



RIFTEK

Sensors & Instruments



SHAFTS GEOMETRY MEASUREMENT MACHINE

RF800 Series

User's manual

22, Logoisky tract, Minsk
220090, Republic of Belarus
tel/fax: +375 17 281 36 57
info@riftek.com
www.riftek.com

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1. Safety precautions

- All specialists must study this User's Manual before operating the machine.
- Use supply voltage and interfaces indicated in the machine specifications.
- In connection/disconnection of cables, the power must be switched off.
- Do not use the machine in locations close to powerful light sources.
- To obtain stable results, wait about 20 minutes after powering the machine to achieve the uniform warm-up of the micrometer.
- During the measurement procedure, the protective doors of the machine must be closed.

2. CE compliance

The machine has been developed for use in industry and meets the requirements of the following Directives:

- EU directive 2014/30/EU. Electromagnetic compatibility (EMC).
- EU directive 2011/65/EU, 'RoHS' category 9.

3. Laser safety

The machine contains an optical micrometer, which makes use of a LED. The micrometer belongs to the 1 laser safety class. The following warning label is placed on the housing:



The following safety measures should be taken while operating the micrometer:

- Avoid staring into the emitter during a prolonged time period.
- Do not disassemble the micrometer.

4. General information

The machine is designed to control the geometrical parameters of the 'shaft' type parts.

Field of application: large-scale production. Place of installation: production line, or laboratory.

Technical characteristics of the machine can be changed for a specific task.

5. Structure and operating principle

5.1. Optical micrometer

To measure the geometrical parameters of the 'shaft' type parts, a two-axis optical micrometer is used.

The operating principle of the micrometer (for one axis) is illustrated in Figure 1.

The micrometer consists of two blocks: transmitter and receiver. Radiation of LED 1 is collimated by a lens 2. With an object placed in the collimated beam region, a shadow image is formed by the telecentric system 3 on the CCD photodetector array 4. A processor 5 calculates the diameter of the object from the position of shadow borders.

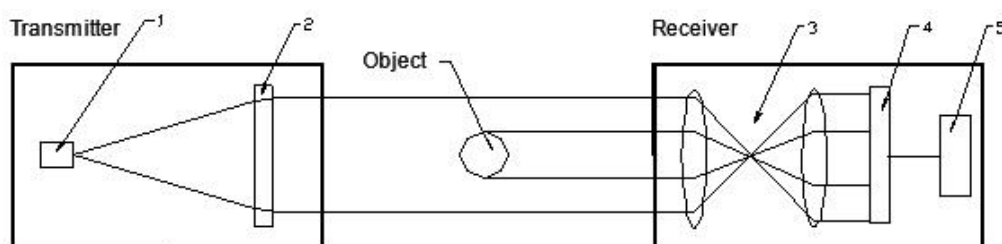


Figure 1

A two-axis optical micrometer contains two identical micrometers (in accordance with the scheme in Fig. 1) in one housing, placed at an angle of 90 degrees to each other, which makes it possible to control the diameter of the object in two mutually perpendicular directions, Fig. 2.

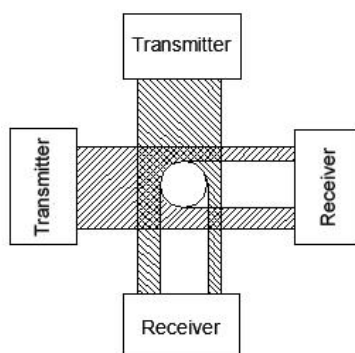
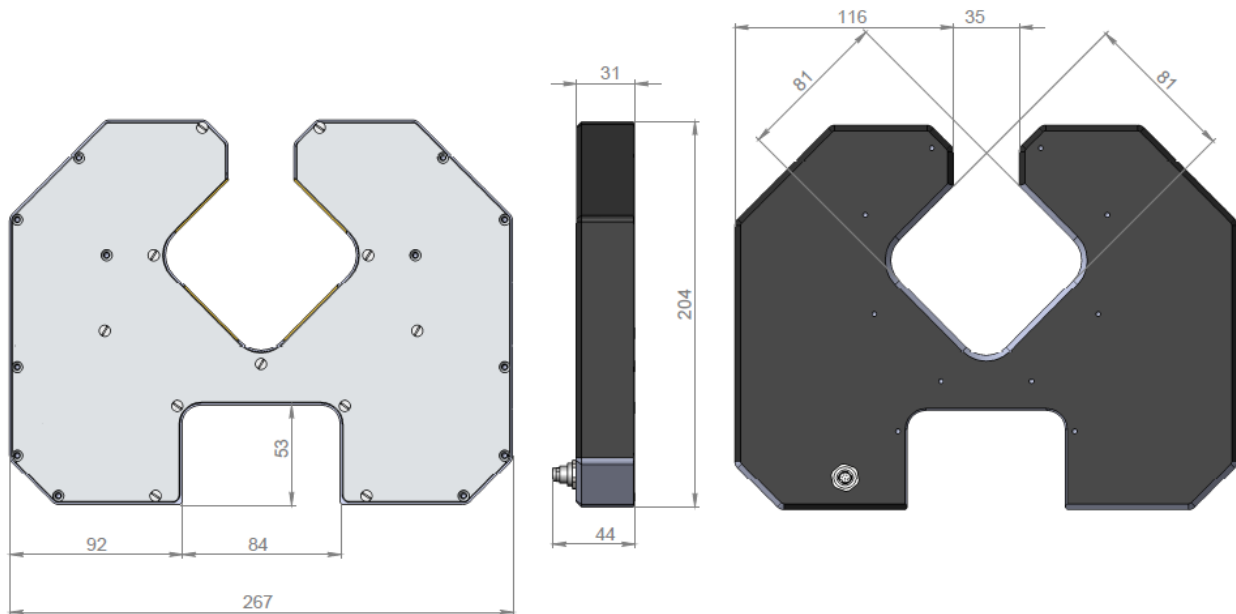


Figure 2

5.1.1. Micrometer specifications

Optical micrometer, RF656XY-35 model		
Measurement range, mm		±6x35
Minimum size of the object, mm		0.25
Maximum size of the object, mm		35
Accuracy, μm		±1
Repeatability, μm		0.5
Maximum scanning frequency, Hz		10000
Maximum update frequency, Hz		2000
Light source		LED
Lase safety class		1 (IEC60825-1)
Output interface		RS485
Synchronization input		2.4 – 5 V (CMOS, TTL)
Power supply, V		24 (9...36)
Power consumption, W		from 1.5 to 2
Environmental resistance	Enclosure rating	IP67
	Vibration	20 g / 10...1000 Hz, 6 hours for each of XYZ axes
	Shock	30 g / 6 ms
	Operating ambient temperature, °C	-10...+60
	Relative humidity	5-95%
Housing material		aluminum
Weight (without cable), gram		1600
Dimensions		see the figure



5.2. Structure

The structure of the machine (without protective doors) is illustrated in Figure 3.

The machine contains a frame (1) on which a linear guide (2) of the linear translation system is installed. The linear guide has a carriage (3) driven by a stepper motor (4).

An optical micrometer (5) is installed on the carriage (3). The end sensors (not shown) are used to monitor the end positions of the micrometer. A table with two Morse tapers (6 and 7) is used to install the controlled shaft. The Morse tapers are mounted on a bar (8) located along the linear guide. One of the end sensors is mounted on the upper taper, the latter can be reinstalled along the bar (8) in order to control the shafts of different lengths.

In addition, the machine has a caliber, which is a part of the upper Morse taper. The caliber is designed for an automatic re-calibration of the micrometer to eliminate the measurement error caused by a change in the temperature of the machine.

The machine contains a mini-computer (9) with a graphic touch screen. The mini-computer has the special software designed to control the machine and to display results. The mini-computer can be built into the machine (as shown in Figure 3), or it can be installed on the special stand (see Figure 4).

The back side of the machine has a power supply 220/24V (10) with a circuit breaker (11), connector for the foot switch (12), USB connector (13) for the USB drive (for example, for data transfer), and the Ethernet connector (14), for example, to connect to the PC.

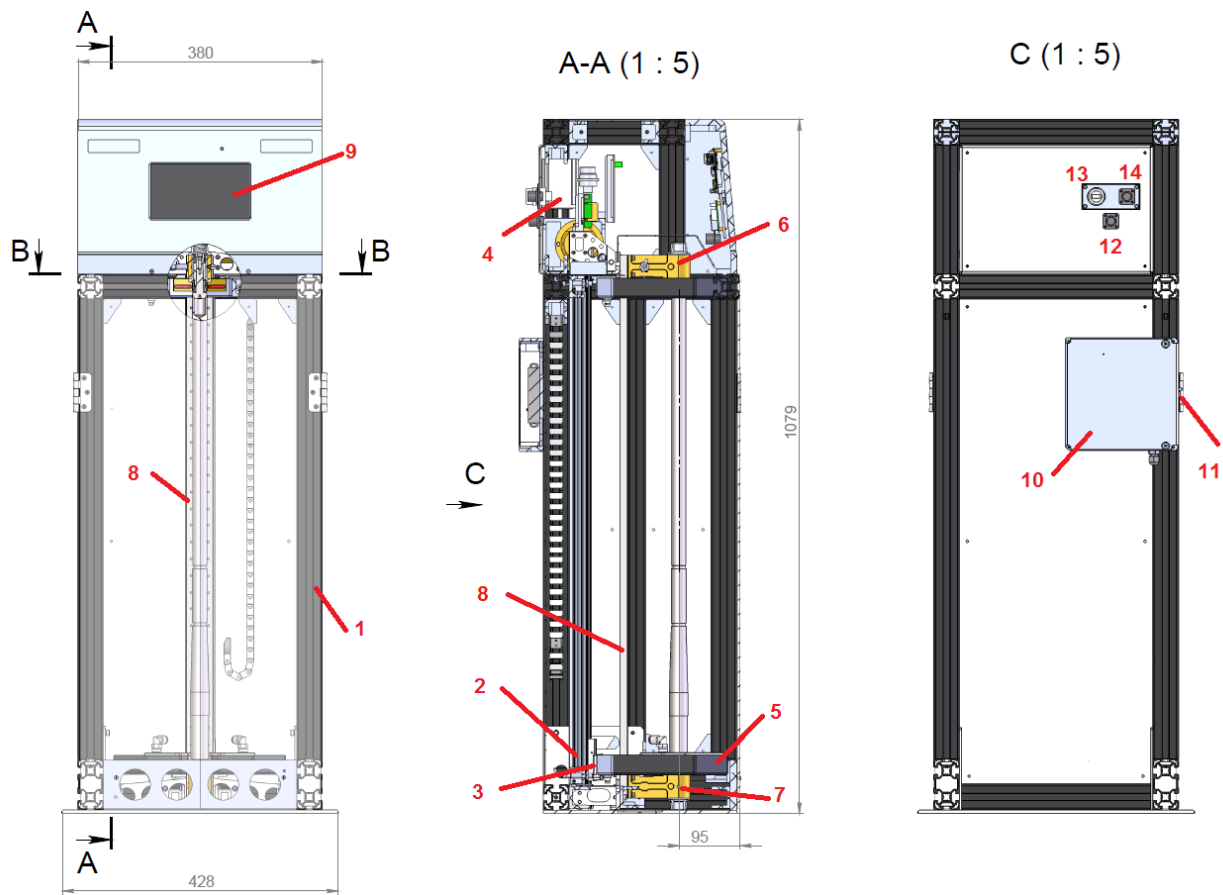


Figure 3

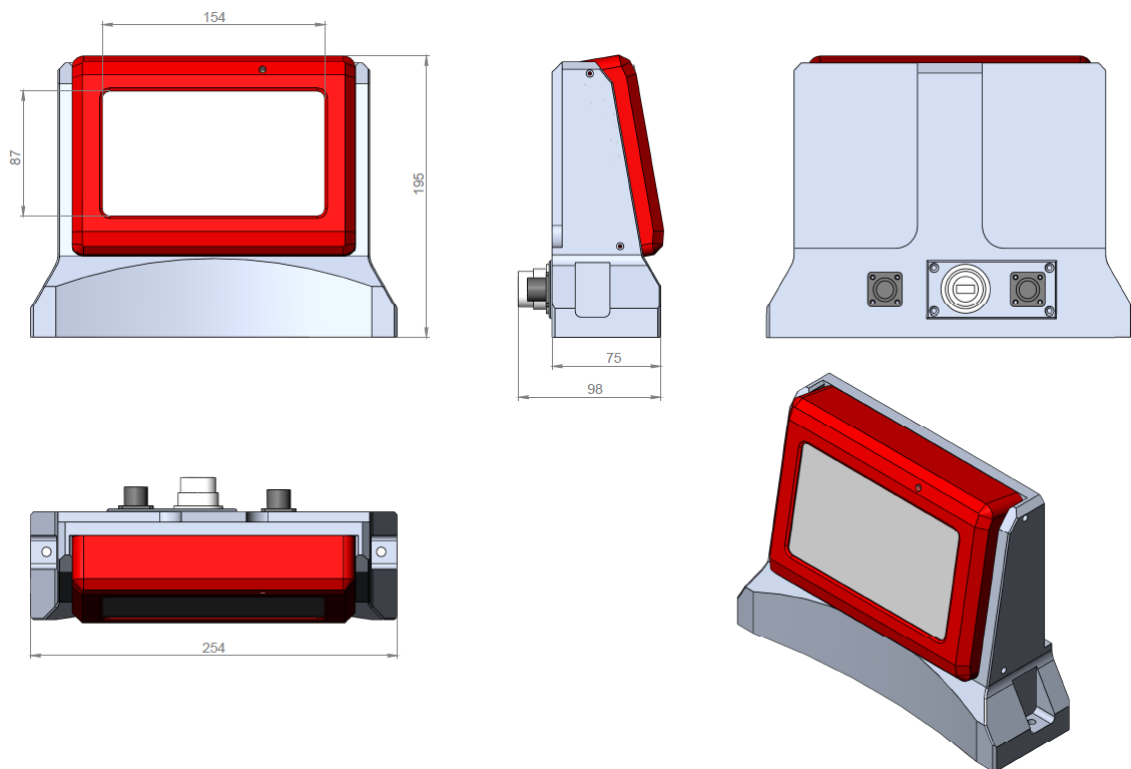


Figure 4

5.3. Operating principle

After the measurement algorithm has been programmed (position and number of controlled zones along the shaft, tolerances, etc. - see the software description), the operator installs a shaft into the machine. After a command from the operator (by the foot switch, or by the softkey on the touch screen), the linear translation system moves the micrometer along the shaft. The data from the micrometer (shaft diameters in two mutually perpendicular cross sections) synchronized with the linear position of the micrometer comes to the computer where the required parameters are calculated (shaft diameter and shaft shape error).

