

DDP

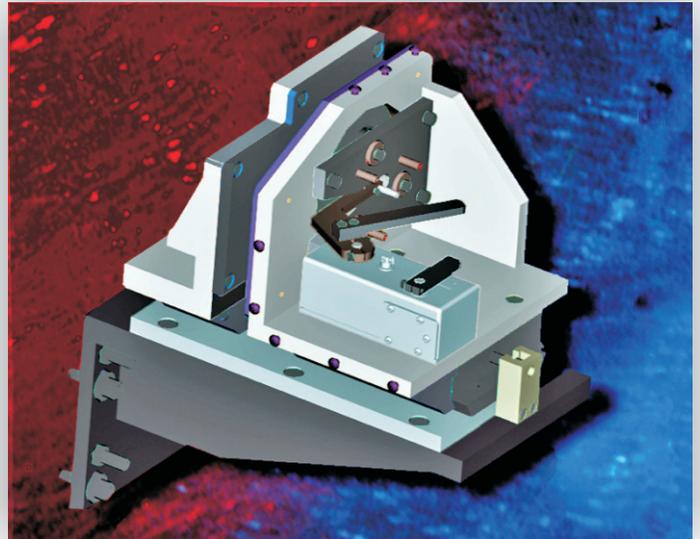


DDP Disc Grinder Gaging Fixture

Simple and robust design measures parts dynamically in a variety of applications

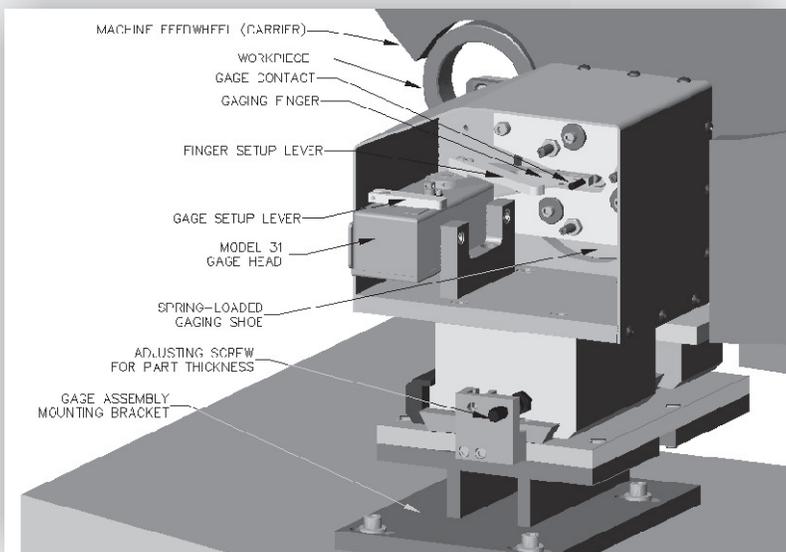
The DDP concept is simple: a circular, spring-loaded gaging shoe presses the ground part against a precise reference surface. The gage contacts the back of the shoe, sending the measured thickness of the part to the D500 Gage Controller.

Workpieces may be carried or pushed through the fixture in several different ways, including rotary carrier, swing arm, or custom mechanism. Our specialized "Micropeak" software analyzes the dynamic gage signal (which is rising and falling with the gage shoe), then calculates precise part size. The D500 monitors size relative to target, then compensates the machine based on a scheme "tuned" to your application.



DDP Specifications:

Thickness range:	2.3mm to 38mm .09" to 1.5"
Thrufeed rate:	2.5 to 7.5 meters/minute 100 to 300 inches/minute
Part diameter, height, length:	25mm to 125mm 1" to 5" for both



DDP "straddling" a rotary carrier, measuring parts "on the fly".

DDP fixtures are designed for the gritty, swarf-filled world of grinding. Fixture components that touch the workpiece are highly hardened or titanium hard-coated. And the measuring head is one of CGI's exclusive quick-setup slip-clutch gages, not a fragile pencil probe. Our gage heads are not only precise (repeatability to .0005mm (.000020")) but are specifically designed to - and do in fact - last for years in the harsh grinding environment.

