

Digimatic Indicators

Bulletin No. 1824



Digital indicators with Absolute encoders

Mitutoyo

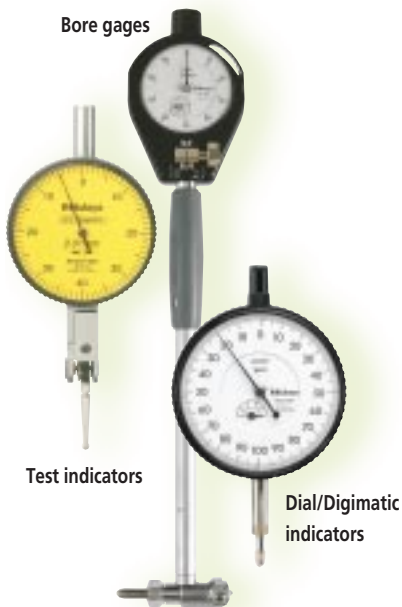
Mitutoyo Digimatic Indicators

The highest in accuracy, reliability and durability

More than 11 million indicators have been produced since production began in 1959. Advanced indicator production lines have been integrated with fully automated assembly and inspection processes, yielding indicators used in every part of the world. The plant also produces and ships test indicators, bore gages, etc. Moreover, we are increasing the production of Digimatic indicators to meet the ever increasing demand for digital gaging in manufacturing.



Nakatsugawa Plant
Site area: 46,800m²
Date of establishment: July, 1997



ABSOLUTE

Mitutoyo's leading-edge ABSOLUTE encoder never forgets its absolute origin throughout the entire battery life, unless it is otherwise preset for a different setup. It immediately indicates the absolute position of the spindle at power-on, ready to begin measuring. This technology also eliminates spindle over-speed error, a phenomenon that usually happens with incremental type indicators.

ABSOLUTE IDS



543-692

.5"/12.7mm range model

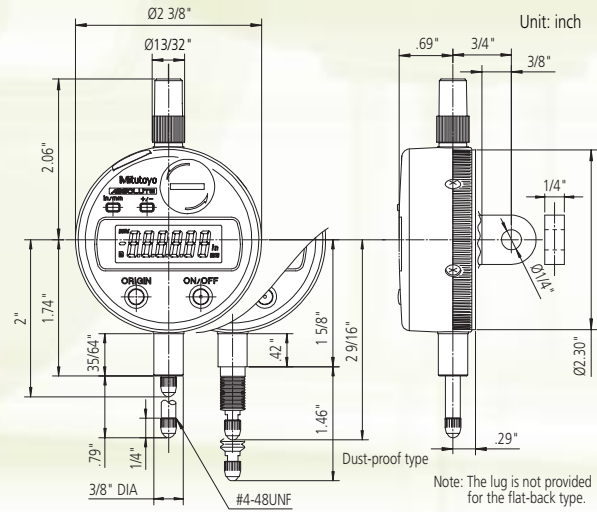
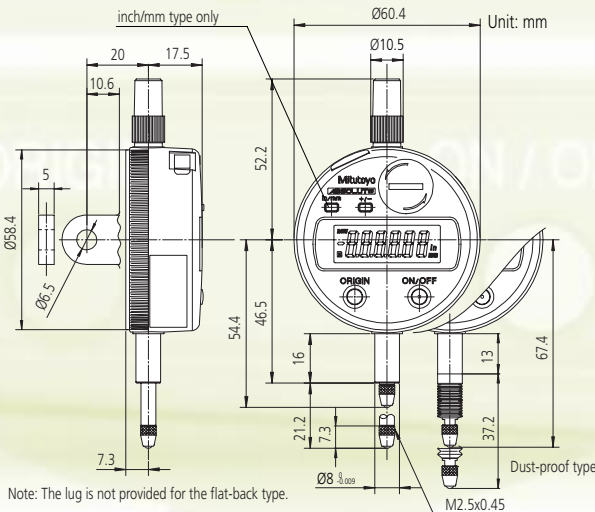
Simple key functions in an economical package