7

6. Basic technical data

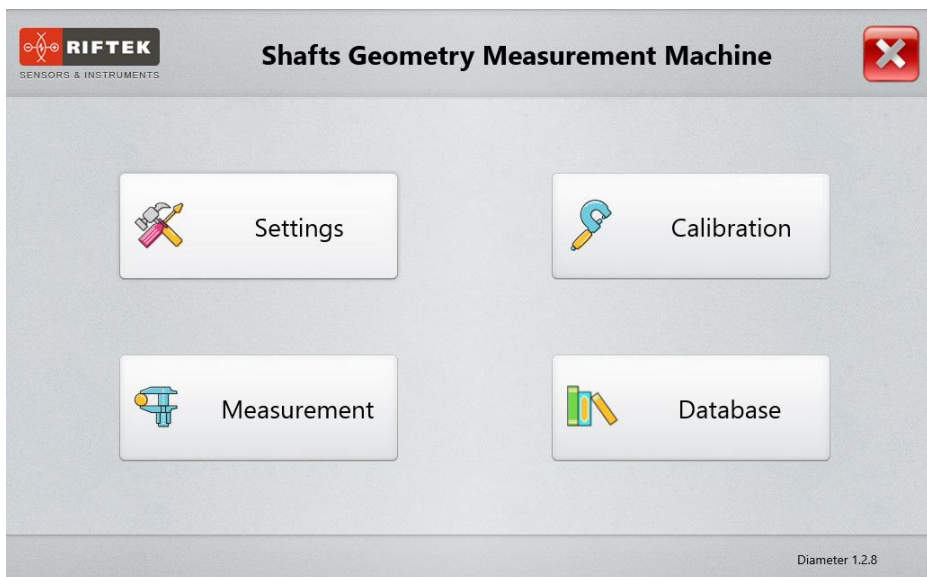
Parameter	Value
Shaft length, mm	160...750
Shaft diameter, mm	5...30
Accuracy, μm	± 1
Time of measuring the shaft of the maximum length, s, no more than	20
Number of controlled shaft zones and their position	Programmable value
Maximum shaft weight, kg	2
Measured parameters	Diameter, ovality, taper
Sorting "OK"-"NOK"	Yes
Ability to sort by groups	Yes
Power supply	Three-phase alternating current network with frequency of (50 ± 1) Hz, nominal voltage 220 / 380V with a permissible voltage deviation of $\pm 10\%$.
Power consumption, W	100
Environmental resistance	Operating ambient temperature: $+1...+35^{\circ}\text{C}$ Relative humidity for 25°C : 65%
Operation mode	3 shifts, 6 days a week
Dimensions, mm	380x428x1079

Note: Machine parameters can be changed for a specific task

7. Software

7.1. Main window

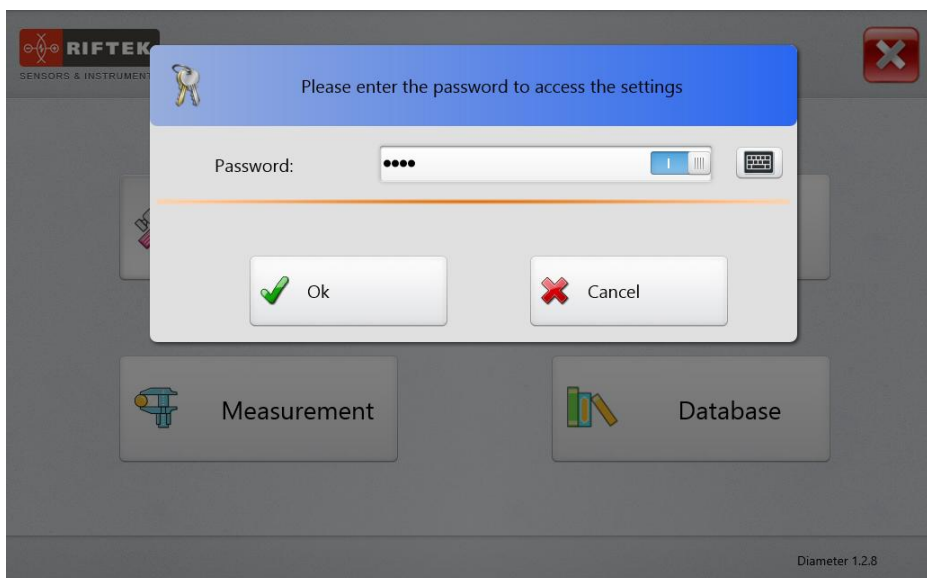
After the machine is powered on, the software is loaded and the main window appears.



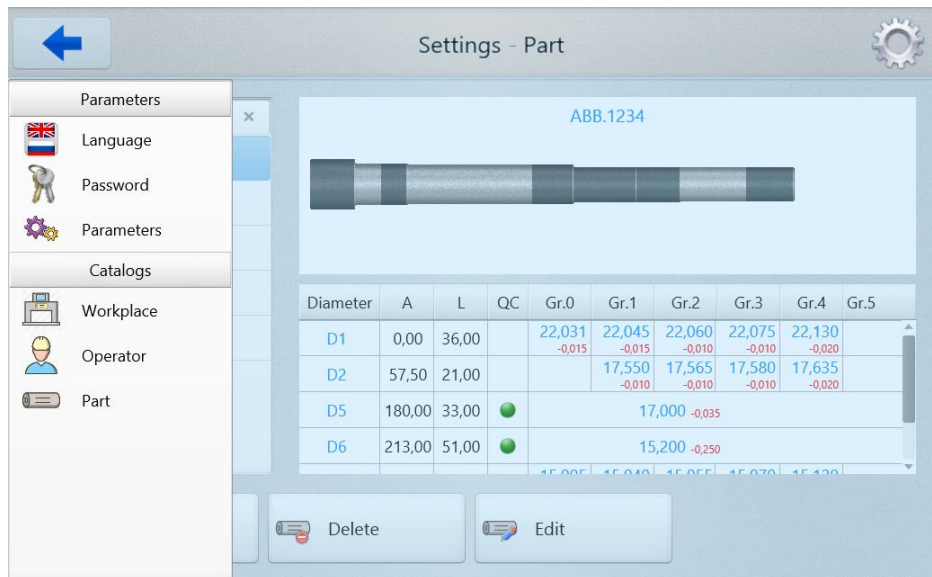
Button	Assignment
Settings	Set the measurement parameters.
Calibration	Perform the calibration procedure.
Measurement	Control the measurement process.
Database	View the database.

7.2. Settings

Only qualified users are allowed to change settings, so when you tap the **Settings** button, you will need to enter a password (by default: 1111).



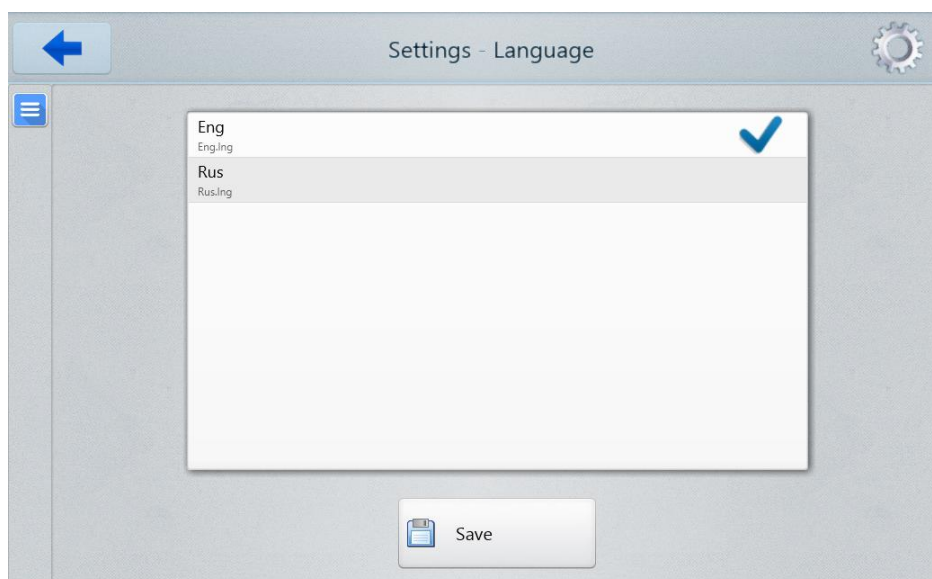
Enter the password and tap **Ok**. The **Settings** window appears:



The parameters menu is located in the left part of the window. The **arrow** in the upper left corner is used to go back to the previous window.

7.2.1. Language

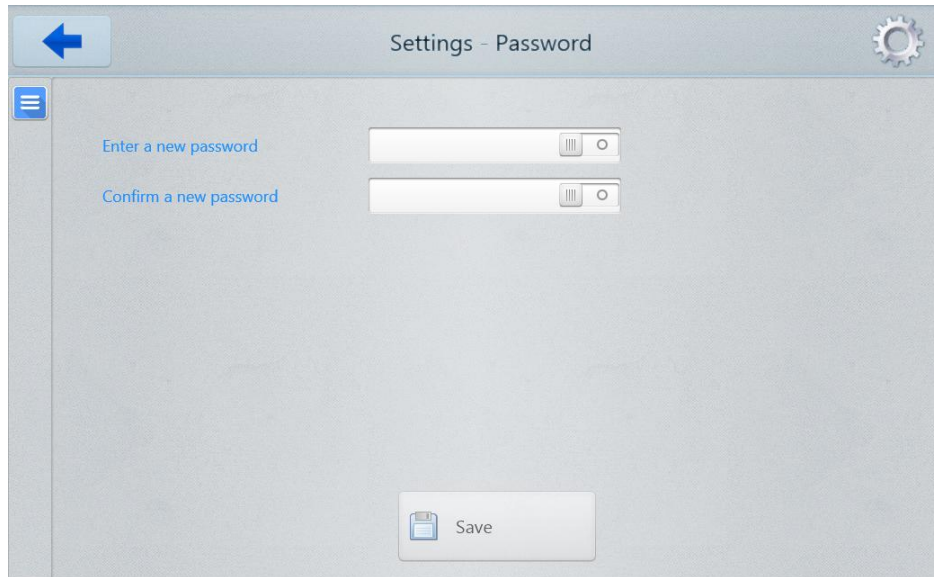
To select the language, tap **Language**. The following window appears:



Select the language and tap **Save**.

7.2.2. Password

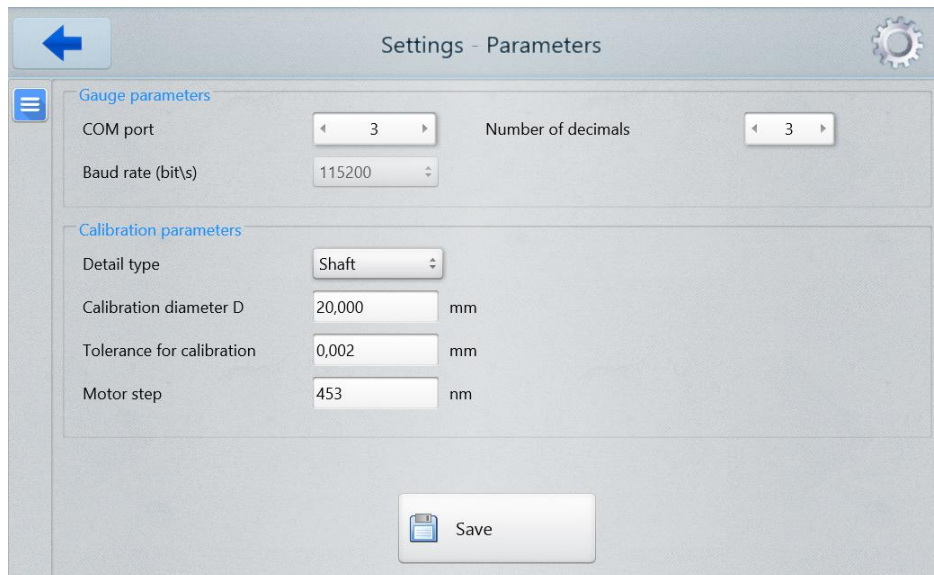
To change the password, tap **Password**. The following window appears:



Enter a new password and confirm it (the toggles in the fields are used to show/hide the entered characters). Tap **Save**.

