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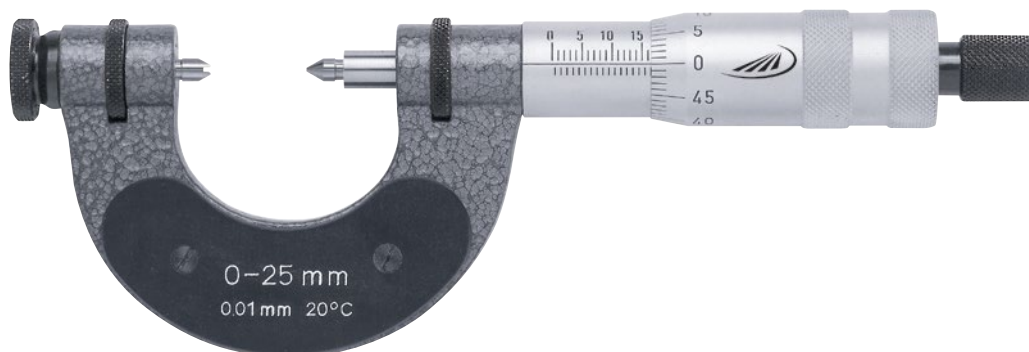


HELIOS • PREISSER

0870 Precision micrometers for thread flank measurement



DIN
863-3



Model

- DIN 863-3
- Reading 0.01 mm
- Reading parts are satin chrome finished
- Locking ring

Functions

- Ratchet stop
- Thermally insulated
- Spheroid ductile iron frame, lacquered

Delivery

- Wooden case
- Thread flank inserts and setting standards must be ordered separately

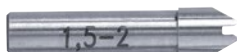
	Measuring range mm	Pitch mm	Thimble dia. mm	Error limit mm	Spindle adjustment mm	Required length of setting standard mm	Order no.
For inserts with shank dimensions, dia. 3.5 x 13.5 mm							
	0 - 25	0.5	20	0.004	25	-	0870 301
	25 - 50	0.5	20	0.004	25	25	0870 302
	50 - 75	0.5	20	0.005	25	50	0870 303
	75 - 100	0.5	20	0.005	25	75	0870 304
	100 - 125	0.5	20	0.006	25	100	0870 305
	125 - 150	0.5	20	0.006	25	125	0870 306
	150 - 200	0.5	20	0.007	50	175	0870 307
	200 - 250	0.5	20	0.008	50	225	0870 309
	250 - 300	0.5	20	0.009	50	275	0870 311

Marked * = excess length/excess weight

Marked * = includes a F.O.C. calibration certificate, traceable to national standards



0870 Thread flank inserts for external measurement



Model

- Made of hardened special steel and finely grinded
- Every insert is inscribed with the pitch details
- In a set (V-anvil + tapered anvil)
- Shank dimensions: 3.5 x 13.5 mm

		Pitch angle in degrees	Pitch mm	Applicable for UNC, UNF 60°	Thread pitch in TPI mm	Order no.
Metric ISO - threads						
		60°	0.35 - 0.50	72 - 48		0870 901
		60°	0.60 - 0.80	44 - 32		0870 903
		60°	0.90 - 1.25	28 - 18		0870 905
		60°	1.5 - 2.0	16 - 11		0870 907
		60°	2.5 - 3.5	10 - 7		0870 909
		60°	4.0 - 6.0	6 - 4		0870 911
Whitworth - threads						
		55°			60 - 48	0870 921
		55°			40 - 32	0870 923
		55°			28 - 22	0870 925
		55°			20 - 16	0870 927
		55°			14 - 11	0870 929
		55°			10 - 7	0870 931
		55°			6 - 4	0870 933
Metric ISO - Trapezoid threads (DIN 103)						
		30°	1.5			0870 941
		30°	2.0			0870 943
		30°	3.0			0870 945
		30°	4.0			0870 947
		30°	5.0 - 6.0			0870 949
		30°	7.0 - 8.0			0870 951
		30°	9.0 - 10.0			0870 953
		30°	12.0 - 14.0			0870 955



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0870 Thread flank setting gauges for external measurement



Model

- Measuring faces made of hardened special steel
- One end is rounded, the lapped bore simplifies the fitting upon the conical insert
- Thermally insulated handle
- Note: With trapezoid threads every pitch requires a separate setting standard

⌘	Length mm	Pitch angle in degrees mm	Available for following pitches	Error limit μm	Order no.
Metric ISO - threads					
	25	60°		3	0870 801
	50	60°		3	0870 802
	75	60°		3	0870 803
	100	60°		4	0870 804
	125	60°		4	0870 805
	175	60°		4	0870 807
	225	60°		4	0870 809
	275	60°		4	0870 811
Whitworth - threads					
	25	55°		3	0870 821
	50	55°		3	0870 822
	75	55°		3	0870 823
	100	55°		4	0870 824
	125	55°		4	0870 825
	175	55°		4	0870 827
	225	55°		4	0870 829
	275	55°		4	0870 831
Metric ISO - Trapezoid threads (DIN 103)*					
	25	30°	2 / 3 / 4 / 5 - 6 / 7 - 8 / 9 - 10	4	0870 841
	50	30°	2 / 3 / 4 / 5 - 6 / 7 - 8 / 9 - 10	4	0870 842
	75	30°	2 / 3 / 4 / 5 - 6 / 7 - 8 / 9 - 10	4	0870 843
	100	30°	3/ 4/ 5-6/ 7-8/ 9-10/ 12-14	5	0870 844
	125	30°	4/ 5-6/ 7-8/ 9-10/ 12-14	5	0870 845
	175	30°	4/ 5-6 /7-8 /9-10/ 1 -14	5	0870 847
	225	30°	5 - 6 / 7 - 8 / 9 - 10 / 12 - 14	5	0870 849
	275	30°	5 - 6 / 7 - 8 / 9 - 10 / 12 - 14	5	0870 851

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