RF-05A/06A Rear-Fork Gages

Measuring Heads for Small-Diameter Inner-Surface Grinders

Features

Through Spindle Type
Installation through the spindle facilitates a wide range of grinding wheel, auto loader and dressing unit configurations. For ultra small diameters, a grinding wheel that is close to the machining hole diameter can be used, eliminating the necessity of frequent replacements.

Stationary/Oscillating Measurements
Two type of heads are available: A stationary type where the stylus remains in the hole during grinding, and an oscillating type where sliding in and out is synchronized with the grinding wheel.

Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>RF-05A</th>
<th>RF-06A</th>
</tr>
</thead>
<tbody>
<tr>
<td>Measuring range (oscillation type)</td>
<td>Ø1.5 – Ø14 mm</td>
<td>Ø1.5 – Ø14 mm</td>
</tr>
<tr>
<td>Measuring range (stationary type)</td>
<td>Ø10 – Ø34 mm</td>
<td>Ø10 – Ø34 mm</td>
</tr>
<tr>
<td>Measuring force</td>
<td>0.5 ±0.1 N</td>
<td>0.5 ±0.1 N</td>
</tr>
<tr>
<td>Oscillation speed</td>
<td>Up to 800 cpm</td>
<td>Up to 800 cpm</td>
</tr>
<tr>
<td>Measuring time</td>
<td>20 ms or more</td>
<td>20 ms or more</td>
</tr>
<tr>
<td>Repeatability</td>
<td>0.5 µm</td>
<td>0.5 µm</td>
</tr>
</tbody>
</table>

Configurations

Stationary Type
- DELCOM 120A
- PULCOM V4
- PULCOM V6
- PULCOM V7
- PULCOM V10A

Oscillating Type
- PULCOM V4, V7, V10A with memory function

RF-05A Miniature Type
This easy-to-use type features an outer diameter of 24.8 mm.

RF-06A Pencil Type
Designed for especially compact machines, this type has an outer diameter of 15.9 mm.

Superior Response
These rear-fork gages feature a maximum response of 800 cpm for ultra-small diameter oscillating grinding.
### Applications

#### Automatic Inner Diameter Sizing

Sizing measurement can be performed during machining by alternately inserting the gage and the grinding wheel. Non-continuous surfaces can also be measured.

**RF-05A • RF-06A**

#### Outer Appearance/Dimension Diagram

**Product Code**
- 0960018 Inner diameter measuring head (RF-05A/R-P3)
- 0960019 Inner diameter measuring head (RF-05A/R-N3)
- 0960022 Inner diameter measuring head (RF-05A/H-P3)
- 0960023 Inner diameter measuring head (RF-05A/H-N3)
- 0960026 Inner diameter measuring head (RF-05A/BH-P3)
- 0960027 Inner diameter measuring head (RF-05A/BH-N3)
- 0960007 Inner diameter measuring head (RF-06A-P3)
- 0960064 3m relay cable (A062113)