Technical Data

- Display: LCD
- Functions: Origin setting, power on/off, counting direction switching, inch/mm conversion (inch/mm type), SPC data output
- Battery: SR44 (1pc.) (938882)
- Battery life: 20,000 hours in continuous use
- Stem diameter: 3/8" (ANSI/AGD type) or 8mm (ISO/JIS type)
- Contact point: Carbide ball (ISO/JIS type) or steel ball (ANSI/AGD type)
- Measuring force: 2.0N or less
2.5N or less (Dust-proof type with rubber boot)
- Dust-water protection level: Conforming to IP42
Conforming to IP53 (Dust-proof type with rubber boot)
- Alarm: Low battery voltage, scale contaminations, ABS data Composition error
- Operating temperature: 0°F to 104°F (0°C to 40°C)
- Mass: .33 lbs./150g (.26 lbs./120g)*

*0.01mm (.005"/0.01mm) resolution type

Dimensions



Specifications (ISO/JIS type)

Order No.	Accuracy	Resolution	Range
Back w/lug	Flat-back		
543-690	543-690B	0.003mm	12.7mm
543-694*	543-694B*	0.003mm	12.7mm
543-681	543-681B	0.02mm	12.7mm
513-691	513-691B	.00012"	.00005"/0.001mm
543-695*	543-695B*	.00012"	
543-682	543-682B	.0008"	.0005"/0.01mm

* Dust-proof type with rubber boot

Specifications (ANSI/AGD type)

Order No.	Accuracy	Resolution	Range
Back w/lug	Flat-back		
543-692	543-692B	.00012"	.00005"/0.001mm
543-696*	543-696B*	.00012"	
543-693	543-693B	.00012"	.0001"/0.001mm
543-683	543-683B	.0008"	.0005"/0.01mm

* Dust-proof type with rubber boot

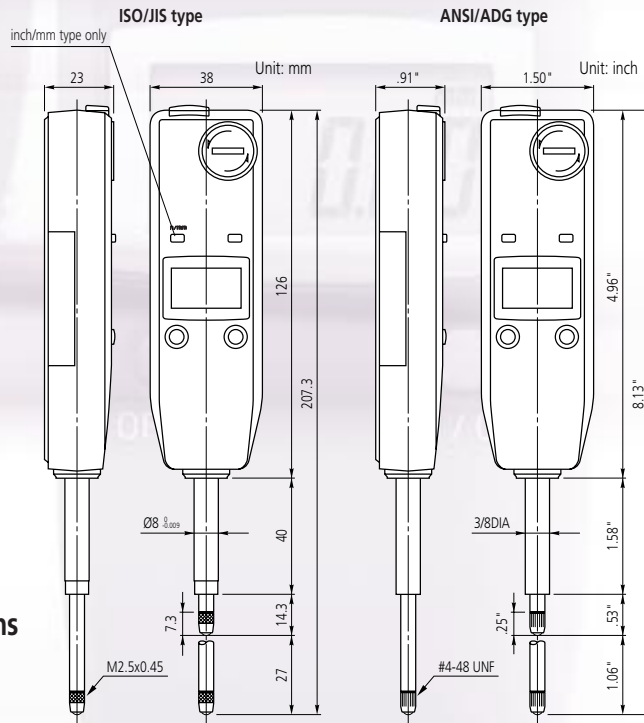


575-123

1"/25.4mm range mode with slim body design

Technical Data

- Display: LCD
- Functions: Origin setting, Power on/off, inch/mm conversion (inch/mm type), Counting direction switching, SPC data output
- Battery: SR44 (1pc.) (938882)
- Battery life: 20,000 hours in continuous use
- Stem diameter: 3/8" (ANSI/AGD type) or 8mm (ISO/JIS type)
- Contact point: Carbide ball (ISO/JIS type) or steel ball (ANSI/AGD type)
- Measuring force: 1.8N or less
- Dust-water protection level: Conforming to IP42
- Alarm: Low battery voltage, Scale contaminations
- Operating temperature: 0°F to 104°F (0°C to 40°C)
- Mass: .31 lbs./140g



Dimensions

Specifications (ISO/JIS type)

Order No.	Accuracy	Resolution	Range
575-121	0.02mm	0.01mm	25.4mm
575-122	.0008"	.0005"/0.01mm	1"/25.4mm

Specifications (ANSI/ADG type)

Order No.	Accuracy	Resolution	Range
575-123	.0008"	.0005"/0.01mm	1"/25.4mm

**1"/25.4mm, 2"/50.8mm range models
Multipurpose design**



543-558A

2"/50.8mm range model

ABSOLUTE IDC

Standard .5"/12.7mm, 1"/25.4mm, 2"/50.8mm range models
Various designs for a wide range of applications



Peak Holding Type
543-260



Standard Type
543-250



Dust-proof Type
543-259



Signal Output Type
543-282



Designed for Bore Gage
543-264B

Standard Type

FEATURES

Tolerance judgment

- GO/±NG judgment can be performed by setting upper and lower tolerance limits. The judgment result (GO/±NG) can be displayed in full-size characters.