7.2.3. Parameters

To change parameters, tap **Parameters**. The following window appears:



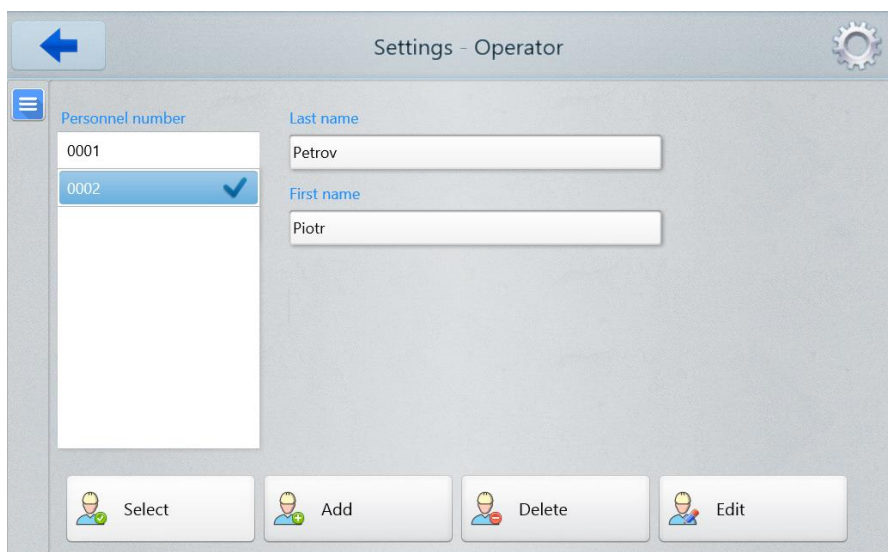
Parameter	Default value	Note
COM port	3	The COM port number of the internal RS485 network. This parameter can be changed only by the manufacturer.
Baud rate, bit/s	115200	The baud rate of the COM port. This parameter can be changed only by the manufacturer.
Number of decimals	3	The displayed number of decimals.
Part type	Shaft	This parameter is selected in accordance with the device type: Shafts control - 'Shaft', Holes control - 'Hole'.

Parameter	Default value	Note
Calibration diameter D	20 mm	The diameter of the caliber installed in the Morse taper (see p. 5.2.).
Tolerance for calibration	0.002 mm	This tolerance is used when testing the calibration accuracy (see p. 7.3.).
Motor step	453	Linear displacement of the micrometer, which corresponds to one step of the motor. This parameter can be changed only by the manufacturer.

To save changes, tap **Save**.

7.2.4. Operator

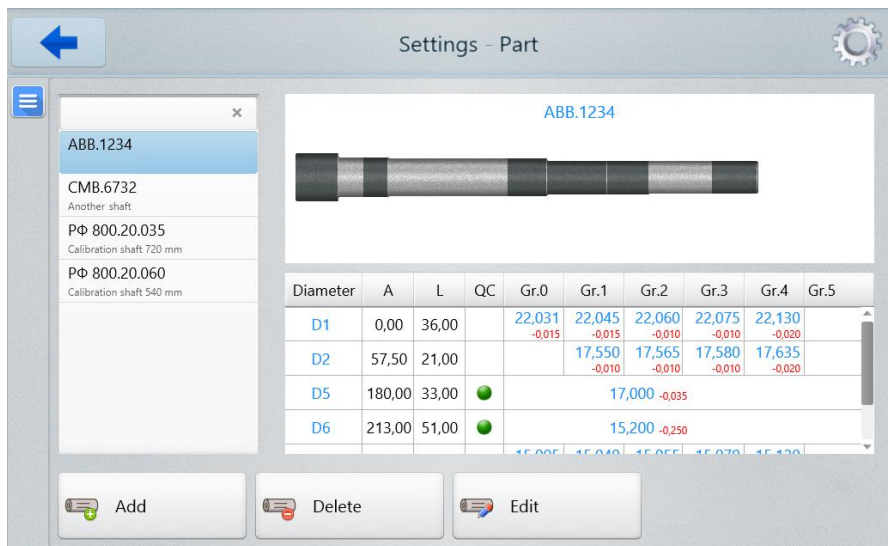
Tap **Operator**. The following window appears:



In this window, you can select, edit, delete, or add the new operator.

7.2.5. Part

In the program, the measured parts are shown as templates described by the following parameters: the position of the controlled zone on the shaft, its size and diameter, and the tolerances for sorting. The number of zones is up to 8. To set the template parameters, tap **Part**. The following window appears:



Diameter	A	L	QC	Gr.0	Gr.1	Gr.2	Gr.3	Gr.4	Gr.5
D1	0,00	36,00		22,031 -0,015	22,045 -0,015	22,060 -0,010	22,075 -0,010	22,130 -0,020	
D2	57,50	21,00			17,550 -0,010	17,565 -0,010	17,580 -0,010	17,635 -0,020	
D5	180,00	33,00	●			17,000 -0,035			
D6	213,00	51,00	●			15,200 -0,250			

In this window, you can see a list of controlled shafts with their unique numbers and names. Parameters of the selected shaft are shown in the table (the selected shaft is highlighted in blue in the list to the left).

The description of parameters:

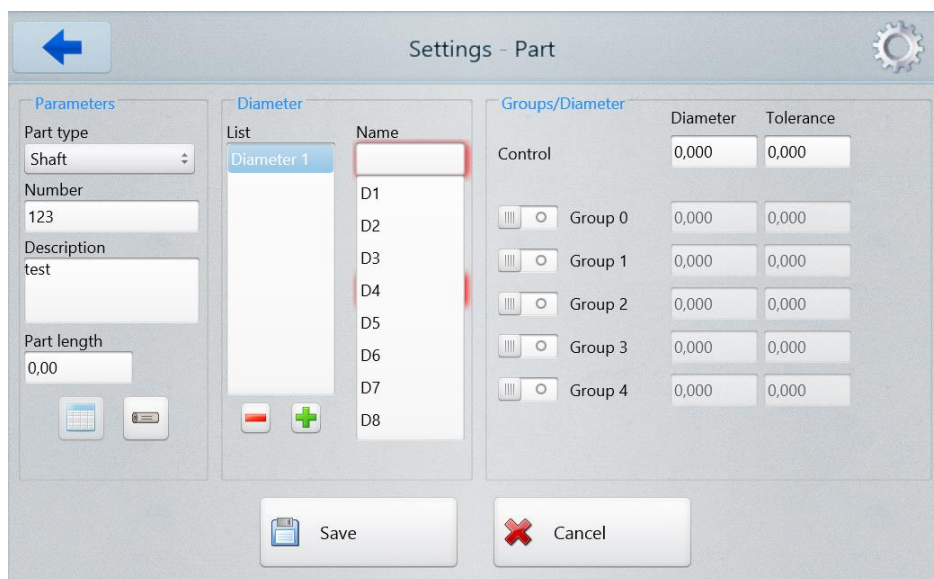
Name	Description
A	The position of the controlled zone on the shaft.
L	The length of the controlled zone.
Gr0...Gr4	Sorting groups (diameter value $\pm$ tolerance).
QC	Quality control sign.

7.2.5.1. Adding / editing the part template

To add the part template to the list, tap **Add**. To edit the part template, tap **Edit**. The following window appears:



Enter a decimal number of the part, its description and length into the respective fields. To form the controlled zones, tap . "Diameter 1" appears in the **List**:



Select the diameter (D1...D8) from the **Name** drop-down list.



Enter the diameter value and the tolerance value into the **Diameter** field and the **Tolerance** field respectively. Enter the parameters of the controlled zone, namely, the position of the zone on the shaft (**Size A**) and the zone length (**Size L**). In addition, it is necessary to enter the number of controlled sections (**Sections d**): 2 or 3. When "2" is selected, the measurements are performed in two sections spaced from the edges of the zone for 3 mm. When "3" is selected, an additional measurement is made in the center of the zone. The diameter of the zone is calculated as the average diameter measured in the selected sections. The cylindricity value of the zone is calculated as the difference in diameters measured at the edges of the zone.

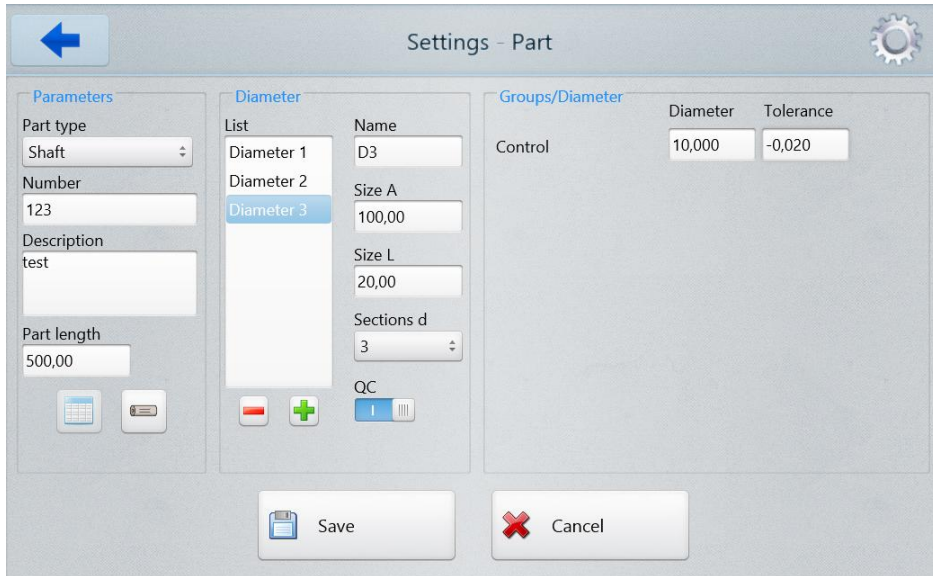
If it is necessary to divide the measured parts into groups, tap on the **Group** toggles and enter the diameter value and the tolerance value for each group.



These tolerances are also used to control the ovality and taper of the zone.

Enter the required number of zones and their parameters in accordance with the algorithm described above.

If the diameter is controlled only by the quality control department, tap on the **QC** toggle to enable it. The groups will be hidden.



Settings - Part

Parameters

Part type: Shaft

Number: 123

Description: test

Part length: 500,00

Diameter

List:

- Diameter 1
- Diameter 2
- Diameter 3

Name: D3

Size A: 100,00

Size L: 20,00

Sections d: 3

QC: [Icon]

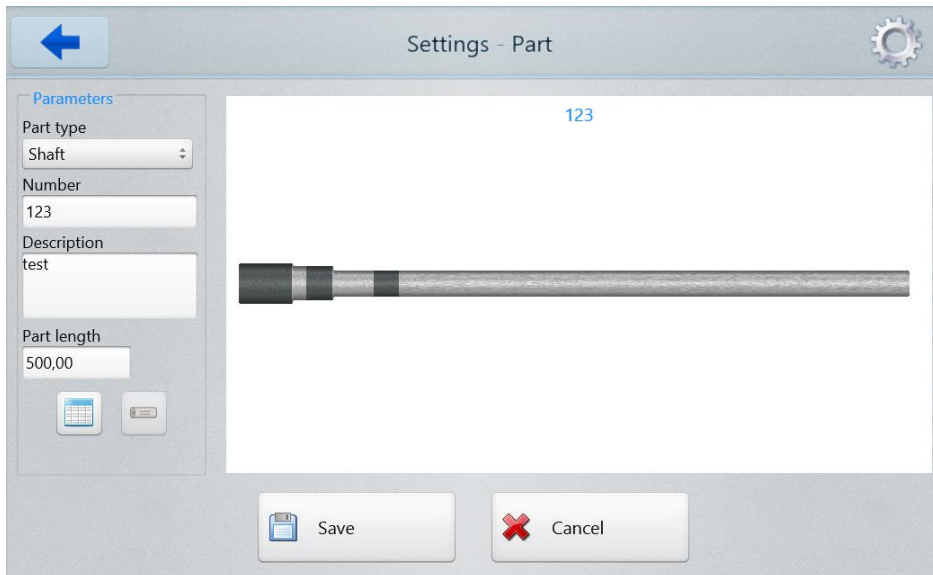
Groups/Diameter

Control	Diameter	Tolerance
	10,000	-0,020

Save Cancel

7.2.5.2. Part template control

To control the part template, tap .



Settings - Part

Parameters

Part type: Shaft

Number: 123

Description: test

Part length: 500,00

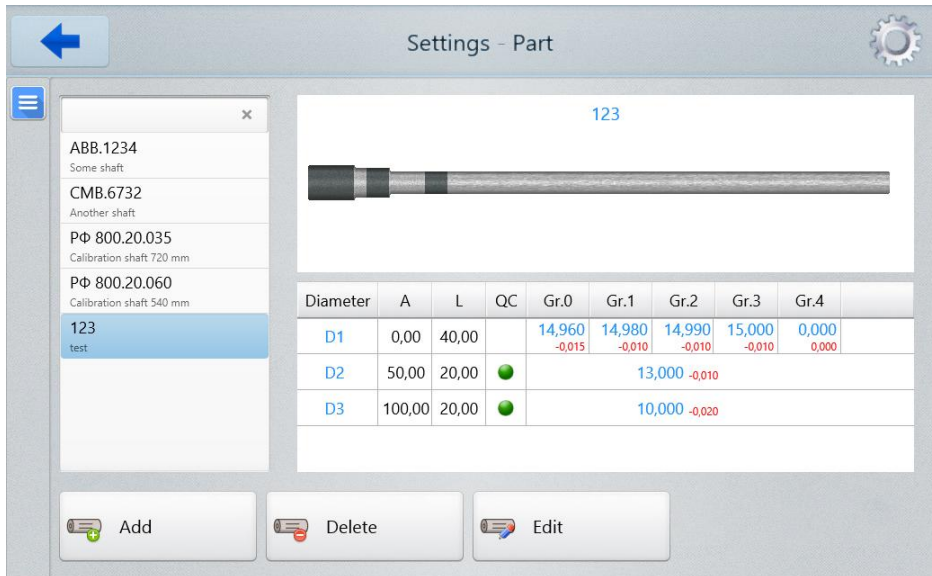
123

Save Cancel

This window displays the part template with the controlled zones. The proportions of the zones correspond to their size. To go back to the template creation window, tap .

