

Indicating Thread Snap Gage MaraMeter 852

Willrich Precision
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- Rugged, forged steel frame with heat insulators
- Measuring spindle is mounted in long guide way with lever controlled retraction
- Measuring spindle and anvil spindle are both made of hardened stainless steel, with mounting bore for insertion of interchangeable anvils
- Adjustable center stop for automatic alignment
- Anvil spindle can easily be fine adjusted
- Constant measuring force as a result of built-in spring, thus eliminating user influence
- Maximum wear resistance due to non-contact positioning in conjunction with carbide tipped measuring faces
- **Scope of delivery:** Flat contact point 903 (steel), Wooden case (package excludes indicator)



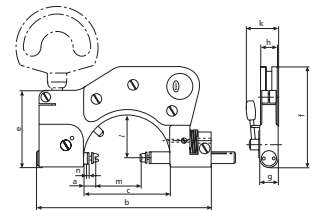
Application:

- For measuring pitch, root and outside diameters of all kinds of external threads as well as serrations
- Universally applicable and extremely versatile. Each instrument spans a broad measuring range

Technical Data

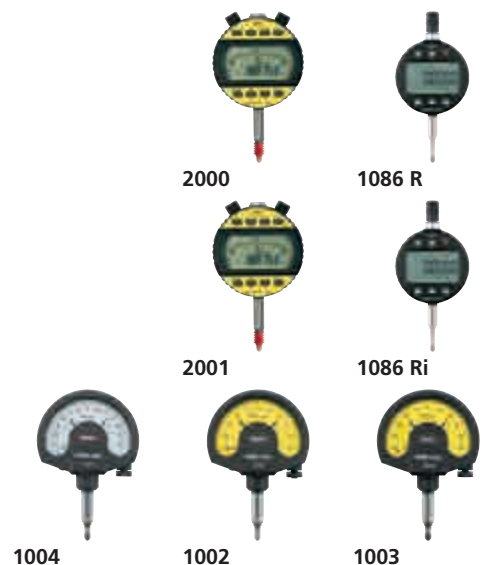
Order no.		4510000	4510001	4510002	4510003
Product type		852			
Measuring range	mm	0 – 45	45 – 85	85 – 140	140 – 190
Measuring range	inch	0 – 1.77"	1.77 – 3.34"	3.34 – 5.51"	5.51 – 7.48"
Distance of movable anvil	mm	2	2.5		
Repeatability f_w	μm	1			
Measuring force	N	7.5		9	
Frame size		2	3	4	5

Order no.	k	l	a	b	c	e	f	g	h
	mm	mm	mm	mm	mm	mm	mm	mm	mm
4510000	25	34	13	140	68	60	77	13	13
4510001	28	59	8	193	11	60	103	14	13
4510002	31	87	10	258	162	70	141	16	12
4510003	31	112	6	316	212	75	171	16	12

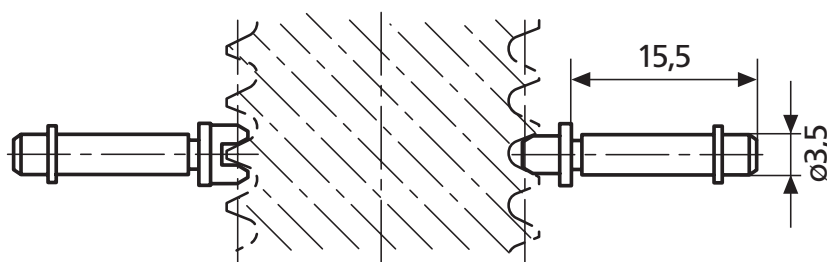


Accessories

Order no.	Product name	Product type
4333000	Millimess 5 μm , $\pm 130 \mu\text{m}$	1004
4334000	Millimess 1 μm , $\pm 50 \mu\text{m}$	1003
4334001	Millimess 2 μm , $\pm 130 \mu\text{m}$	1003 XL
4335000	Millimess 0.5 μm , $\pm 25 \mu\text{m}$	1002
4337620	Digital Indicator, 0.0005 mm, 12.5 mm	1086 R
4337624	Digital Indicator, 0.0005 mm, 12.5 mm	1086 Ri
4346000	Inductive dial comparator, $\pm 0.9 \mu\text{m}$	2000
4346100	Inductive dial comparator, $\pm 0.9 \mu\text{m}$	2001
4450051	Holder, Frame size 2	840 Fk/2
4450020	Base, for stationary application	840 Ff
4173210	Anvil flat, hardened steel	40 Za
4511190	Anvil flat, carbide tipped	40 Za
4450052	Holder, Frame size 3	840 Fk/3
4450053	Holder, Frame size 4 + 5	840 Fk/4



MaraMeter Thread anvils



- For pitch diameters
- Wear-resistant special steel, hardened
- With cylindrical mounting shank and retainer ring for rotatable mounting in the bore of dial comparator snap gage
- Pair comprises V-anvil and cone
- **With a pitch of 0.2 – 0.45 mm, the V-anvil bridges 3 turns;** It should therefore be set with 715 E thread adjustment pins, otherwise with 43 Z setting standards.