There are already application drawings for multiple machines and part types, and the DDP can typically be designed into new situations at very reasonable cost.

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Control Gaging Incorporated

847 Avis Dr. Ann Arbor, Michigan 48108 Phone: +1 734.668.6750 Fax: +1 734.994.1335
www.controlgaging.com Email: sales@controlgaging.com



D500 Gage Controller

The D500 is an advanced, highly-configurable gage controller with the power for demanding applications. Advanced DSP technology yields fast, clean, and precise gaging signals. Field-proven software can collect accurate size readings even on fast-moving parts, then calculate trends and initiate compensations.

Control Gaging has over 35 years of experience in controlling grinders. In that time we have developed advanced trend-analysis and compensation techniques that can help optimize the performance of your process.

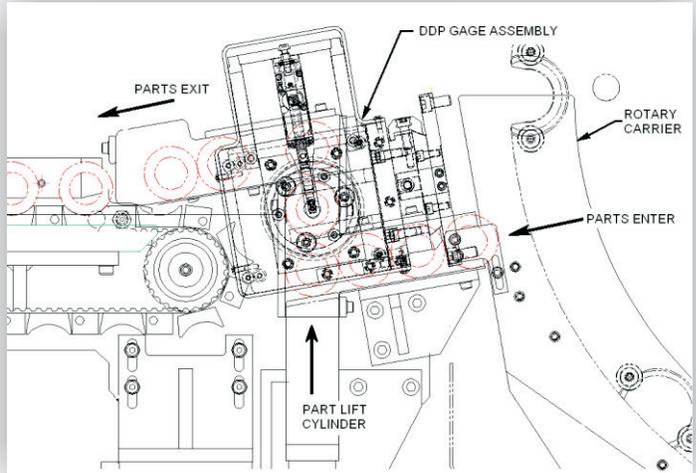
DDP - Applied to two different machine types at same plant

Working with the machine OEM and end-user, Control Gaging was able to integrate the DDP into two very different machine applications. This minimized training and provided commonality of components and software.

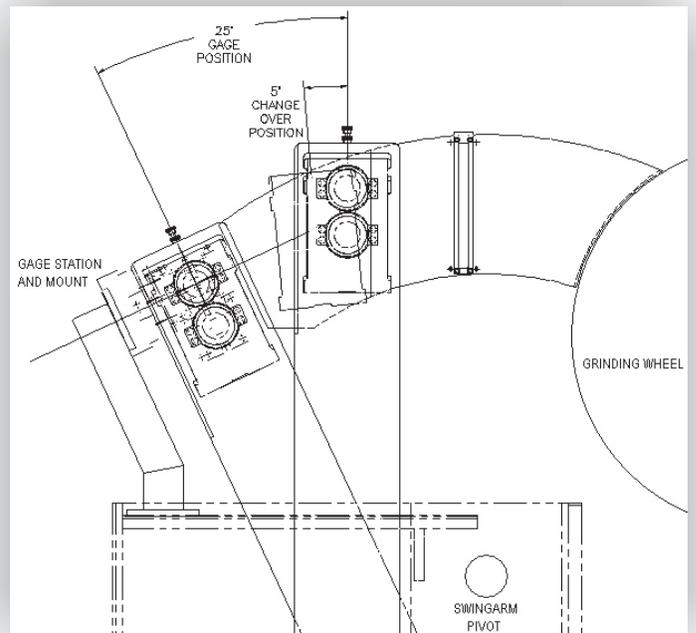
One application (shown at right, top) had a rotary carrier, to which a parts-handling mechanism was added. The parts exited the carrier into a chute, then were pushed up through the DDP for a gage reading prior to leaving the machine.

The second machine, at right, had a swing arm that brought the part back through the transfer position to pass into and out of the gage before unloading.

The DDP Gage Fixture can be adapted to multiple work-holding methods.



DDP on rotary disc grinder - the machine manufacturer built a part-handling mechanism to push parts up through the fixture



DDP location on swing-arm grinder - the range of motion of the swing arm was extended to add the gaging position

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