7.2.5.3. Saving the part template

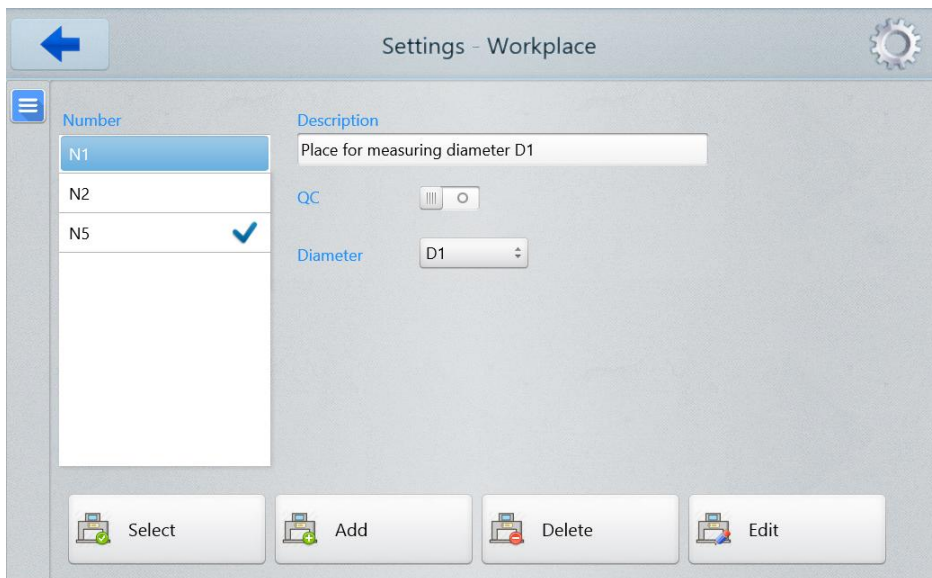
To save the part template, tap **Save**. The program returns to the list of controlled parts and displays the parameters of the saved template.



Diameter	A	L	QC	Gr.0	Gr.1	Gr.2	Gr.3	Gr.4
D1	0,00	40,00		14,960 -0,015	14,980 -0,010	14,990 -0,010	15,000 -0,010	0,000 0,000
D2	50,00	20,00	●	13,000 -0,010				
D3	100,00	20,00	●	10,000 -0,020				

7.2.6. Workplace

The machine can be installed on workplaces of various types (production line, quality control department). On production lines, only one selected zone is measured at each workplace. During the quality control, the whole shaft is measured without sorting into groups) To set the workplace type and its description, tap **Workplace**.



The list of workplace numbers is shown in the left side of the window.

The workplace number of the machine is marked with ✓.

Description of the workplace (in the right side of the window) is given for the workplace number highlighted in blue in the list to the left.

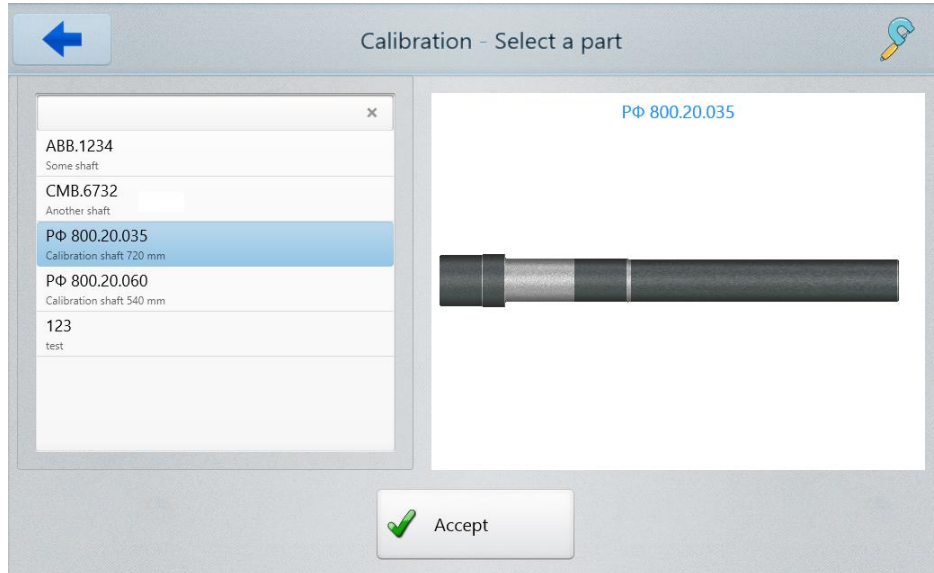
If the **QC** toggle is enabled, this workplace relates to the quality control department, and the measurements are performed in full (without sorting into groups).

To describe the workplace (not QC), disable the **QC** toggle and follow the steps below:

- Select (**Select** button), or add (**Add** button), and then select the workplace number.
- Select the controlled diameter from the **Diameter** drop-down list.
- Describe the workplace in the **Description** text box.

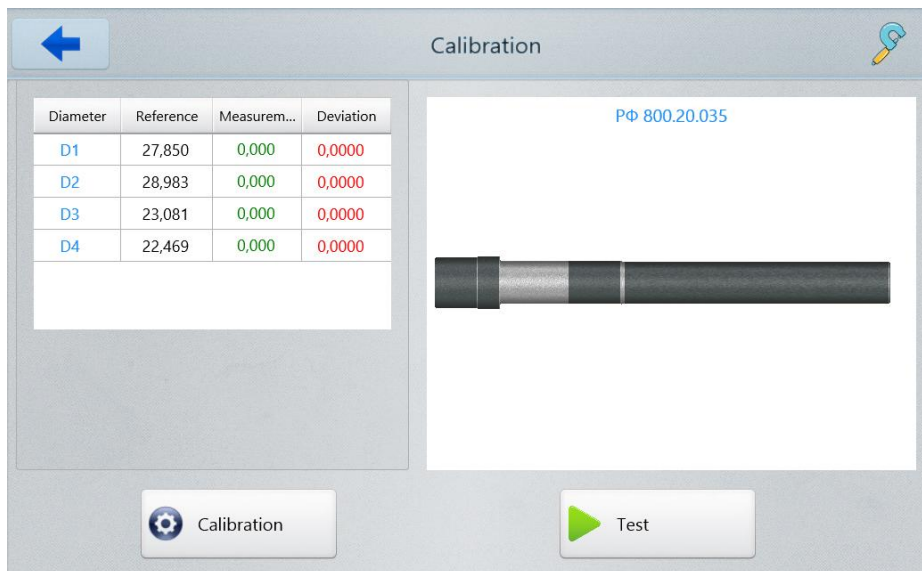
7.3. Calibration

To perform the calibration of the machine, go to the main menu and tap **Calibration**.

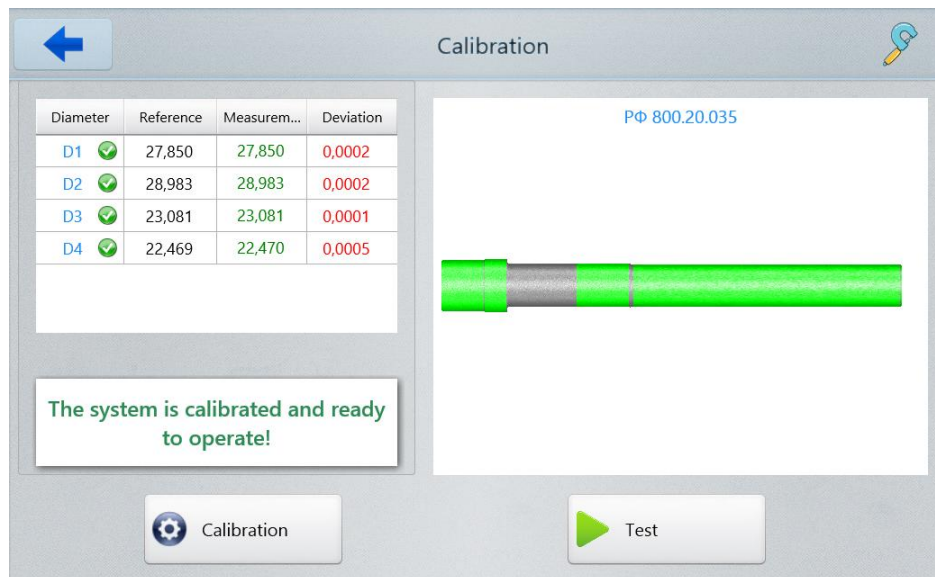


16

Select the shaft that will be used as the caliber. Tap **Accept**. The program displays the description of the selected shaft.

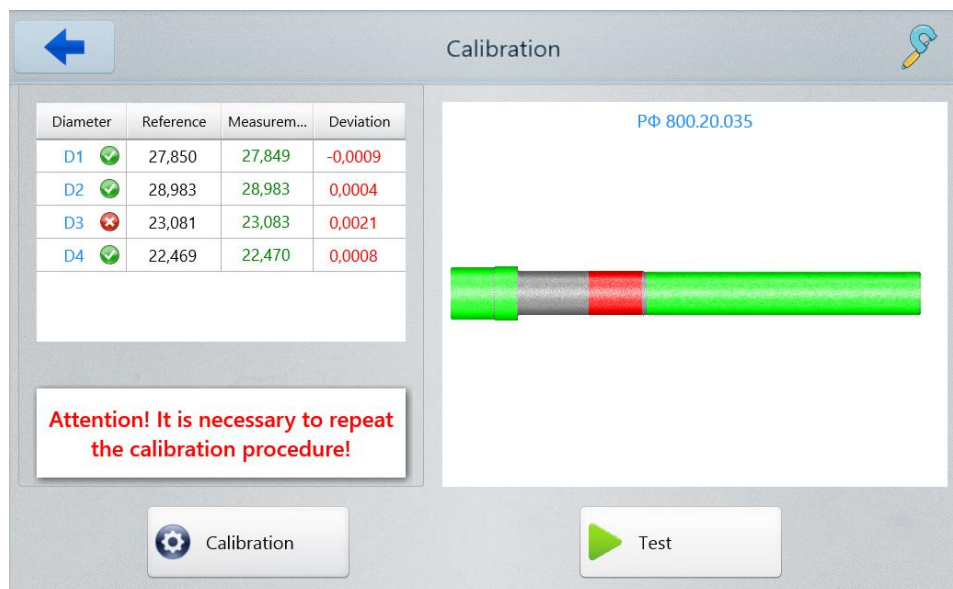


Install the shaft into the machine, and tap **Calibration**. The shaft will be scanned. If necessary, parameters of the optical micrometers will be corrected automatically, and then the shaft will be scanned again in order to test the machine. If successful, the following window appears:



The **Deviation** column shows the difference between the actual value and the measurement result. The calibration is successful if the deviation value doesn't exceed the tolerance (**Tolerance for calibration**, see par. [7.2.3.](#)).

If the calibration is not successful, the following window appears:



Zones, in which the measurement result exceeds the tolerance, are shown in red.

Repeat the calibration procedure until you see the message informing about success.

8. Intended use

8.1. Preparation for use

Preparation of the machine includes:

- visual inspection,
- installation,
- switching on the machine,
- setting parameters and forming the database of templates,
- calibration of the machine,
- metrological verification of the machine.

8.1.1. Visual inspection

Before operating, it is needed to ensure of the serviceability of the machine:

- check the cables and ground wires,
- check the condition of output windows of the micrometer, and, if necessary, wipe them with a soft lint-free cloth.

8.1.2. Installation

Install the machine on the equipment. Connect the power cable (220V).

8.1.3. Switching on the machine

Feed power to the machine by switching on the circuit breaker, see Figure 3.

8.1.4. Setting parameters and forming the database of templates

Set parameters in accordance with p. [7.2](#). Form the database of templates in accordance with p. [7.2.5](#).

8.1.5. Calibration

Calibrate the machine in accordance with p. [7.3](#). The calibration procedure must be performed:

- daily before the work shifts,
- in case of changing the shaft type,
- if the position of the machine was changed.

8.1.6. Metrological verification

Metrological verification of the machine must be performed:

- before commissioning,
- after repair,
- periodically during operation.

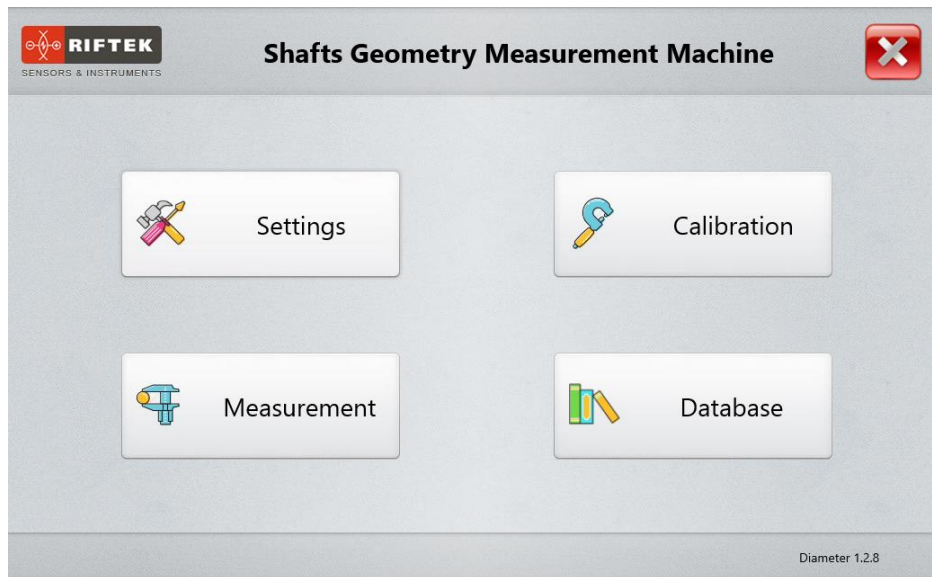
8.2. Working with the machine

The measurement of geometrical parameters is fully automated and the work with the machine is reduced to the mechanical adjustment, and then to the work with the software. Follow the steps below:

- Configure the machine to operate with the shaft of the appropriate diameter, see par. [8.2.1](#).
- Configure the machine to operate with the shaft of the required length, see par. [8.2.2](#).
- Start the software, see par. [7](#).
- Install the controlled shaft into the machine.

ATTENTION: It is necessary to clean the shaft from cutting fluid and oil before installing into the machine!

- Tap the **Measurement** button.



