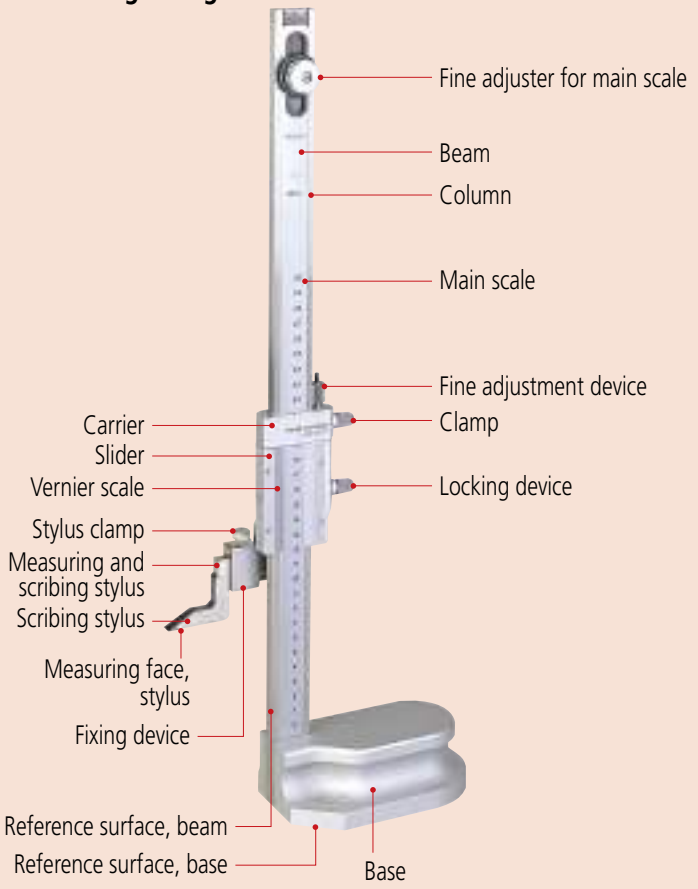
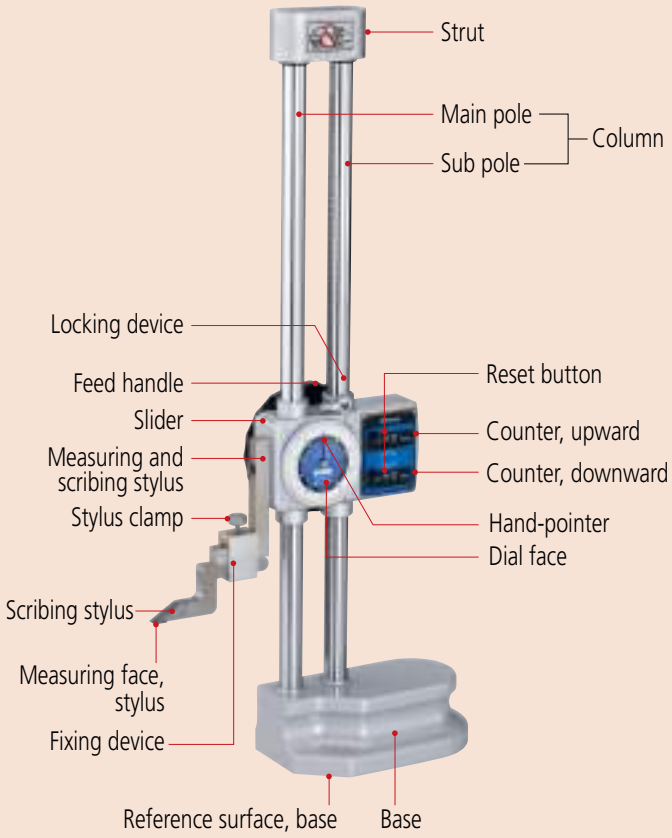
Height Gages

