inspection and ID measurement of nuclear Power station pipes.
ID measurement by laser Scanning.
APPLICATIONS
Rotating lasers system.
How it works

https://youtu.be/c8q88ZQ5S5Y
Rotating lasers system for rifled gun barrels control

- Four rotating laser sensors inside
- Diameters: 57, 81, 90, 105, 120 mm
- Accuracy +/- 2 um
- Barrels straightness measurement option
- Video camera option
- Wi-Fi connection
- Self-propelled translation module
Rotating lasers system for rifled gun barrels control

https://youtu.be/0OwxHmT431E
Rotating lasers system for pipes diameter control

- Diameter range: 45...55 mm
- ID accuracy measurement: ±5 um
Rotating lasers system for cylinders diameter control

- Nominal diameter: 185 mm
- ID accuracy measurement: ± 5 um
VIDEO: Rotating lasers systems for cylinders diameter control. Measurement module is placed on linear translation stage.

https://youtu.be/O6ykAsSAkFk
Rotating lasers systems for cylinders diameter control

Results: Diameter of the pipe with defect
Pipe ID Measurement Machine

https://youtu.be/QGFFOYDGWHI
Laser ID scanning module

- Diameter of the sensor – 9 mm
- Measurement range – 5 mm (9...19 mm diameter)
- ID accuracy measurement ±5 um
Laser ID scanning module

https://youtu.be/AIGrhw7jrwA
Laser ID scanning module for CNC machines

- Diameter of the sensor – 15 mm
- Measurement range – 20 mm
- ID accuracy measurement ±5 um
Laser ID scanning module for CNC machines

http://youtu.be/e1Bpb0oc9g8
AUTOMATED SYSTEM FOR LAMINATED TUBES GEOMETRY MEASUREMENT

https://youtu.be/Mw__T0BwwoE
LEAF SPRINGS HOLES ID
MEASUREMENT MACHINE

https://youtu.be/DoKnp4__YJU
Laser Inspection System.
RF096-Insp

https://youtu.be/ooVtGOnnQ5o
The system for measurement of ID and OD high temperature pipes

http://youtu.be/tkf9jYPbr5M
Laser measurement
(by rotating triangulation sensors)
of ID and OD of large diameter pipes

https://youtu.be/I8P_C24kTY0
ID measurement: Projects
Hand-held ID measurement gauge

- From 2017
Hand-held ID Measurement Gauge
Model RF096-200/600-HH (prototype tests)

Basic specification:
- Measured ID range, mm: 200...600
- Accuracy, mm: ±0.1
- Depth of measurement, mm: on request
- Measurement time, s: 2
- Sensors laser power, mW: 1
- Laser Class: 2

[Link to video](https://youtu.be/1BKwPpssy7U)
Laser Systems for Inner Surface Scanning

- Designed use: Progressive cavity stators, tubes and pipes, gun barrel bore (rifled and smooth)
- ID range: 10...300 mm
- Accuracy: from ±2um
- Angle resolution: 4 arcminutes
- Linear resolution: 20 um

From 2017
Laser Scanning Modules
THANK YOU FOR YOUR ATTENTION!

www.riftek.com