Technical Data

- Display: LCD (indicator face: 330° rotation)
- Functions: Origin set (preset), Power on/off, Zero setting, Counting direction switching, GO/±NG judgment, inch/mm conversion (inch/mm type), SPC data output
- Battery: SR44 (1pc.) (938882)
- Battery life: 5,000 hours in continuous use
- Stem diameter: 3/8" (ANSI/AGD type) or 8mm (ISO/JIS type)
- Contact point: Carbide ball (ISO/JIS type) or steel ball (ANSI/AGD type)
- Measuring force: 1.5N/0.9N* or less (.5"/12.7mm range models), 1.8N or less (1"/25.4mm range models), 2.3N or less (2"/50.8mm range models)
- *543-270/543-270B/543-271/543-271B/543-272/543-272B
- Dust-water protection level: Conforming to IP42
- Alarm: Low battery voltage, Scale contaminations, Over flow error, Tolerance limit setting error
- Operating temperature: 0°F to 104°F (0°C to 40°C)
- Mass: .35 lbs./160g (.5"/12.7mm range models), .42 lbs./190g (1"/25.4mm range models), .62 lbs./280g (2"/50.8mm range models)

Specifications (ISO/JIS type)

Order No.	Accuracy	Resolution	Range	
Back w/lug	Flat-back			
543-250	543-250B	0.003mm	0.001mm	12.7mm
-	543-450B	0.003mm		25.4mm
-	543-460B	0.006mm		50.8mm
543-290	543-290B	0.005mm	0.01mm	12.7mm
543-270	543-270B	0.02mm		
-	543-457B	0.005mm		25.4mm
-	543-454B	0.03mm		
-	543-464B	0.04mm		50.8mm
543-251	543-251B	.00012"	.00005"/0.001mm	.5"/12.7mm
-	543-451B	.00012"		1"/25.4mm
-	543-461B	.00025"		2"/50.8mm
543-291	543-291B	.0002"	.0005"/0.01mm	.5"/12.7mm
543-271	543-271B	.0008"		
-	543-458B	.0002"		1"/25.4mm
-	543-455B	.0012"		
-	543-465B	.0016"		2"/50.8mm

Specifications (ANSI/AGD type)

Order No.	Accuracy	Resolution	Range	
Back w/lug	Flat-back			
543-252	543-252B	.00012"	.00005"/0.001mm	.5"/12.7mm
-	543-452B	.00012"		1"/25.4mm
-	543-462B	.00025"		2"/50.8mm
543-253	543-253B	.00012"	.0001"/0.001mm	.5"/12.7mm
-	543-453B	.00012"		1"/25.4mm
-	543-463B	.00025"		2"/50.8mm
543-292	543-292B	.0002"	.0005"/0.01mm	.5"/12.7mm
543-272	543-272B	.0008"		
-	543-459B	.0002"		1"/25.4mm
-	543-456B	.0012"		
-	543-466B	.0016"		2"/50.8mm

Low measuring force type

FEATURES

Low measuring force of 0.4N - 0.7N

- The low measuring force type is specially designed for elastic workpieces such as plastic parts.

Technical Data

- Measuring force: 0.4N to 0.7N

Note: Other specifications are same as those of the above standard type.

Specifications

Order No.	Accuracy	Resolution	Range	
Back w/lug	Flat-back			
543-254	543-254B	0.003mm	0.001mm	12.7mm
543-274	543-274B	0.02mm	0.01mm	12.7mm
543-255	543-255B	.00012"	.00005"/0.001mm	.5"/12.7mm
543-256*	543-256B*	.00012"		
543-275	543-275B	.0008"	.0005"/0.01mm	.5"/12.7mm
543-276*	543-276B*	.0008"		

*ANSI/AGD type

Dust-proof type

FEATURES

IP53 dust/water protection level

- The IP53 protection level structure of the dust-proof type allows the indicator to resist dust and contaminants for safe operation in harsh machine shop environments.