8.2.1. Shafts of different diameters

The machine is equipped with the Morse tapers of two types: a small taper and a big taper (see Figure 5 and Table 5 in Catalog RF800.00.000, items 7 and 8). To replace the tapers, it is necessary to: unscrew the calibers, get the tapers, tighten the calibers, install the new tapers.

8.2.2. Shafts of different lengths

To measure the shafts of different lengths, the machine is adjusted by moving the upper rack of the Morse taper with the end sensor fixed to it along the table (see Figure 5 in Catalog RF800.00.000).

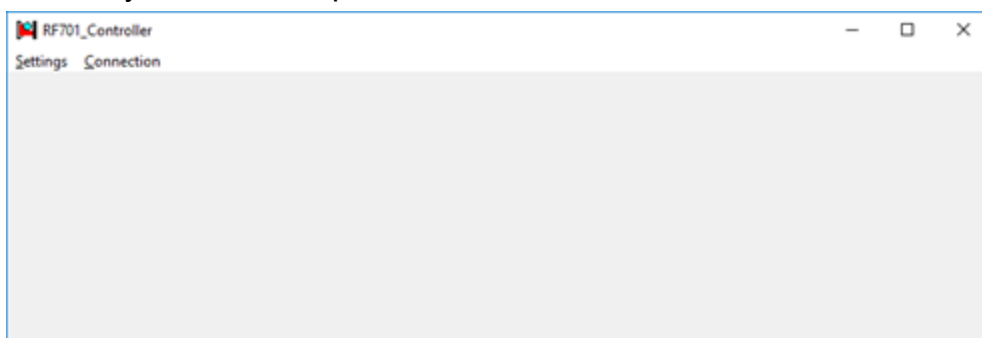
8.2.3. Setting the origin of the linear coordinate

After you replace the support taper, it is necessary to set the origin of the linear coordinate.

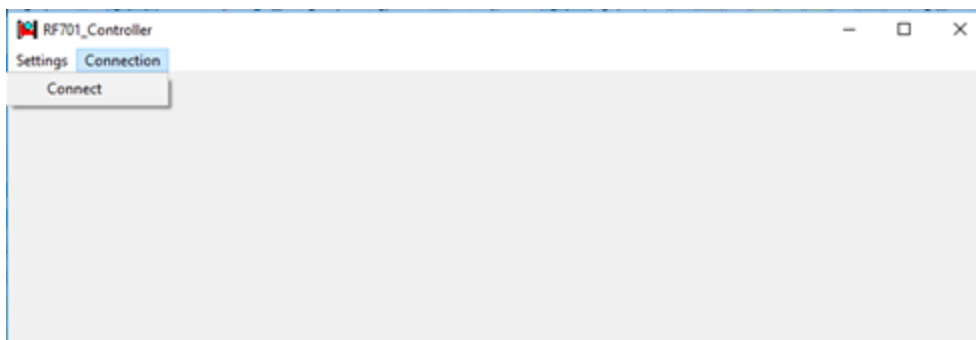
The upper end sensor, installed on the movable Morse taper, specifies the origin of the linear coordinate of the linear translation system (the coordinate of the starting position of the micrometer). In the starting position, the micrometer must be positioned so that the caliber (the part of the Morse taper) is placed within the measurement zone of the micrometer.

Follow the steps below:

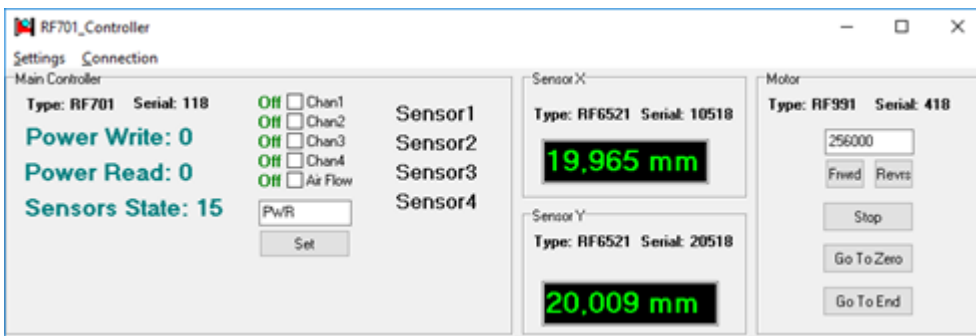
1. Start **RF701_Controller.exe**, which is in the **Riftek install \RF701_Controller** directory on the desktop of the mini-PC.



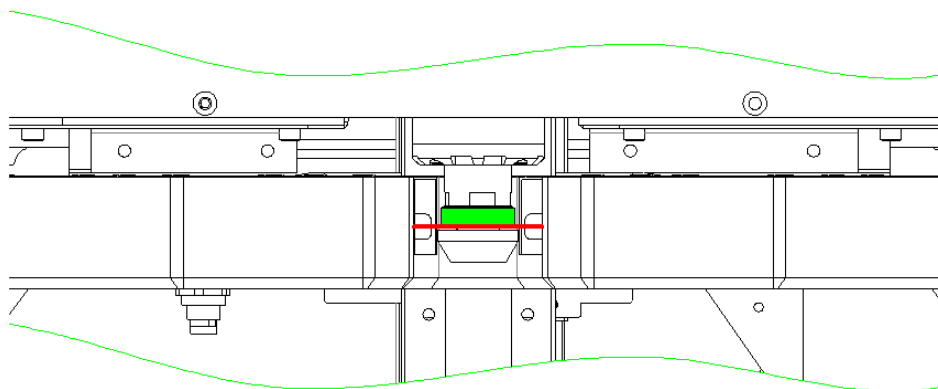
2. In the **Settings** menu, select a port: **COM4**.
3. Select **Connection > Connect** in order to connect to the system.



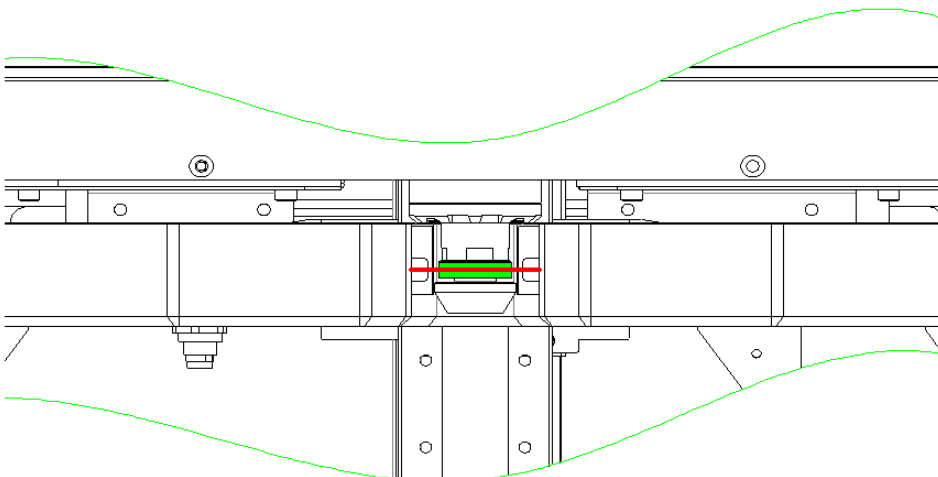
4. Tap the **GoToEnd** button in order to move the micrometer to the lowest position.



5. Install the rack 3 (see Figure 4 in Catalog RF800.00.000) at the highest position.
6. Install the shaft into the machine. **ATTENTION:** the shaft must be installed!
7. Tap the **GoToZero** button in order to move the micrometer to a zero position.
The caliber must be on the beam axis of the micrometer.
The figure below illustrates the incorrect position of the micrometer:



The figure below illustrates the correct position of the micrometer:

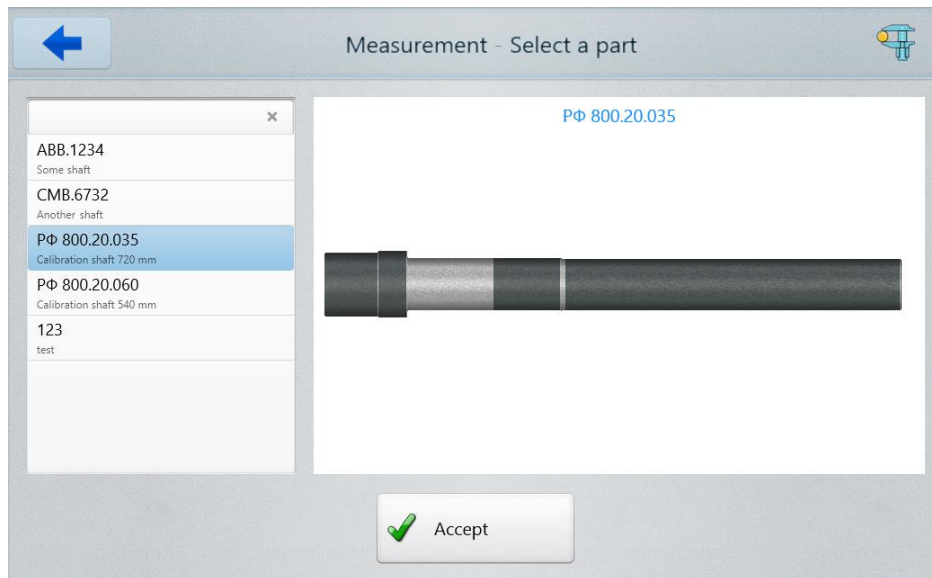


8. If the setting is incorrect, tap the **GoToEnd** button in order to move the micrometer to the lowest position.
9. Screw the rack 1-2 turns.
10. Repeat steps 6-9 until the beam axis of the micrometer is on the axis of the caliber.
11. Secure the rack by using the counter bush.

8.2.4. Template selection

Select the template from the list. The template that was used for calibration is highlighted in blue.

21



After you select the template, tap the **Accept** button. The program will display the parameters of the selected template:



In this window, you can see the following: the number of the shaft is PΦ800.20.035, the workplace is the D3 diameter control (highlighted in blue in the table and in the figure), not QC (QC toggle is disabled). If the selected template is what you need, tap **Accept**, otherwise go back to the previous window (tap on the blue arrow), and select another template.

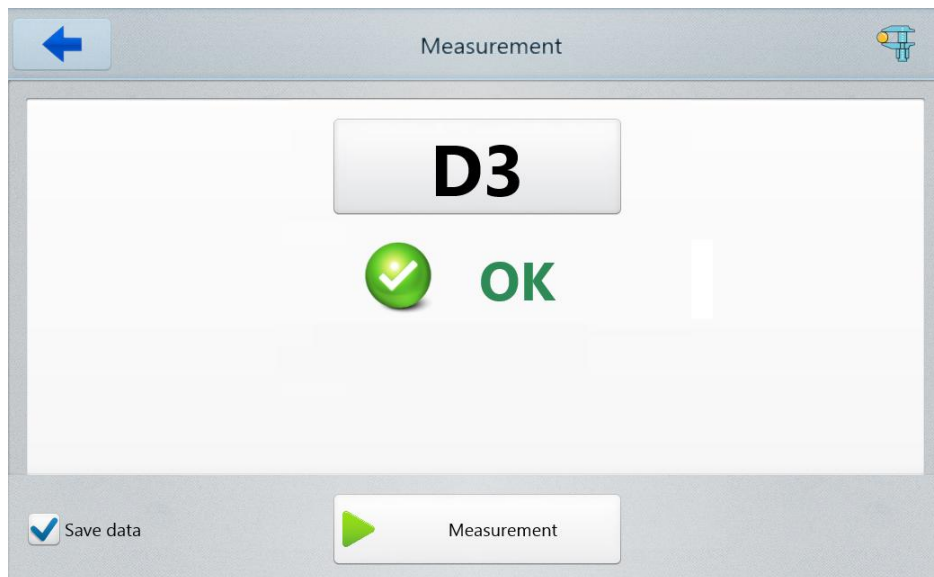
8.2.5. Measurement

After you select the template, the program prompts to start the measurement process:



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If you need to save the result to the database, select the **Save data** option. Tap the **Measurement** button, or press the foot switch. If the result is acceptable, the program will display the following:



For more information, tap **D3**:

←
Measurement

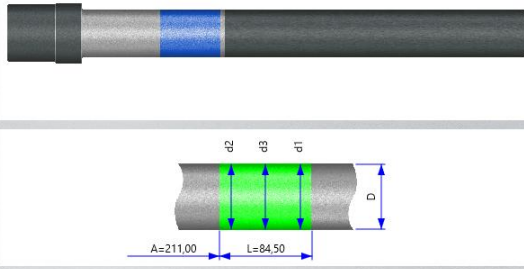

	d1	d3	d2
Actual size	23,080	23,081	23,082
Belongs to the group	Gr. 4	Gr. 4	Gr. 4
Average diameter D3	23,081		
Group	Group 4		
Suitability	OK 		
Ovality	---		
Taper	---		

☒ Save data



Measurement

PΦ 800.20.035



The shaft is considered suitable if the diameters in all three controlled sections of the zone are in the same sorting group, and if the ovality and taper do not exceed the tolerance set for this sorting group.

To measure the shaft again or to measure the new shaft, install the shaft into the machine and repeat the measurement procedure described in this paragraph.