Nomenclature

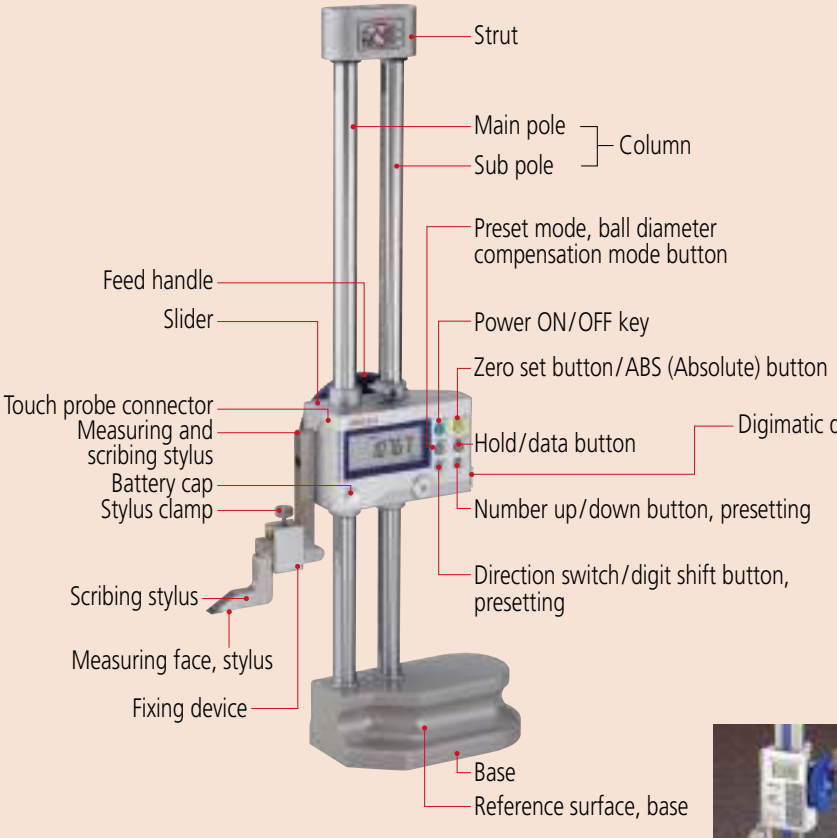
Vernier Height Gage

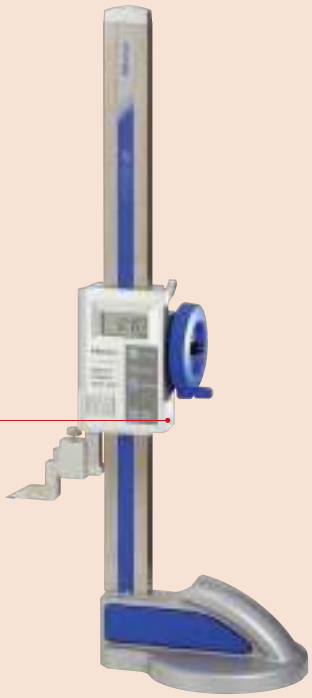


Mechanical Digit Height Gage



Digimatic Height Gages






Slider handwheel

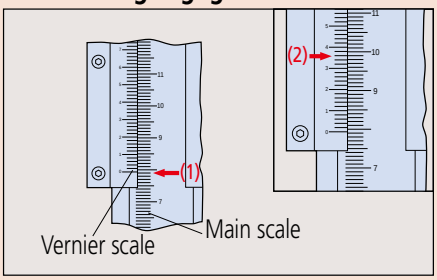

Slider clamping lever


Ergonomic base

D

How to read

Vernier Height gage



Graduation	0.02 mm
(1) Main scale	79 mm
(2) Vernier	0.36 mm
Reading	79.36 mm

General notes on use of Height Gages

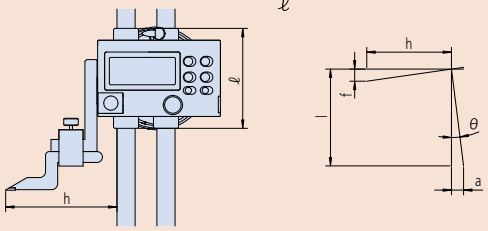
1. Potential causes of error

Like the caliper, the error factors involved include parallax effects, error caused by excessive measuring force due to the fact that a height gage does not conform to Abbe's Principle, and differential thermal expansion due to a temperature difference between the height gage and workpiece.
There are also other error factors caused by the structure of the height gage. In particular, the error factors related to a warped reference edge and scriber installation described below should be studied before use.

2. Reference edge (column) warping and scriber installation

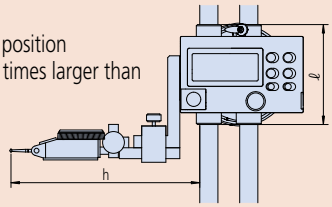
Like the caliper, and as shown in the following figure, measurement errors result when using the height gage if the reference column, which guides the slider, becomes warped. This error can be represented by the same calculation formula for errors caused by nonconformance to Abbe's Principle.

$$f = h\,\theta = h\frac{a}{\ell}$$



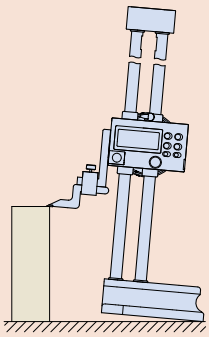
Installing the scriber (or a lever-type dial indicator) requires careful consideration because it affects the size of any error due to a warped reference column by increasing dimension h in the above formula. In other words, if an optional long scriber or lever-type dial indicator is used, the measurement error becomes larger.