Technical Data

- Measuring force: 2.0N or less
- Dust/Water protection level: Conforming to IP53

Note: Other specifications are same as those of above standard type.

Specifications

Order No.	Accuracy	Resolution	Range	
Back w/lug	Flat-back			
543-257	543-257B	0.003mm	0.001mm	12.7mm
543-277	543-277B	0.02mm	0.01mm	12.7mm
543-258	543-258B	.00012"	.00005"/0.001mm	.5"/12.7mm
543-259*	543-259B*	.00012"		
543-278	543-278B	.0008"	.0005"/0.01mm	.5"/12.7mm
543-279*	543-279B*	.0008"		

*ANSI/AGD type

ABSOLUTE IDC

Peak Holding Type

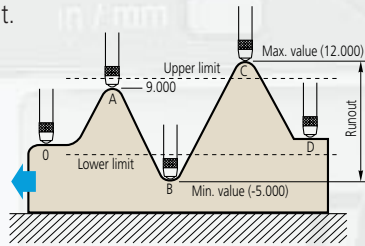
FEATURES

Tolerance judgment

- GO/±NG judgment is performed by setting the upper and lower tolerances for maximum, minimum and runout values.
- High-speed sampling ratio of 50 times per second.

Peak hold function

- The maximum, minimum, or runout value can be displayed during measurement.



Spindle position	0	-	A	-	B	-	C	-	D
Normal mode	0.000	↗	5.000	↘	-5.000	↗	10.000	↘	0.000
Max. mode	0.000	↗	5.000	→	5.000	↗	10.000	→	10.000
Min. mode	0.000	→	0.000	↘	-5.000	→	-5.000	→	-5.000
TIR mode	0.000	↗	5.000	↗	10.000	↗	15.000	→	15.000

Technical Data

- Functions: Origin set (preset), Power on/off, Zero setting, Counting direction switching, GO/±NG judgment, max./min./runout value holding, inch/mm conversion (inch/mm type), SPC data output, Function lock

Note: Other specifications are the same as those of the standard type.

Specifications

Order No.	Accuracy	Resolution	Range
Back w/lug	Flat-back		
543-260	543-260B	0.003mm	0.001mm 12.7mm
543-261	543-261B	.00012"	.00005"/0.001mm .5"/12.7mm
543-262*	543-262B*	.00012"	
543-263*	543-263B*	.00012"	.0001"/0.001mm .5"/12.7mm

*ANSI/AGD type

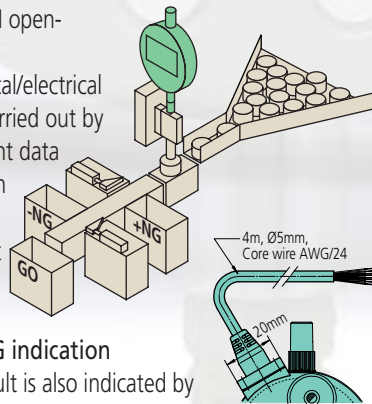
Signal Output Type

FEATURES

GO/±NG signal output

- With the max./min. value holding function, this indicator can output the signal of the GO/±NG judgment result against the peak values set to an external device like a sequencer through the NPN open-collector.

Substitute for the mechanical/electrical contact, the judgment is carried out by calculating the measurement data obtained. This provides high reliability with no deterioration of the contact point and volume adjustment.



Green/red LED for GO/±NG indication

- The GO/±NG judgment result is also indicated by the green/red LED and the "<,O,>" signs on LCD.

IP54 dust/water protection level

- This indicator achieves IP54 protection level to resist dust and contaminants for safe operation in harsh shop environments.