If the result is not acceptable, the program will display the following (Diameter D2 Control):

←
Measurement


D2


NOK

Backlog	
Taper	0,009

☒ Save data



Measurement

For more information, tap **D2**:

Measurement

	d1	d2
Actual size	28,983	28,992
Belongs to the group	Gr. 4	---
Average diameter D2	28,988	
Group	---	
Suitability	Backlog	
Ovality	---	
Taper	0,009	

D2 ---

PΦ 800.20.035

A=67,00 L=36,00

☒ Save data

An example of measuring the shaft during the Quality Control (diameter D1):
The selected template:

Measurement

Quality Control

Diameter	L/A	QC	D
D1	L=0,00 A=67,00	●	27,850
D2	L=67,00 A=36,00		28,983
D3	L=211,00 A=84,50		23,081
D4	L=300,50 A=419,50		22,469

PΦ 800.20.035

☒ Accept

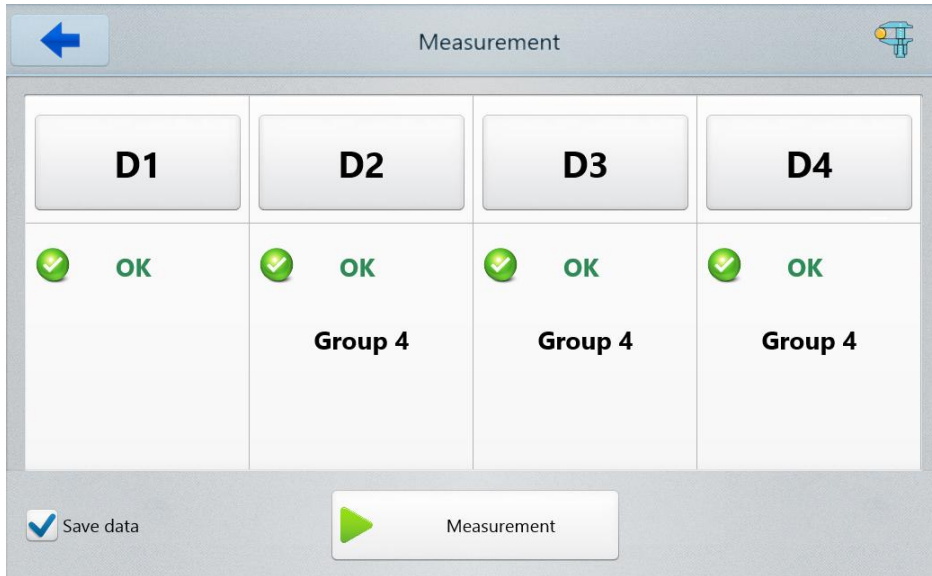
During the measurement process, the program displays the following.

Measurement

D1	D2	D3	D4
	---	---	---

☒ Save data

The measurement result (acceptable):

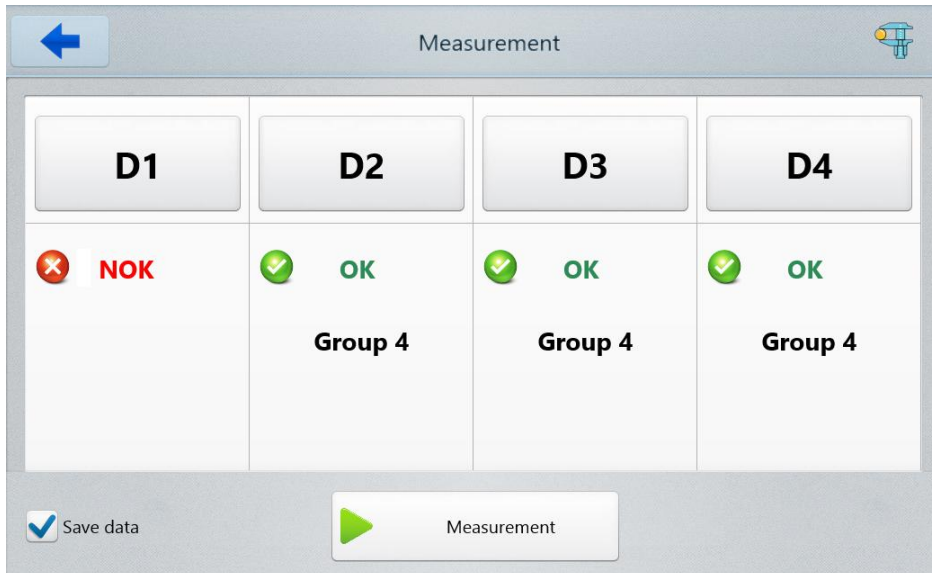


The screenshot shows the 'Measurement' screen with a back arrow on the top left and a probe icon on the top right. It contains a 2x4 grid of buttons labeled D1, D2, D3, and D4. Below each button is a green checkmark icon followed by the text 'OK'. Underneath the 'OK' text, the label 'Group 4' is displayed for D2, D3, and D4. At the bottom left, there is a checked checkbox labeled 'Save data'. At the bottom right, there is a green play button icon followed by the text 'Measurement'.

D1	D2	D3	D4
✓ OK	✓ OK	✓ OK	✓ OK
	Group 4	Group 4	Group 4

☒ Save data  Measurement

The measurement result (defective):



The screenshot shows the 'Measurement' screen with a back arrow on the top left and a probe icon on the top right. It contains a 2x4 grid of buttons labeled D1, D2, D3, and D4. Below the D1 button is a red 'X' icon followed by the text 'NOK'. Below the D2, D3, and D4 buttons is a green checkmark icon followed by the text 'OK'. Underneath the 'OK' text, the label 'Group 4' is displayed for D2, D3, and D4. At the bottom left, there is a checked checkbox labeled 'Save data'. At the bottom right, there is a green play button icon followed by the text 'Measurement'.

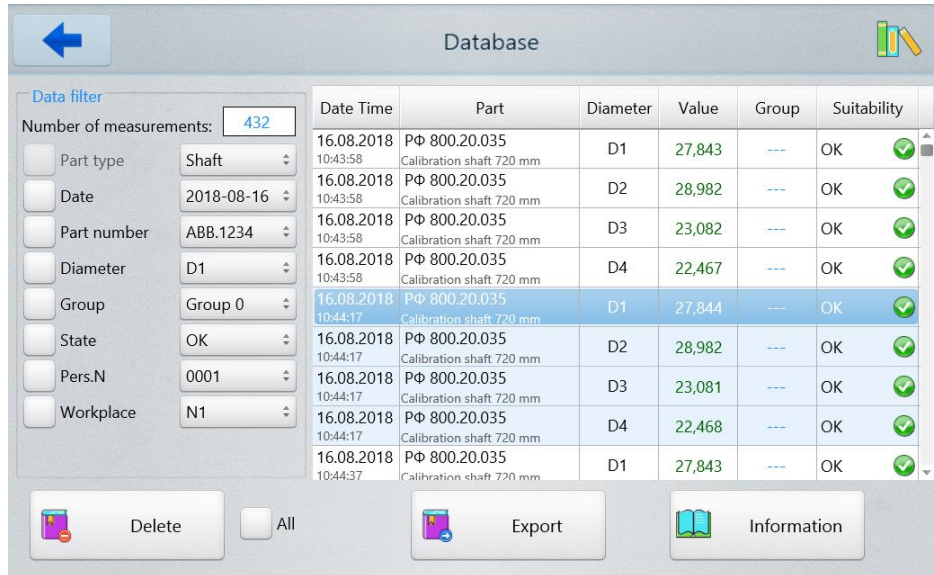
D1	D2	D3	D4
✗ NOK	✓ OK	✓ OK	✓ OK
	Group 4	Group 4	Group 4

☒ Save data  Measurement

For more information, tap the **D1...D4** buttons.

8.3. Working with the database

The results will be saved to the database, if the **Save data** option is enabled (see par. 8.2.5.). To go to the database, tap the **Database** button in the main window. The program will display the database:

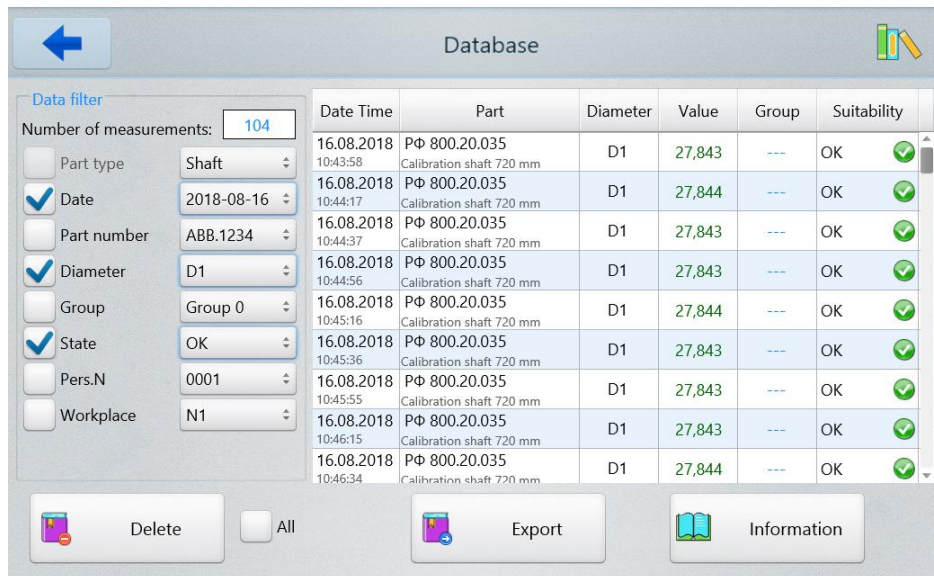


The screenshot shows the 'Database' window with a 'Data filter' section on the left and a table of measurements on the right. The 'Number of measurements' field shows 432. The filter controls include checkboxes for 'Part type', 'Date', 'Part number', 'Diameter', 'Group', 'State', 'Pers.N', and 'Workplace', each with a dropdown menu. The table has columns: Date Time, Part, Diameter, Value, Group, and Suitability. The table contains 10 rows of data, all with a 'Suitability' of 'OK' and a green checkmark icon.

Date Time	Part	Diameter	Value	Group	Suitability
16.08.2018 10:43:58	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK
16.08.2018 10:43:58	PΦ 800.20.035 Calibration shaft 720 mm	D2	28,982	---	OK
16.08.2018 10:43:58	PΦ 800.20.035 Calibration shaft 720 mm	D3	23,082	---	OK
16.08.2018 10:43:58	PΦ 800.20.035 Calibration shaft 720 mm	D4	22,467	---	OK
16.08.2018 10:44:17	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,844	---	OK
16.08.2018 10:44:17	PΦ 800.20.035 Calibration shaft 720 mm	D2	28,982	---	OK
16.08.2018 10:44:17	PΦ 800.20.035 Calibration shaft 720 mm	D3	23,081	---	OK
16.08.2018 10:44:17	PΦ 800.20.035 Calibration shaft 720 mm	D4	22,468	---	OK
16.08.2018 10:44:37	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK

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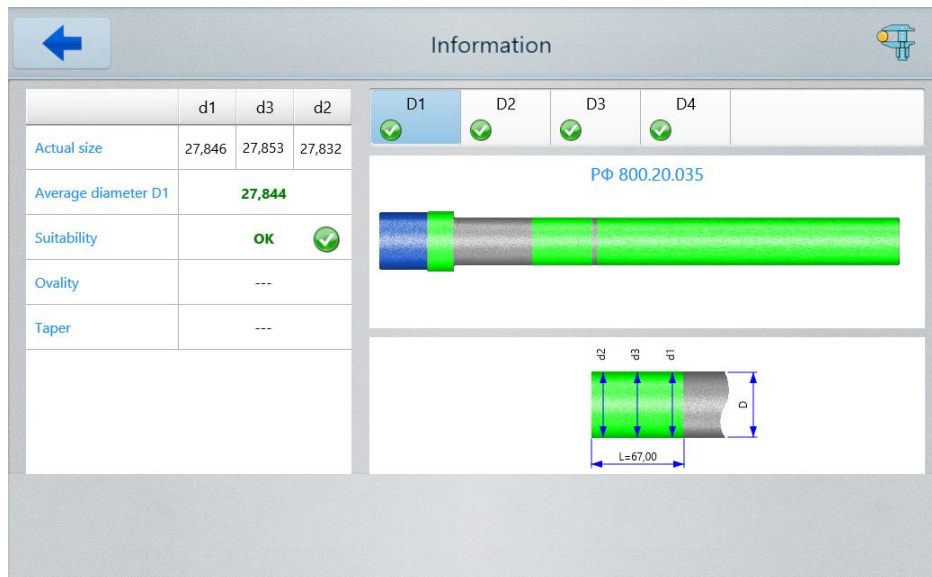
In the right part of the window there is a list of measured shafts and their parameters. In the left part of the window there are the data filter controls. You can use any combination of filters. An example of filtering is shown below (by date, diameter, state). The number of measured shafts is shown in the **Number of measurements** field.



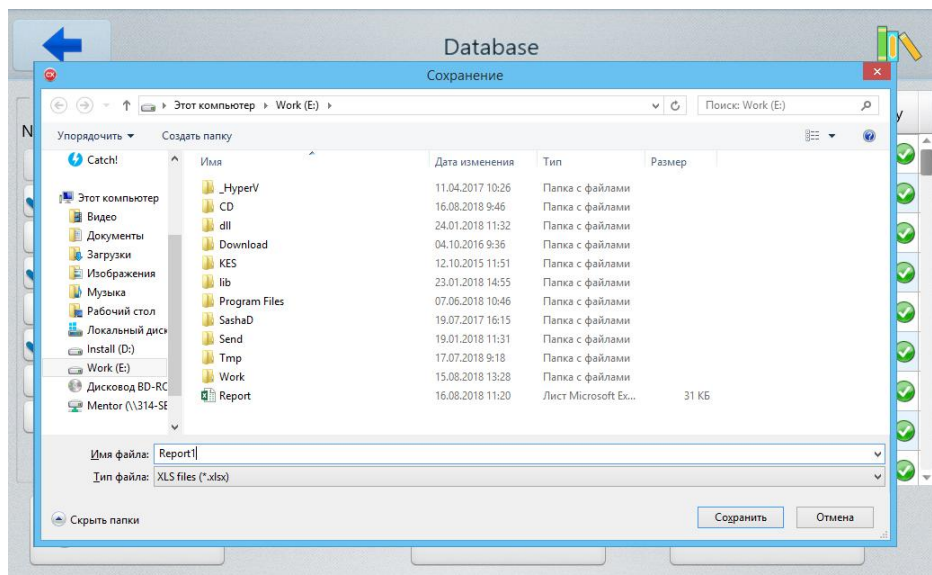
The screenshot shows the 'Database' window with the 'Data filter' section on the left and a table of measurements on the right. The 'Number of measurements' field shows 104. The filter controls include checkboxes for 'Part type', 'Date', 'Part number', 'Diameter', 'Group', 'State', 'Pers.N', and 'Workplace', each with a dropdown menu. The table has columns: Date Time, Part, Diameter, Value, Group, and Suitability. The table contains 10 rows of data, all with a 'Suitability' of 'OK' and a green checkmark icon.

