

FREQUENTLY ASKED QUESTIONS (FAQ)

1 Can FMS measure the pitch diameter of all thread types?

Yes. If the thread is "unusual" or non-standard a drawing may however be necessary to make the thread inserts. A FMS calibration plate (or other threaded component with a known pitch diameter) is necessary for internal pitch diameter measurement.

2 What is the smallest internal thread and finest pitch FMS can be used for?

The smallest internal thread is 6mm / 0.25" and the finest pitch 0.5mm / 48 TPI.

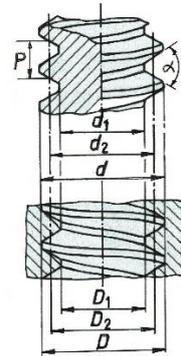
3 Can FMS measure other thread diameters than pitch diameter?

Diameter d can be measured using a caliper or micrometer.

Diameter D_1 can be measured using a caliper. The tolerance on D_1 is usually much larger than D_2 .

Diameters d_1 and D can be measured with specially made FMS thread inserts.

Thread pitch gauges are usually used to check thread pitch.



4 How accurately can FMS measure?

The pitch diameter tolerance on a standard external M6 thread is 0.11mm and internal 0.15mm.

The pitch diameter tolerance on a standard external $\frac{1}{4}$ 20 UNC thread is 0.0037" and internal 0.0049".

Neither of those tolerances should be a problem when a FMS pressure device is used to ensure a constant measurement force with a digital caliper.

When setting up a machine it is common sense to get as close to the middle of the pitch diameter as possible and less inspection need be made.

5 What is the largest diameter thread FMS can measure?

The answer to this is "How long is your digital caliper?"

6 What help can I expect from FMS re threads and tolerances?

As a customer all reasonably thread relevant questions will be answered if possible and at no cost.

Advice will also be given if in doubt as to what to order. If we know thread type/types, pitch/pitches and diameter/diameters then an offer can usually be made within 24 hours.

7 Can FMS inserts measure other than threads?

Yes. External and internal recesses and grooves. Also external and internal recess and groove lengths and depths. There are both standard (in stock) and special inserts can be tailor made.

8 What is the delivery time on non standard items not in stock?

Normal manufacturing time is max 3 work weeks from the date of order.