Example: Effect of measuring point position
When h is 150 mm, the error is 1.5 times larger than when h is 100 mm.



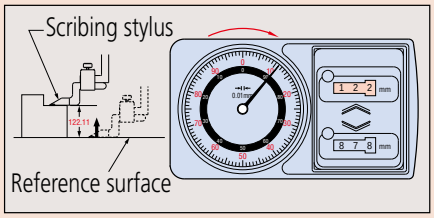
3. Lifting of the base from the reference surface

When setting the scriber height from a gauge block stack, or from a workpiece feature, the base may lift from the surface plate if excessive downwards force is used on the slider, and this results in measurement error. For accurate setting, move the slider slowly downwards while moving the scriber tip to and fro over the gauge block surface (or feature). The correct setting is when the scriber is just felt to lightly touch as it moves over the edge of the surface.
It is also necessary to make sure that the surface plate and height gage base reference surface are free of dust or burrs before use.



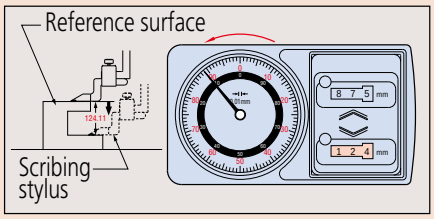
Mechanical Digit Height gage

Measuring upwards from a reference surface



Counter	122	mm
Dial	0.11	mm
Reading	122.11	mm

Measuring downwards from a reference surface



Counter	124	mm
Dial	0.11	mm
Reading	124.11	mm

4. Error due to inclination of the main scale (column)

According to JIS standards, the perpendicularity of the column reference edge to the base reference surface should be better than:

$$\left(0.01+\frac{L}{1000}\right)\text{mm}$$ L indicates the measuring length (unit: mm)

This is not a very onerous specification. For example, the perpendicularity limit allowable is 0.61 mm when L is 600 mm. This is because this error factor has a small influence and does not change the inclination of the slider, unlike a warped column.

5. Relationship between accuracy and temperature

Height gages are made of several materials. Note that some combinations of workpiece material, room temperature, and workpiece temperature may affect measuring accuracy if this effect is not allowed for by performing a correction calculation.

6. The tip of a height gage scriber is very sharp and must be handled carefully if personal injury is to be avoided.

7. Do not damage a digital height gage scale by engraving an identification number or other information on it with an electric marker pen.

8. Carefully handle a height gage so as not to drop it or bump it against anything.

Notes on using the height gage

1. Keep the column, which guides the slider, clean. If dust or dirt accumulates on it, sliding becomes difficult, leading to errors in setting and measuring.
2. When scribing, securely lock the slider in position using the clamping arrangements provided. It is advisable to confirm the setting after clamping because the act of clamping on some height gages can alter the setting slightly. If this is so, allowance must be made when setting to allow for this effect.
3. Parallelism between the scriber measuring face and the base reference surface should be 0.01 mm or better.
Remove any dust or burrs on the mounting surface when installing the scriber or lever-type dial indicator before measurement. Keep the scriber and other parts securely fixed in place during measurement.
4. If the main scale of the height gage can be moved, move it as required to set the zero point, and securely tighten the fixing nuts.
5. Errors due to parallax error are not negligible. When reading a value, always look straight at the graduations.
6. Handling after use: Completely wipe away any water and oil. Lightly apply a thin coating of anti-corrosion oil and let dry before storage.
7. Notes on storage:

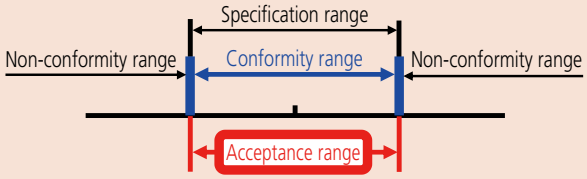
- Avoid direct sunlight, high temperatures, low temperatures, and high humidity during storage.
- If a digital height gage will not be used for more than three months, remove the battery before storage.
- If a protective cover is provided, use the cover during storage to prevent dust from adhering to the column.

