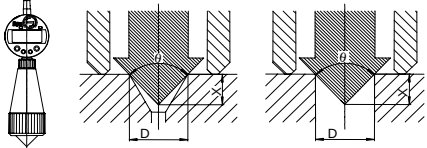
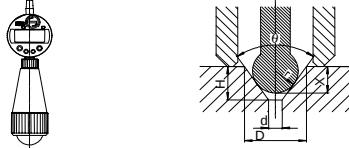
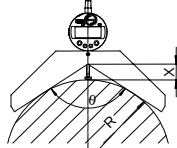
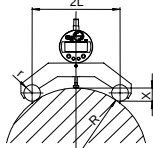
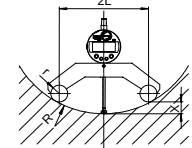
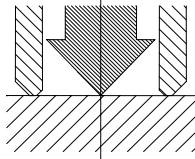
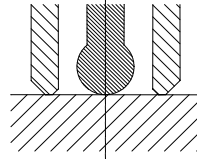
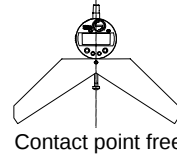
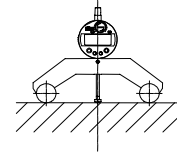


ABSOLUTE ID-C112R Calculation type Digimatic Indicator

User's Manual
No. 99MAH013B
SERIES No. 543

The following shows typical measurement examples of application (special gage) with fixtures and their relevant calculation examples of each arithmetic coefficient. Make the most of these examples.

	Chamfer/Feeler/Hole diameter		Chamfer/Countersink depth		Roll diameter measurement		
Application measurement example							
Contact point/guide	Cone		Ball		Angle plate	Roll or Ball	
Calculation formula	$D = Ax$		$D = Ax + B$	$H = Ax + B$	$R = Ax$	$R = Ax + B + Cx^{-1}$	
Arithmetic coefficient A	$-2 \tan \frac{\theta}{2}$		$-2 \tan \frac{\theta}{2}$	-1	$-\frac{\sin \frac{\theta}{2}}{1 - \sin \frac{\theta}{2}}$	$\frac{1}{2}$	$-\frac{1}{2}$
Arithmetic coefficient B	0		$2r \left[\frac{1}{\cos \frac{\theta}{2}} - \tan \frac{\theta}{2} \right]$	$r \left[\frac{1}{\sin \frac{\theta}{2}} - 1 \right] - \frac{d}{2 \tan \frac{\theta}{2}}$	0	$-r$	r
Arithmetic coefficient C	0		0	0	0	$\frac{L^2}{2}$	$-\frac{L^2}{2}$
Origin setting position (The position when $x=0$)							
Indicated value when origin setting (Indicated value when $x=0$)	0		$2r \left[\frac{1}{\cos \frac{\theta}{2}} - \tan \frac{\theta}{2} \right]$ Value for coefficient B	$r \left[\frac{1}{\sin \frac{\theta}{2}} - 1 \right] - \frac{d}{2 \tan \frac{\theta}{2}}$ Value for coefficient B	0	Error message (Overflow)	
Preset position (Master alignment position)	