Technical Data

- Functions: Origin set (preset), Power on/off, Zero setting, Counting direction switching, GO/±NG judgment, max./min./runout value holding, inch/mm conversion (inch/mm type), Function lock

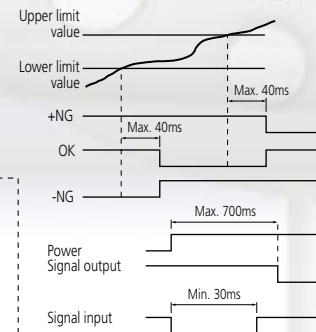
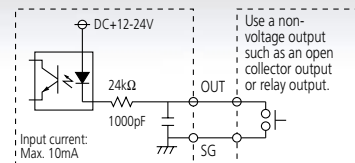
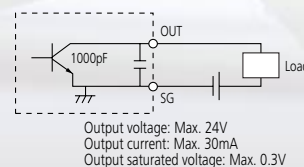
- Dust-water protection level: Conforms to IP54

Note: Other specifications are the same as those of the standard type.

Specifications

Order No.	Accuracy	Resolution	Range
Back w/lug	Flat-back		
543-280	543-280B	0.003mm	0.001mm 12.7mm
543-281	543-281B	.00012"	.00005"/0.001mm .5"/12.7mm
543-282*	543-282B*	.00012"	
543-283*	543-283B*	.00012"	.0005"/0.01mm .5"/12.7mm

*ANSI/AGD type



Signal output

Wire color	Signal	I/O	Description
Black	-V (GND)	-	Connected to minus (-) terminal
Red	+V (plus power voltage)	I	Supply power voltage (12VDC - 24VDC)
Orange	-NG	O	Tolerance judgment result output terminals (NPN open-collector output): Only the terminal corresponding to a judgment result is set to the low level. (See the output circuit diagram.)
Green	OK	O	
Brown	+NG	O	
Yellow	PRESET_RECALL/ZERO	I	External input terminals (no-voltage input): If the relevant terminal is set to the low level, its signal becomes true. (See the input circuit diagram.)
Blue	HOLD_RESET	I	
Shield	FG (Frame Ground)	-	Connected to the ground.

Designed for Bore Gage

FEATURES

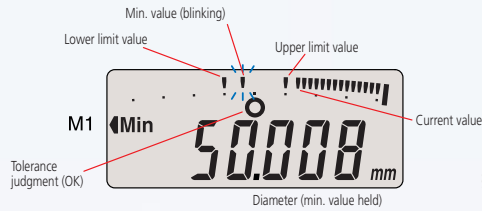
Exclusive design for bore gage use

- The minimum value holding function provides simple, accurate and stable ID measurement.
- Up to three sets of reference diameter and upper/lower tolerance values can be stored to simplify the start-up key operation in the repeatable hole inspection of mixed diameter sizes.
- An analog bar indication is integrated to enhance readability.

Technical Data

- Functions: Origin set (preset), Power on/off, Data hold, GO/±NG judgment, min. value holding, inch/mm conversion (inch/mm type), SPC data output, function lock

Note: Other specifications are same as those of the standard type.



Specifications

Order No.	Accuracy	Resolution	Range
Back w/lug	Flat-back		
- 543-264B	0.003mm	0.001mm	12.7mm
- 543-265B	.00012"	.00005"/0.001mm	.5"/12.7mm

Specifications (ANSI/AGD type)

Order No.	Accuracy	Resolution	Range
Back w/lug	Flat-back		
- 543-266B	0.003mm	.00005"/0.001mm	12.7mm
- 543-267B	.00012"	.0001"/0.001mm	.5"/12.7mm