Mitutoyo

Height Gage Performance Evaluation Method

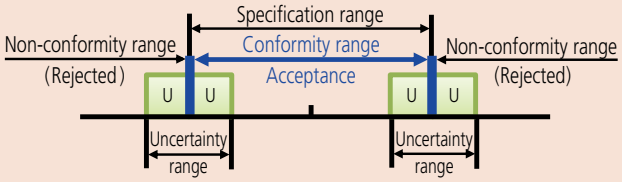
JIS B 7517 was revised and issued in 2018 as the Japanese Industrial Standards of the height gage, and the "Instrumental error" indicating the indication error of the height gage has been changed to "Maximum permissible error (MPE) of indication".
The "Instrumental error" of the conventional JIS adopts acceptance criteria that the specification range (precision specification) equals acceptance range, and the OK/NG judgment does not include measurement uncertainty (**Fig. 1**).
The "Maximum permissible error (MPE) of indication" of the new JIS employs the basic concept of the OK/NG judgment taking into account the uncertainty adopted in the ISO standard (ISO 14253-1).
The verification of conformity and nonconformity to the specifications is clearly stipulated to use the internationally recognized acceptance criteria (simple acceptance) when the specification range equals the acceptance range, and it is accepted that the specification range equals the acceptance range if a given condition considering uncertainty is met.
The above said internationally recognized acceptance criterion is ISO/TR 14253-6: 2012 (**Fig. 2**).
The following describes the standard inspection method including the revised content of JIS 2018.

Fig. 1 **Conventional JIS** Instrumental error
JIS B 7517-1993



Uncertainty is not included in judgment
Specification range=Acceptance range

Fig. 2 **New JIS** Maximum permissible error (MPE)
JIS B 7517: 2018 (ISO/TR 14253-6: 2012)



When a condition considering uncertainty is satisfied
Specification range=Conformity range

Maximum permissible error of height measurement E_{MPE} [JIS B 7517: 2018]

The height measurement error in a height gage is the indication error when the reference edge (column) is perpendicular to the base reference surface and the direction of contact is downward. **Table 1** shows the maximum permissible height measurement error E_{MPE}.
E_{MPE} for any desired height is obtained by measuring a gauge block, or equivalent, with a height gage on a precision surface plate (**Fig. 3**) and then subtracting the gauge block size from the measured size.

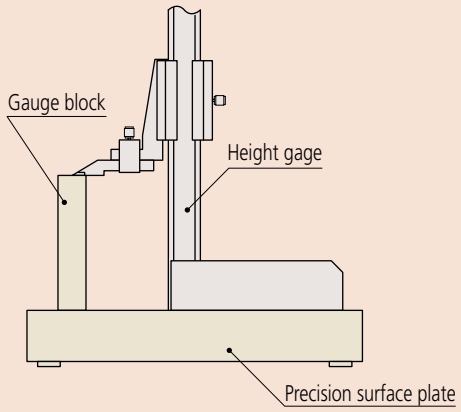
Table 1: Maximum permissible height measurement error E_{MPE} of a conventional height gage

Unit: mm

Measurement height	Scale interval, graduation or resolution	
	0.05	0.02 or 0.01
50 or less	±0.05	±0.02
Over 50, 100 or less	±0.06	±0.03
Over 100, 200 or less	±0.07	
Over 200, 300 or less	±0.08	±0.04
Over 300, 400 or less	±0.09	
Over 400, 500 or less	±0.10	±0.05
Over 500, 600 or less	±0.11	
Over 600, 700 or less	±0.12	±0.06
Over 700, 800 or less	±0.13	
Over 800, 900 or less	±0.14	±0.07
Over 900, 1000 or less	±0.15	

Note: E_{MPE} includes the measurement error arising from straightness, flatness of the measuring surface and parallelism with the reference surface.

Fig. 3: Determination of height measurement error



The "Instrumental error" indicating the indication error of JIS has been changed to "Maximum permissible error (MPE) of indication" for the following models:

- **SERIES 192 Digimatic Height Gage** described on page D-43 (All models)
- **SERIES 570 ABSOLUTE Digimatic Height Gage** described on page D-45 (All models)
- **SERIES 570 Digimatic Height Gage** described on page D-47 (All models)
- **SERIES 514, 506 Standard Height Gage with Adjustable Main Scale** described on page D-49 (All models)
- **SERIES 192 With digital counter** described on page D-50 (All models)