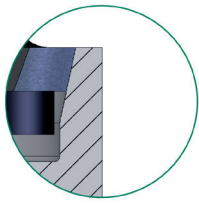


Checking assembly studs with cone gauges

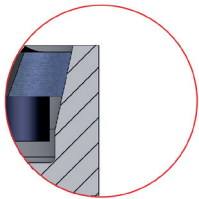
Information

The hardened STAUFF assembly studs for cutting ring assemblies are wear-resistant and allow uniform assembly results because they have narrower tolerances than normal fitting studs.

To achieve constantly uniform assembly processes, the inner cone of the assembly stud has to be checked for dimensional accuracy on a regular basis. STAUFF offers the appropriate cone gauges for this.



good



reject

How to use the cone gauges

- The check should be carried out after every 50th assembly process at the latest (see DIN 3859-2)
- Before checking the dimensional accuracy, clean the interior of the assembly stud thoroughly with a cloth
- Use a visual check to identify any deep grooves, edges or fractured areas in the cone area. If this is the case, replace the assembly stud
- Carry out the check by aligning the gauge axially and inserting it into the cone of the assembly stud (axially aligned cone gauge)

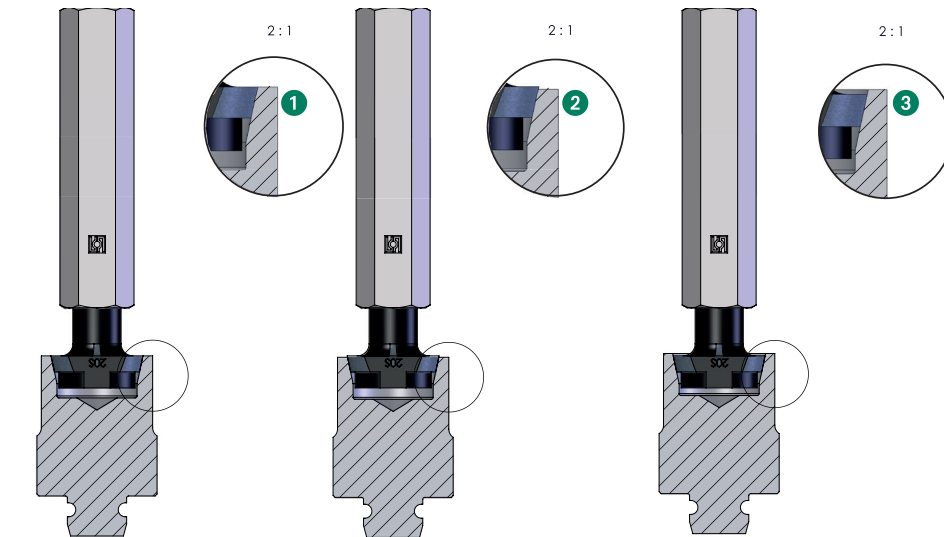
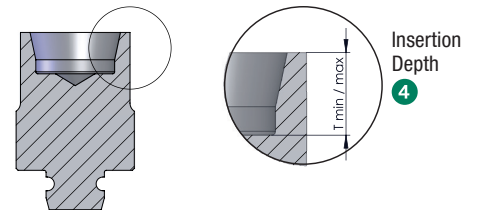
Checking the results

- 1 Cone Gauge slightly from the hole (good)
 - ▶ assembly stud can still be used!
 - ▶ Cone gauge has play in the cone area (ovality or flare) assembly stud has to be replaced!
- 2 Gauge cone is flush with the upper edge of the hole (good)
 - ▶ assembly stud can still be used!
 - ▶ Cone gauge has play in the cone area (ovality or flare) assembly stud has to be replaced!
- 3 Gauge cone starts to disappear into the hole (reject)
 - ▶ assembly stud has to be replaced!
- 4 Measure the depth as an additional check (see table below). Deviations can result in leaks.

Caution

Checking the assembly stud for dimensional accuracy does not replace the visual check of the bulging at the cutting ring edge (see assembly instructions).

It is only intended for checking the assembly studs with regard to the change in the bulging quality during the assembly process.



Insertion Depth		Tmax*		Size
Tmin* (mm)	(in)	(mm)	(in)	
6,8	.27	6,95	.27	FI-MFK/FK-06L
6,8	.27	6,95	.27	FI-MFK/FK-08L
6,8	.27	6,95	.27	FI-MFK/FK-10L
6,8	.27	6,95	.27	FI-MFK/FK-12L
6,8	.27	6,95	.27	FI-MFK/FK-15L
7,3	.29	7,45	.29	FI-MFK/FK-18L
7,3	.29	7,45	.29	FI-MFK/FK-22L
7,3	.29	7,45	.29	FI-MFK/FK-28L
10,3	.41	10,45	.41	FI-MFK/FK-35L
10,8	.43	10,95	.43	FI-MFK/FK-42L
6,8	.27	6,95	.27	FI-MFK/FK-06S
6,8	.27	6,95	.27	FI-MFK/FK-08S
7,3	.29	7,45	.29	FI-MFK/FK-10S
7,3	.29	7,45	.29	FI-MFK/FK-12S
7,8	.31	7,95	.31	FI-MFK/FK-14S
8,3	.33	8,45	.33	FI-MFK/FK-16S
10,3	.41	10,45	.41	FI-MFK/FK-20S
11,8	.46	11,95	.47	FI-MFK/FK-25S
13,3	.52	13,45	.53	FI-MFK/FK-30S
15,8	.62	15,95	.63	FI-MFK/FK-38S

* Attention: Deviations can result in leaks.