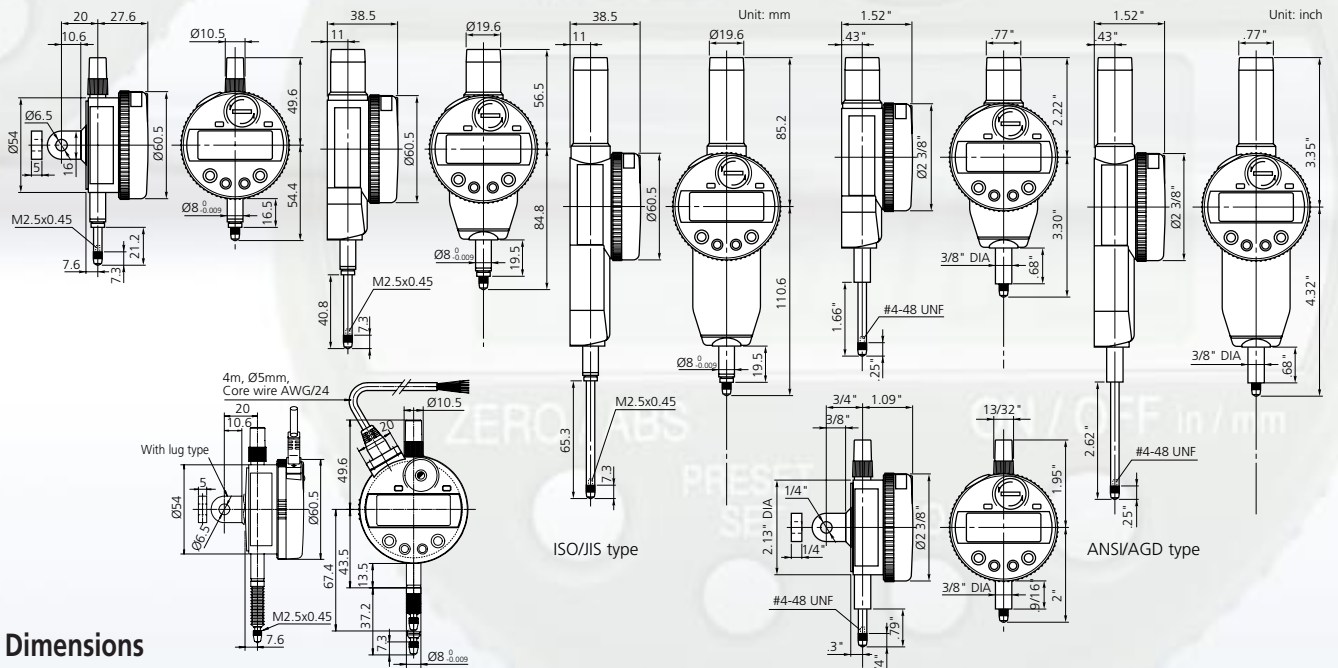
Optional bore gage

Order No.	Range
526-170	0.95 - 1.55mm
526-160	1.5 - 4.0mm
526-150	3.7 - 7.3mm
526-101	7.0 - 10.0mm
526-102	10 - 18mm
511-126	18 - 35mm
511-127	35 - 60mm
511-132	50 - 150mm

* Set No. with IDC 18-150mm:
511-905 .7"-6" 511-915



Detecting a minimum point for diameter

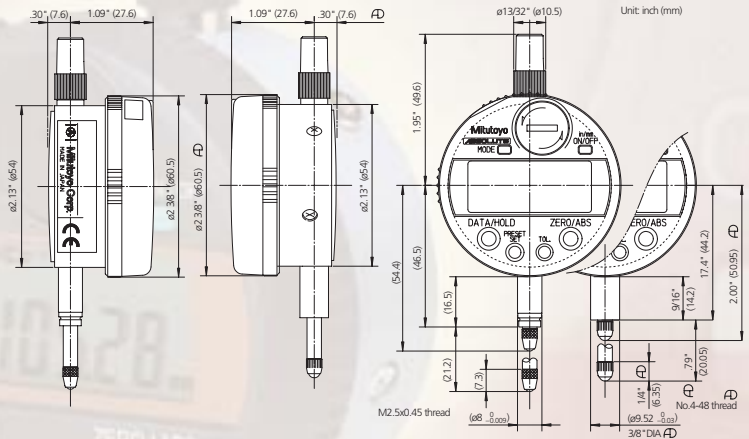


Dimensions

CALCULATION-TYPE DIGIMATIC INDICATOR



The Calculation-Type Digimatic indicator incorporates an internal calculation function in place of spindle displacement. With fixtures, measurements such as inside diameter and radius of curvature measurement can easily be obtained without the trouble of conversion tables or equivalents.



Technical Data

- Display: LCD
- Functions: Calculation, Zero set, Presetting, Tolerance judgment, Hold button, Output and Switching ABS/INC conversion
- Battery: SR44 x 1pc.
- Battery life: 120 months under normal use
- Stem diameter: 3/8" DIA or 8mm (ø9.525mm)
- Contact point: Carbide ball (ISO/JIS type) or steel ball (ANSI/AGD type)
- Measuring force: 1.5N or less
- Dust/Water protection level: Conforming to IP42
- Alarm: Low battery voltage, Scale contaminations, Tolerance limit setting error, ABS data composition error, Over flow error
- Operating temperature: 0°F to 104°F (0°C to 40°C)
- Mass: .35lbs / 160g

Specifications

Order No.	Accuracy	Resolution	Range
543-285B	0.003mm (0.00012") or less	0.002mm to 1mm	12.7mm
543-286B	0.003mm (0.00012") or less	.00001" / 0.003mm to	.5" / 12.7mm
543-287B		.05" / 1mm	

All instruments in this series are of the flat-back type.