Accessories

Thread pitch in mm	Blade Order no.	V-anvil Order no.
Pitch diameter, external thread		
Metric 60°		
0,2	4173707	4173007
0,25	4173708	4173008
0,3	4173709	4173009
0,35	4173710	4173010
0,4	4173711	4173011
0,45	4173712	4173012
0,5 – 0,7	4173700	4173000
0,7 – 1	4173701	4173001
1,25 – 2	4173702	4173002
	4511104	4511105
2 – 3,5	4173703	4173003
	4511107	4511108
3,5 – 5	4173704	4173004
	4511139	4511140
5 – 7	4173705	4173005
	4511141	4511142
7 – 9	4173706	4173006

Thread pitch in TPI	Blade Order no.	V-anvil Order no.
UST 60°		
10 – 7	4173820	4173120
14 – 10	4173819	4173119
18 – 14	4173818	4173118
24 – 18	4173817	4173117
32 – 24	4173816	4173116
4,5 – 3	4173822	4173122
40 – 32	4173815	4173115
48 – 40	4173814	4173114
7 – 4,5	4173821	4173121
Whitworth 55°		
10 – 7	4173748	4173048
14 – 10	4173747	4173047
18 – 14	4173746	4173046
24 – 18	4173745	4173045
3 – 2,5	4179410	4179408
32 – 24	4173744	4173044
4,5 – 3	4173750	4173050
40 – 32	4173743	4173043
7 – 4,5	4173749	4173049

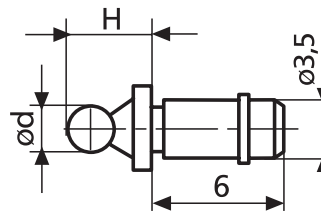
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Ball contact Marameter

- For measuring gears and for special applications
- Carbide ball
- With cylindrical mounting shank and retainer ring
- For mounting into mounting bores of thread micrometers 40 Z and 852

Order no.	d	h
	mm	mm
4179150	0.5	5
4179151	0.551	5.1
4179152	0.62	5.1
4179153	0.623	5.1
4179154	0.63	5.1
4179155	0.722	5.2
4179156	0.862	5.4
4179157	0.895	5.4
4179158	0.965	5.5
4170550	1	5.5
4179159	1.1	5.6
4179160	1.118	5.6
4170551	1.25	5.8
4179161	1.125	5.6
4179162	1.35	5.9
4179163	1.372	5.9
4179164	1.385	5.9
4170552	1.5	6
4179165	1.524	6
4179166	1.54	6
4179167	1.6	6.1
4179168	1.65	6.2
4179169	1.7	6.2
4170553	1.75	6.3
4179170	1.782	6.3
4179171	1.8	6.3
4179172	1.829	6.3
4179173	1.9	6.4
4170554	2	6.5
4170568	2.032	6.5
4170569	2.2	6.7
4170564	2.25	6.8
4179174	2.284	6.8
4179175	2.386	6.9
4179176	2.438	6.9
4170556	2.5	7
4179177	2.667	7.2
4179178	2.704	7.2
4179179	2.713	7.2
4179180	2.721	7.2
4179181	2.743	7.2
4170565	2.75	7.3
4170557	3	7.5
4179182	3.048	7.5
4170570	3.2	7.7
4170566	3.25	7.8
4179183	3.4	7.9
4170558	3.5	8
4179184	3.658	8.2
4170571	3.7	8.2
4170559	4	8.5
4170560	4.5	9
4179185	4.835	9.3
4170561	5	9.5
4179186	5.25	9.8
4179187	5.486	10

Order no.	d	h
	mm	mm
4170562	5.5	10
4170563	6	10.5
4179188	6.096	10.6
4179189	6.35	10.9
4170567	6.5	11
4170572	7	11.5
4170573	8	12.5
4170574	9	13.5
4170575	10	14.5



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Roller blades, carbide MaraMeter

- For measuring gears for special applications
- Carbide measuring roller
- To be mounted in the mounting bores of the 40 Z and 852

Order no.	B	b	d	h
	mm	mm	mm	mm
4510200	5.00	5	1	5.5
4510201	5.00	5	1.25	5.8
4510202	5.00	5	1.5	6
4510203	5.00	5	1.75	6.3
4510204	5.50	5	2	6.5
4510206	5.50	5.5	2.5	7
4510207	5.50	5.5	3	7.5
4510208	5.50	5.5	3.5	8
4510209	5.50	5.5	4	8.5
4510210	5.50	5.5	4.5	9
4510211	6.00	6	5	9.5
4510212	6.00	6	5.5	10
4510213	6.00	6	6	10.5