Date Time	Part	Diameter	Value	Group	Suitability
16.08.2018 10:43:58	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK
16.08.2018 10:44:17	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,844	---	OK
16.08.2018 10:44:37	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK
16.08.2018 10:44:56	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK
16.08.2018 10:45:16	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,844	---	OK
16.08.2018 10:45:36	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK
16.08.2018 10:45:55	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK
16.08.2018 10:46:15	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,843	---	OK
16.08.2018 10:46:34	PΦ 800.20.035 Calibration shaft 720 mm	D1	27,844	---	OK

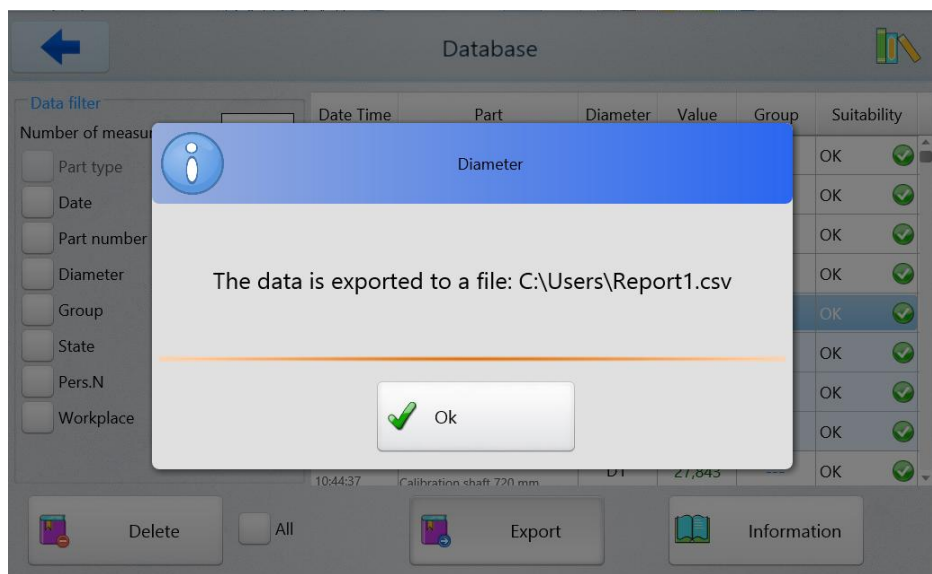
To view all parameters, select the shaft from the list by tapping on the string, and then tap the **Information** button.



To export data to a file, tap the **Export** button, select the file type and path:



If successful, you will see the following message:



9. Maintenance

9.1. General instructions

Maintenance of the machine is carried out to ensure a constant-ready status, and to prevent premature failure. Maintenance includes preventive measures aimed at identifying and eliminating the defects, and at ensuring the normal operation of the machine. It is recommended to perform the daily and annual maintenance work.

9.2. Safety precautions

Observe the safety precautions outlined in Paragraph 1 of this User's Manual.

9.3. Maintenance procedure

9.3.1. Daily maintenance work

Daily maintenance work includes:

- visual inspection of the machine,
- checking the completeness of the machine,
- checking for any damage to structural elements, power and instrument cables, display and connectors,
- checking for the presence of contamination on the linear guide, and, if necessary, wiping with a clean lint-free cloth,
- checking the loosening of screw connections,
- optical signal quality control.

9.3.1.1. Checking the loosening of screw connections

Check the screw connections of the linear translation system, micrometer, and table. Tightening force should provide the backlash-free connection and not lead to destruction of the threaded connection.

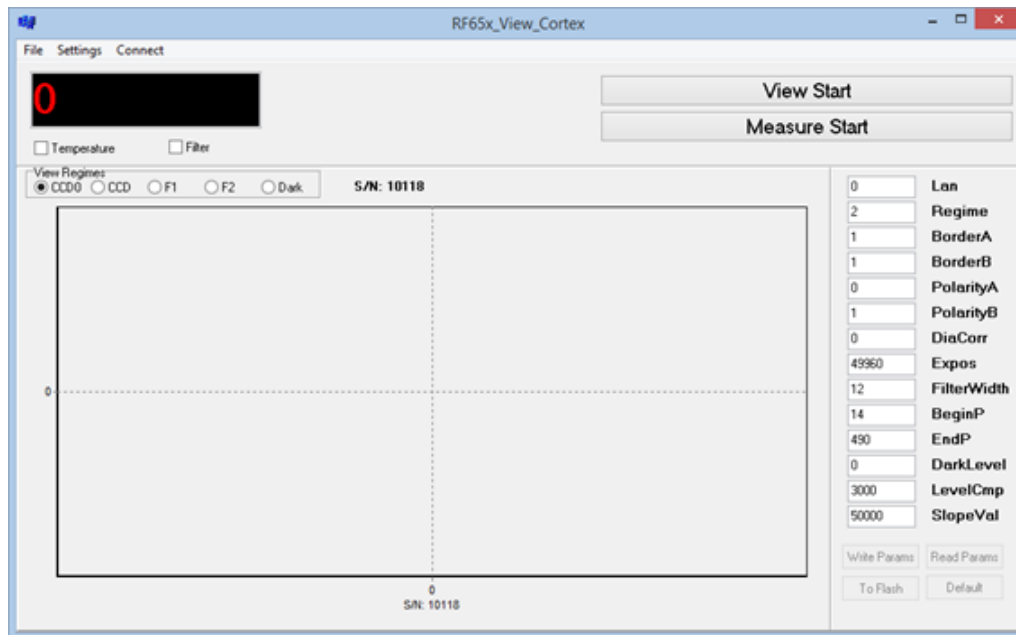
Tight the fixing screws of the racks until there are no gaps, but apply a force no more than 1.3 N•m.

9.3.1.2. Optical signal quality control

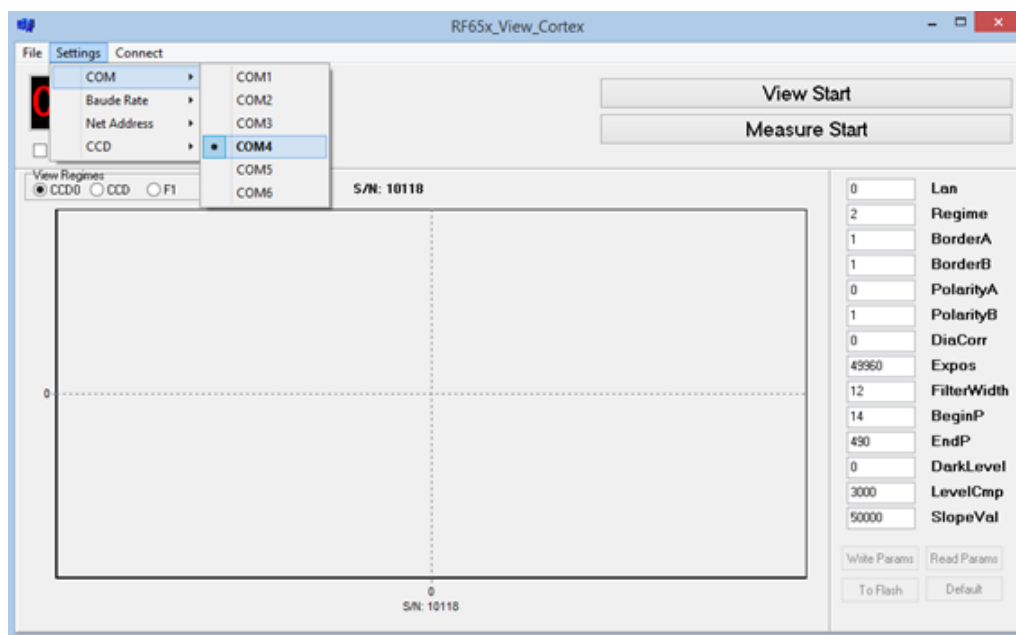
To ensure the required measurement accuracy, the optical windows of the micrometer should not have any contamination or damage. Controlling the quality of the optical signal allows to assess the degree of contamination.

Please follow the steps below:

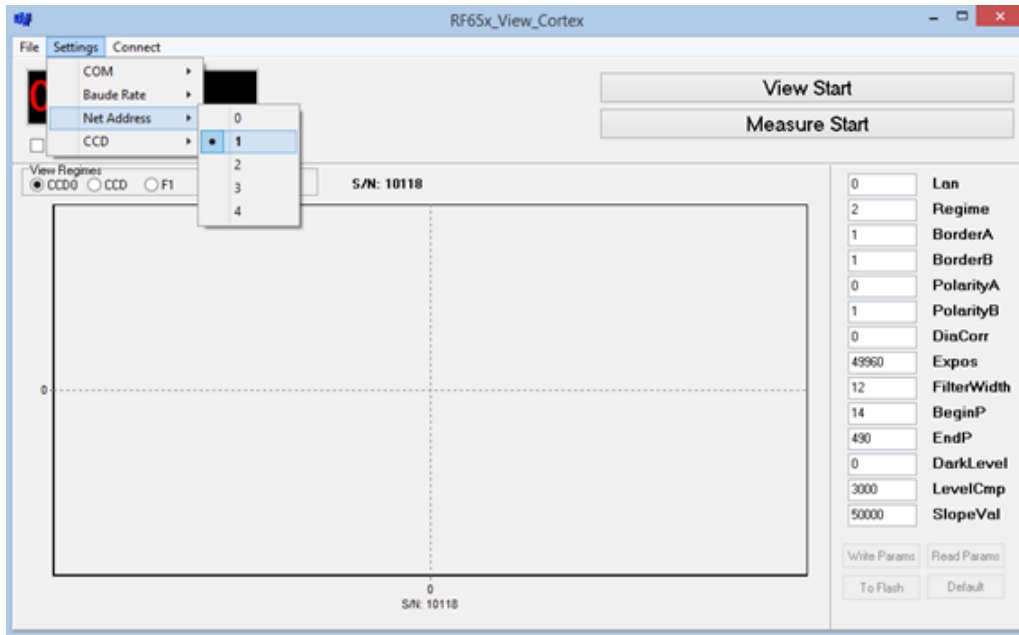
1. Run the executable file **RF65x_View_Cortex.exe**, which you can find in the **Riftek install\RF65x_View_Cortex** directory on the desktop of the mini-PC.



2. In the **Settings** menu, select **COM > COM4**.



3. In the **Settings** menu, select **Net Address > 1** in order to connect to the X channel of the micrometer.

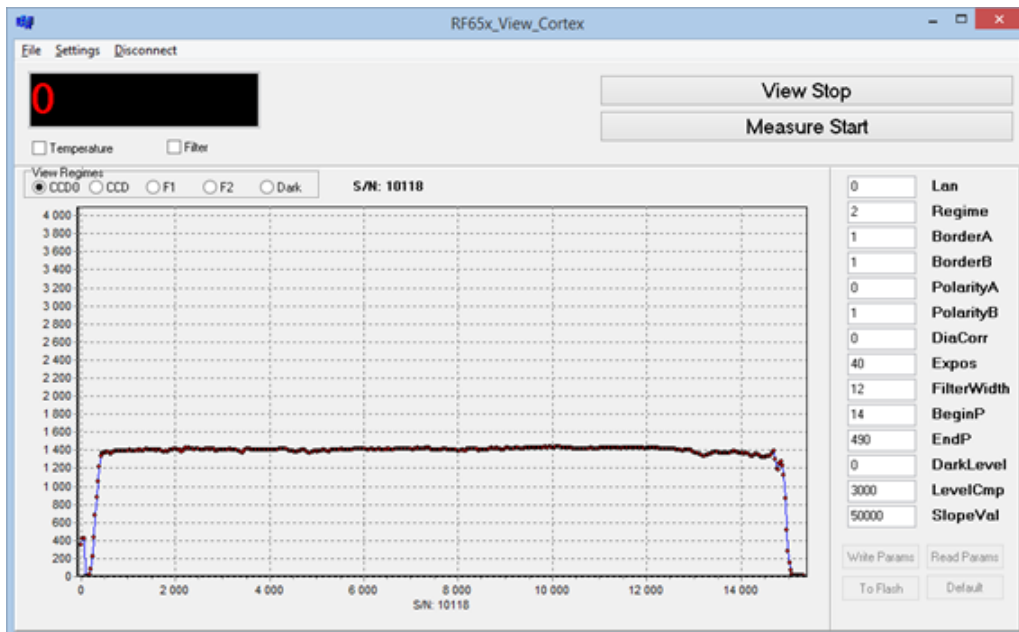


4. Tap **Connect** to establish connection with the micrometer.

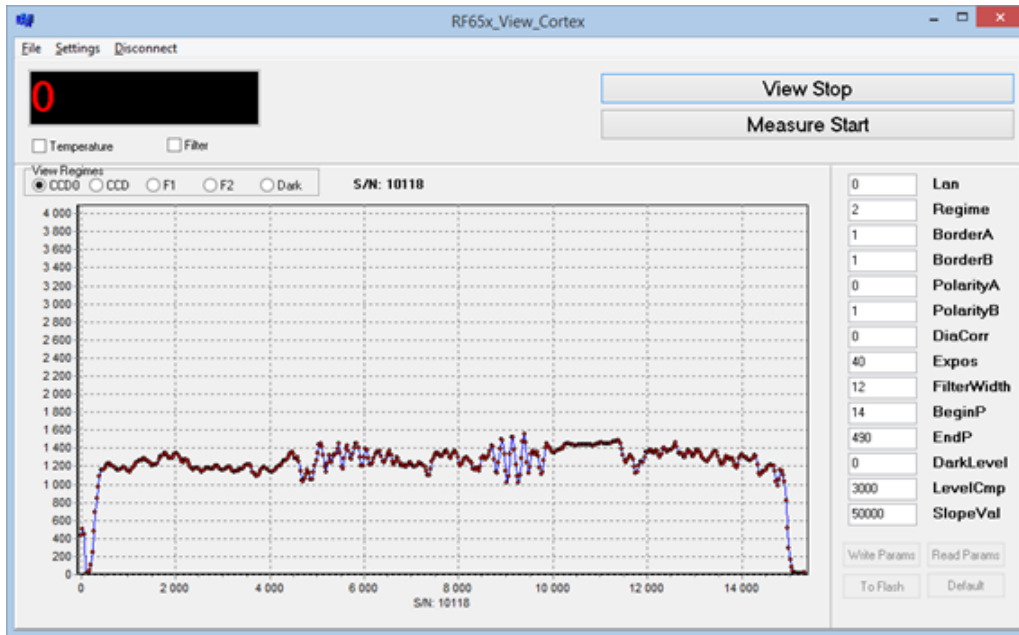
5. Tap **View Start** to run the **Optical signal view** mode.