Fixture example



Hole diameter



Groove width



Outside diameter



Chamfer hole diameter



Radius of curvature



Inside diameter

Calculation function

The Absolute Digimatic indicator performs internal calculations using the formula $Ax+B+Cx^{-1}$ (assuming spindle displacement as x) while the specified coefficients A , B and C can be set with respect to the purpose of measurement or dimensions of the fixtures. This unique feature allows you to read your measurements directly, without making conversions.

Data output

The Absolute Digimatic indicator can output data to a data processor. This allows the recording of measuring results and the configuration of a system that includes process control via the data processor. Additionally, arithmetic coefficients can be set from a connected personal computer rather than the indicator itself.

Tolerance judgment

Setting the upper/lower limits produces a display of tolerance judgments, thus making it easy to calculate for extreme accuracy.

Large display LCD

A large LCD makes it easy to read the settings of arithmetic coefficients, as well as tolerance judgments and other aspects of the measuring process.

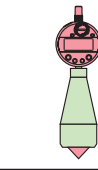
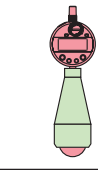
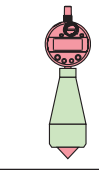
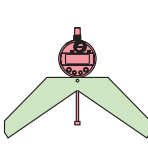
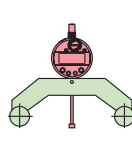
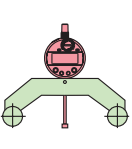
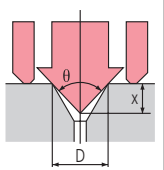
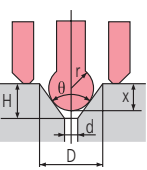
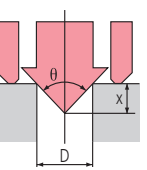
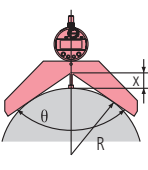
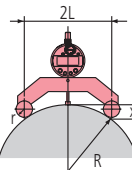
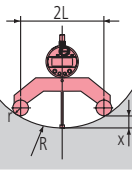
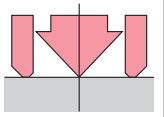
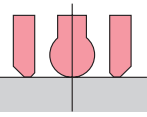
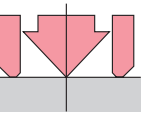

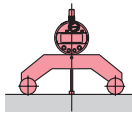
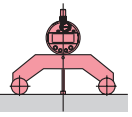
Display hold

The Display Hold function is useful when LCD viewing is difficult during measurement.

Maximum value and minimum value can be held, as well.

Calculation examples of arithmetic coefficients

(Calculate arithmetic coefficients A , B , and C with a scientific calculator and then set the value you've determined. For details, refer to the table below.)

Fixture								
Contact point	Cone	Ball	Cone	—	—	—		
Dimension X : Spindle displacement								
Measurement item	D= Diameter/Feeler/ Groove width H= Countersink depth	D= Diameter/Feeler/ Groove width H= Countersink depth	D= Hole diameter/ Feeler/ Groove width	$2R$ =Outside diameter	$2R$ =Outside diameter	$2R$ =Inside diameter		
Calculation formula	$D=Ax$	$D=Ax+B$ $H=Ax+B$	$D=Ax$	$R=Ax$	$R=Ax+B+Cx^{-1}$	$R=Ax+B+Cx^{-1}$		
Arithmetic Coefficient	A	$-2\tan\frac{\theta}{2}$	$-2\tan\frac{\theta}{2}$	-1	$-2\tan\frac{\theta}{2}$	$-\frac{\sin\frac{\theta}{2}}{1-\sin\frac{\theta}{2}}$	$\frac{1}{2}$	$-\frac{1}{2}$
	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	0	$-r$	r
	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	Value for coefficient B	0	0	(Overflow)	(Overflow)		

Various fixtures suited for individual workpieces can be prepared. Measuring accuracy is subject to fixture accuracy.



Note:

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