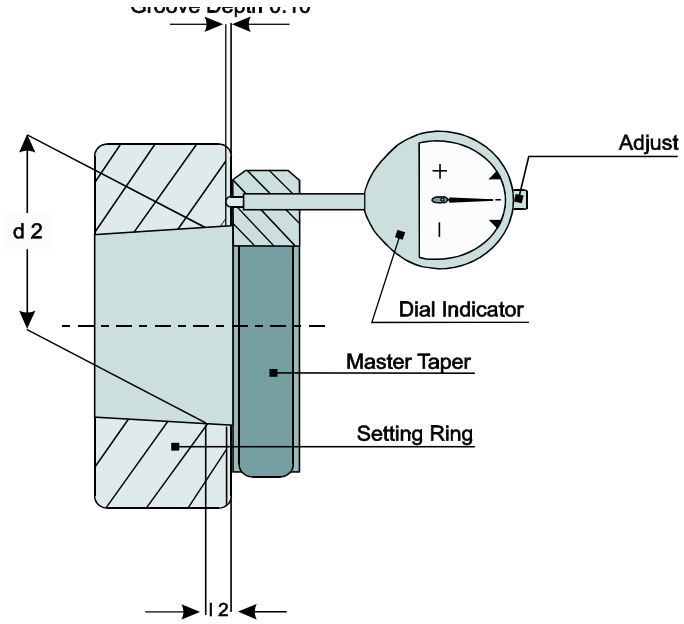

Instructions

1. Thoroughly clean the Master Taper and Setting Ring (we recommend using lint-free wipes).
2. Insert the Master Taper into the Setting Ring so that the dial indicator mounting hole is aligned with the 0.10 groove.
3. Using a hex wrench, install the Dial Indicator such that the indicator reads zero when positioned in the 0.10 groove. The fine adjustment on the Dial Indicator can be used if needed.

With the Dial Indicator reading zero, the measurement distance l2 in relation to the taper diameter d2 is set to zero (per ISO 12164-2).

When finished, lightly oil measuring surfaces to protect in storage.

Measuring Example

Because of the 1:10 taper of the HSK, the dial gauge shows the d2 deviation multiplied by a factor of 10. For example, for HSK-A63, the nominal dimension d2 is 47.998 mm. If the spindle being checked has an actual diameter d2 of 47.997 mm, the Dial Indicator displays –0.01.

Dimensions per ISO 12164-2

HSK-A/C/E	HSK-B/D/F	d2	l2
32	40	23.998	3.2
40	50	29.998	4.0
50	63	37.998	5.0
63	80	47.998	6.3
80	100	59.997	8.0
100	125	74.997	10.0
125	160	94.996	12.5
160		119.995	16.0

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