Windows are considered clean if the amplitude of signal irregularity does not exceed 150 units (vertical scale).

An example of the signal when the windows of the micrometer are clean:



An example of the signal when the windows of the micrometer have contamination:



6. If necessary, clean the windows. **ATTENTION:** Cleaning is best done with a soft dry lint-free cloth. In order to remove fingerprints or grease, use the alcohol or alcohol-ether mixture. Do not use scratching cleaners or other aggressive media.
7. In the **Settings** menu, select **Net Address > 2** in order to connect to the Y channel of the micrometer (see step 3).
8. Repeat steps 3-5 for the Y channel of the micrometer.

9.3.2. Annual maintenance work

Annual maintenance work includes:

- lubrication of the Morse tapers,
- metrological verification of the machine.

10. Warranty policy

Warranty assurance for Shafts Geometry Measurement Machine RF800 Series - 12 months from the date of putting in operation; warranty shelf-life - 12 months.

11. Revisions

Date	Revision	Description
01.08.2018	1.0.0	Starting document.

12. Distributors

AUSTRIA

MBM Industry & Rail Tech GmbH

RAILWAY INSTRUMENTS ONLY

Tullnerbachstraße 36,
A-3002 Purkersdorf, Austria
Tel: +43 2231 66000
Fax: +43 2231 66000 12
office@mbm-industrietechnik.at
www.mbm-tech.at

AUSTRALIA

Applied Measurement Australia Pty Ltd

RAILWAY INSTRUMENTS ONLY

Thornton Plaza, Unit 5,
27 Thornton Crescent, Mitcham
VIC 3132, Australia
Tel: +61 39874 5777
Fax: +61 39874 5888
sales@appliedmeasurement.com.au
www.appliedmeasurement.com.au

BENELUX

Altheris B.V.

Vietweg 17a
2266KA Leidschendam
The Netherlands
Tel: +31 70 3924421
Fax: +31 70 3644249
sales@altheris.nl
www.altheris.com

BULGARIA, HUNGARY

RMT Ltd.

R Zahradni 224
739 21 Paskov, Czech Republic
Tel: +420 558640211
Fax: +420 558640218
rmt@rmt.cz
www.rmt.cz

BRAZIL

CAPi Controle e Automação Ltda

Rua Itororo, 121, CEP 13466-240
Americana-SP, Brazil
Tel: +55 19 36047068
Fax: +55 19 34681791
capi@capicontrol.com.br
www.capicontrol.com.br

CHILE

Verne SpA

Apoquindo 2818, oficina 31,
Las Condes, Santiago, Chile
Tel: +56 2 228858633
info@verne.cl
jsaavedra@verne.cl
www.verne.cl

CHINA

Zhenshangyou Technologies Co., Ltd.

Rm 2205-2210, Zhongyou Hotel
1110 Nanshan Road, Nanshan
District 518054 Shenzhen, China
Tel: +86 755-26528100/8011/8012
Fax: +86 755-26528210/26435640
info@51sensors.com
www.51sensors.com

CHINA

Shanghai micron-metrology com., Ltd.

Room 602 unit 4, lane 399,
Mudan road, Pudong New district
Shanghai, China
Tel: +86-21-68416510
sales@micron-metrology.cn
www.micron-metrology.cn

CHINA

JRKtech Co., Ltd.

1F, Building 9, 100 Xianlie Rd.,
Guangzhou, China
Tel: +86 755 85267190/
+86 15989362481
Fax: +86 755 85267190
shengz_k@163.com
www.jrktech.com

CZECH REPUBLIC

RMT Ltd.

Zahradni 224
739 21 Paskov, Czech Republic
Tel: +420 558640211
Fax: +420 558640218
rmt@rmt.cz
www.rmt.cz

FINLAND

TERASPYORA-STEELWHEEL OY

RAILWAY INSTRUMENTS ONLY

Juvan teollisuuskatu 28
FI-02920 ESPOO, Finland
Tel: +358 400 422 900
Fax: +358 9 2511 5510
steelwheel@steelwheel.fi
www.teraspyora.fi

FRANCE

DB Innovation (ALTHERIS France)

26, avenue de la Mediterranee
34110 Frontignan France
Tel: +33-467786166
Fax: +33-467740134
dbi@altheris.fr
www.altheris.fr

GERMANY

Disynet GmbH
 Breyeller Str. 2
 41379, Brueggen
 Tel: +49 2157 8799-0
 Fax: +49 2157 8799-22
disynet@sensoren.de
www.sensoren.de

GERMANY

Hylewicz CNC-Technik
SHTRIKH-2 ONLY
 Siemensstrasse 13-15,
 47608 Geldern, Germany
 Tel: +49 2831 91021-20
 Fax: +49 2831 91021-99
info@cnc-step.de
www.cnc-step.de

INDONESIA

PT. DHAYA BASWARA
SANIYASA
 Botanic Junction Blok H-9 NO. 7
 Mega Kebon Jeruk, Joglo
 Jakarta 11640, Indonesia
 Tel: + 62 21 29325859
management@ptdbbs.co.id

ITALY

FAE s.r.l.
 Via Tertulliano, 41
 20137 Milano, Italy
 Tel: +39-02-55187133
 Fax: +39-02-55187399
fae@fae.it
www.fae.it

NORWAY

Salitec AS
 PB 468,
 N-1327 Lysaker
 Tel.: +47 23 891015
 Fax: +47 92101005
mail@salitec.no
www.salitec.no

GERMANY

BIP-Industrietechnik GmbH
RAILWAY INSTRUMENTS ONLY
 Am Elisabethhof 22,
 D-14772 Brandenburg
 D-41379 Brueggen, Germany
 Tel: +49 (0) 33 81 75 90 0
 Fax: +49 (0) 33 81 75 90 11
info@bip-industrie.de
www.bip-industrietechnik.de

INDIA

Pragathi Solutions
 #698, 5th Main, 8th Cross,
 HAL 3rd Stage,
 New Tippasandra Road,
 Bangalore, 560075, India
 Tel: +91 80 32973388
 Tel/fax: +91 80 25293985
 Mobile: +91 9448030426/
 +919448492380
sales@pragathisolutions.in
arghya@pragathisolutions.in
www.pragathisolutions.in

IRAN

Novin Industrial
Development Grp.
 Tel: +98 21 44022093-6
 Fax: +98 21 43858794
 Mobile: +98 9123207518
info@novinid.com
www.novinid.com

LATVIA, ESTONIA

SIA "SOLARTEX"
RAILWAY INSTRUMENTS ONLY
 Dunties 15a, 5th floor, office B7
 Riga, Latvia
 Tel.: +371 67 130 787
solartex@inbox.lv

PERU

Verne Peru S.A.C.
 Las Codornices 104,
 Surquillo, Lima, Peru
 Tel/fax: +51 992436734
info@verne.cl
www.verne.cl

GERMANY

Finger GmbH & Co. KG
OPTICAL MICROMETERS ONLY
 Sapelloh 172,
 31606 Warmssen, Germany
 Tel: +49 5767 96020
 Fax: +49 5767 93004
finger@finger-kg.de
www.finger-kg.de

INDIA

Paragon Instrumentation
Engineers Pvt. Ltd.
RAILWAY INSTRUMENTS ONLY
 200, Station Road,
 Roorkee, 247 667, India
 Tel: +91-1332-272394
tanuj@paragoninstruments.com
www.paragoninstruments.com

ISRAEL

Nisso Dekalo Import
Export LTD
 1 David Hamelech Street
 Herzlia 46661 Israel
 Tel: +972-99577888
 Fax: +972-99568860
eli@fly-supply.net
www.fly-supply.net
www.aircraft-partsupply.com

MALAYSIA

OptoCom InstruVentures
 H-49-2, Jalan 5, Cosmoplex
 Industrial Park, Bandar Baru
 Salak Tinggi, Sepang, Malaysia
 Tel: 603 8706 6806
 Fax: 603 8706 6809
optocom@tm.net.my
www.optocom.com.my

POLAND

MTL ASCO Sp. z o.o.
RAILWAY INSTRUMENTS ONLY
 ul. Wielowiejska 53 44-120
 PYSKOWICE (k/ GLIWIC),
 Poland
 Tel: + 48 32 230 45 70
 Fax: + 48 32 332 70 14
rail@ascorail.eu
www.ascorail.eu

PORTUGAL

UltraSens

Qt. da Portela, Lt. 22.1, Ap. 152
 3030 - 502 Coimbra, Portugal
 Phone +351 239 796 277
 Fax: +351 239 918 267
info@ultrasens.com
www.ultrasens.com

SERBIA, SLOVAKIA

RMT Ltd.

Zahradni 224
 739 21 Paskov, Czech Republic
 Tel: +420 558640211
 Fax: +420 558640218
rmt@rmt.cz
www.rmt.cz

SPAIN

Iberfluid Instruments S.A.

C/ Botanica, 122
 08908 L'Hospitalet de Llobregat,
 Barcelona
 Tel: +34 93 447 10 65
 Fax: +34 93 334 05 24
myct@iberfluid.com
www.iberfluid.com

SWEDEN, DENMARK

Latronix AB

Propellervagen 10,
 183 62 Taby, Sweden
 Tel.: +46 08-446 48 30
 Fax: +46 08-446 48 39
sales@latronix.se
www.latronix.se

UKRAINE

KODA

Frunze st 22
 61002, Harkov, Ukraine
 Tel/fax: +38 057 714 26 54
mail@koda.com.ua
www.koda.com.ua

RUSSIA

Sensorika-M LLC

Dmitrovskoye shosse 64-4
 127474, Moscow, Russia
 Tel: +7 499 487 0363
 Fax: +7 499 487 7460
info@sensorika.com
www.sensorika.com

SOUTH AFRICA

Ratcom Enterprise Pty Ltd

CSIR BUILDING 35, Office 78
 Meiring Naude Road, Brummeria
 Pretoria, 0084 South Africa
 Tel: + 27 12 841 2032
 Fax: + 27 86 225 0650
info@ratcom.co.za
www.ratcom.co.za

SWITZERLAND

ID&T GmbH

Gewerbstrasse 12/a
 8132 Egg (Zurich), Switzerland
 Tel: + 41 44 994 92 32
 Fax: + 41 44 994 92 34
info@idtlaser.com
www.idtlaser.com

THAILAND

Advantech Solution Co.,Ltd.

20/170 Motorway Rd.,
 Kwang Pravet, Khet Pravet,
 Bangkok, Thailand 10250
 Tel: +662-1848705
 Fax: +662-1848708
sales@advantechsolution.com
www.advantechsolution.com

UNITED KINGDOM, IRELAND

Ixthus Instrumentation Ltd

The Stables, Williams' Barns
 Tiffeld road, Towcester, Northants
 Tel: +44 1327 353437
 Fax: +44 1327 353564
info@ixthus.co.uk
www.ixthus.co.uk

RUSSIA

Diesel-test-Komplekt LLC

620030, Karjernaya St, 16
 Ekaterinburg, Russia
 Tel/fax: +7 343 2227565
 Tel/fax: +7 343 2227370
mail@d-test.ru
www.d-test.ru

SOUTH KOREA

PROSEN. CO., LTD

M-1001, Songdo techno park IT
 center, 32, Songdogwahak-ro,
 Yeonsu-gu, Incheon, 21984,
 Republic of Korea
 Tel: +82-32-811-3457
 Fax: +82-32-232-7458
trade@prosen.co.kr
www.prosen.co.kr

SWEDEN, DENMARK

BLConsult

Ryssbalt 294,
 95 291 KALIX, Sweden
 Mobile: +46 70 663 19 25
info@blconsult.se
www.blconsult.se

TURKEY

TEKMA Muhendislik A.S.

Cevizli Mh. M. Kemal Cd.,
 Hukukcular Towers,
 A-Blok, No: 66-A/39
 Kartal – Istanbul
 Tel: +90 216 970 1318
 Tel: +90 850 840 2334
info@tekma.eu
www.tekma.eu

USA, CANADA, MEXICO

International Electronic Machines Corporation

RAILWAY INSTRUMENTS ONLY

850 River Street, Troy,
 New York, USA
 Tel: +1 518 268-1636
 Fax: +1 518 268-1639
marketing@iem.net
www.iem.net

USA, CANADA, MEXICO

**Acuity Products of Schmitt
Industries, Inc.**

2765 NW Nicolai Street
Portland, OR, 97210, USA

Tel: +1 503 227 7908

Fax: +1 503 223 1258

sales@acuitylaser.com

www.acuitylaser.com