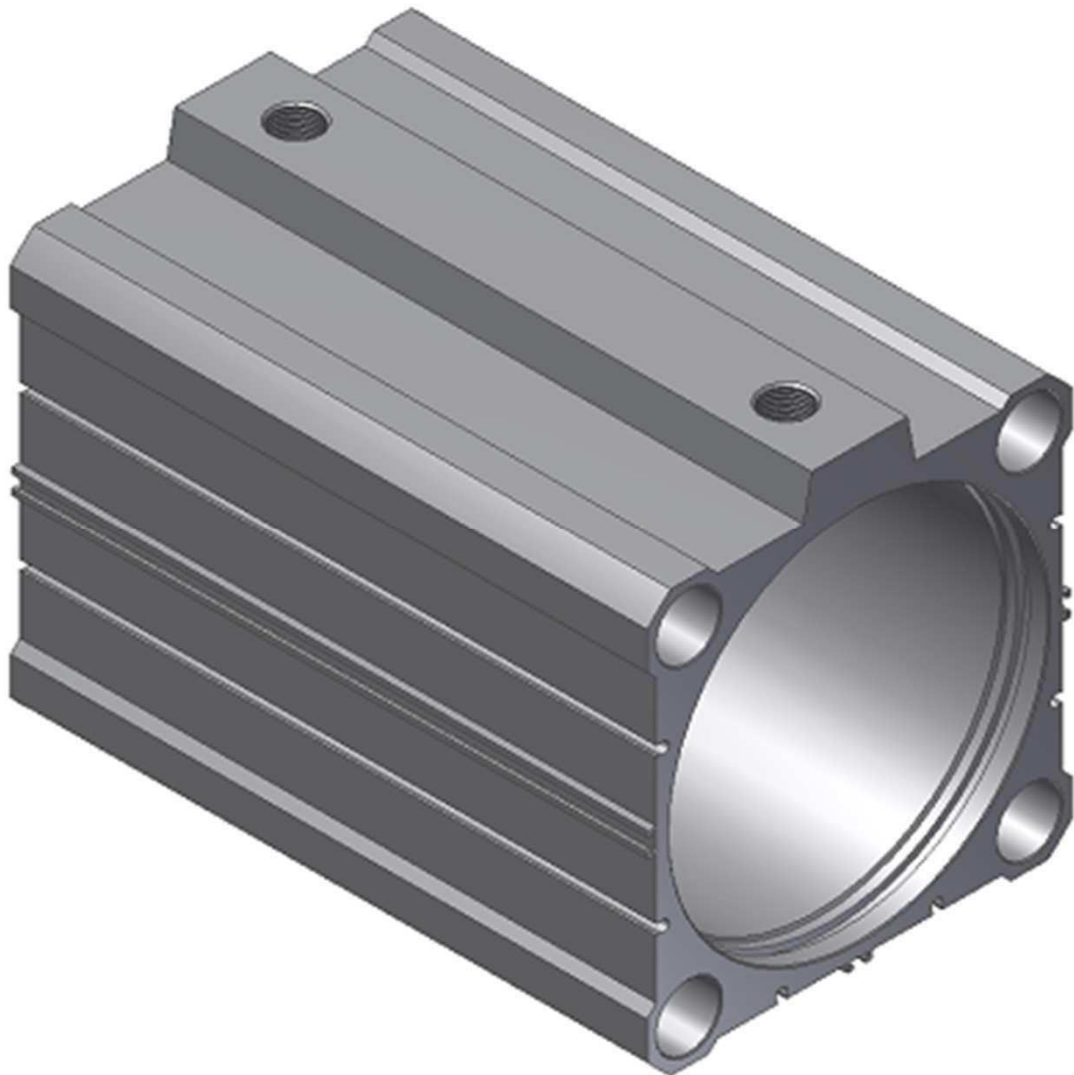


## Essential particular\_Cylinder (No.42586932)

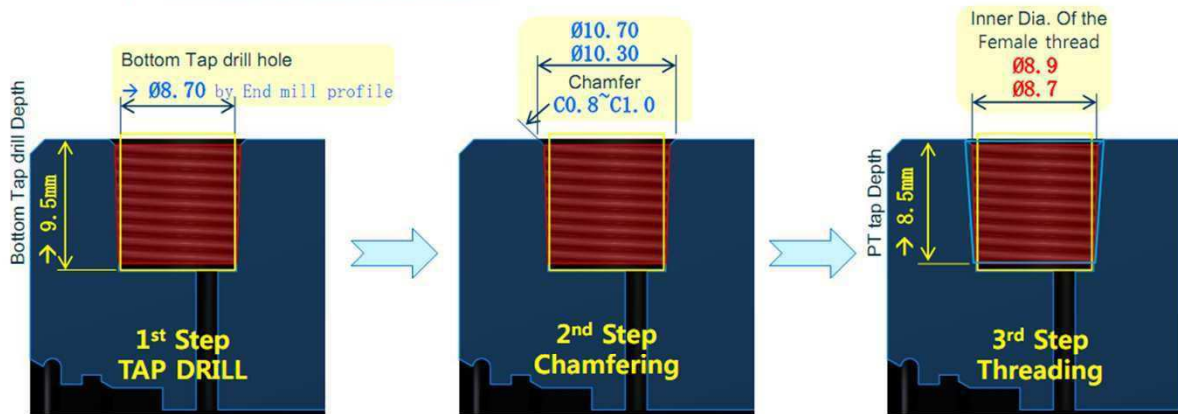
### Manufacturing and mangement of Cylinder

- 1)Inspection of thread
- 2)Management of screw thread
- 3)Threading
- 4)Cyinder`s Magnet
- 5)Anodizing

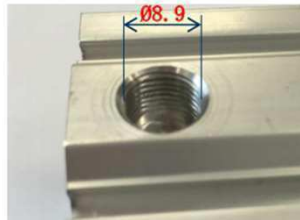


- ⚠ Inspection of thread
- ⚠ Management of screw thread

▶ Machine step : PT 1/8 Compressed air fitting port



PT 1/8 TAP (Inner basic diameter) measures



### ⚠ Threading

▶ Tooling check : PT 1/8 TAP

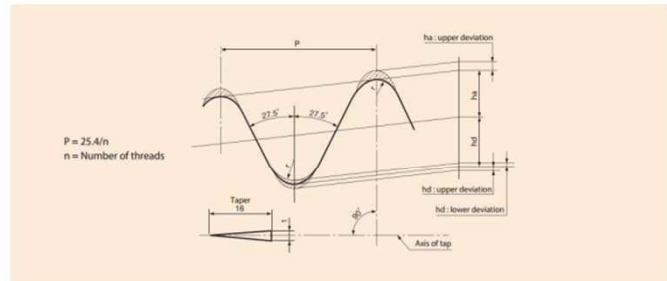
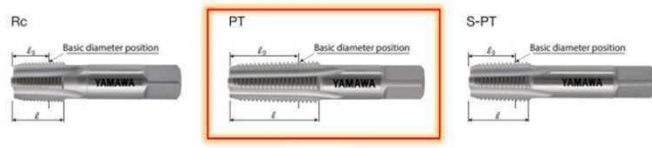


◆ Basic diameter position =  $l - l_g$   
 = 19 - 13  
 = 6.0mm

◆ Actual Tool(Tap) = 13.8 - 8.5 = 5.3mm

測定値      加工値

◆ Comparison = 6.0 - 5.3 = 0.7mm (Over position)

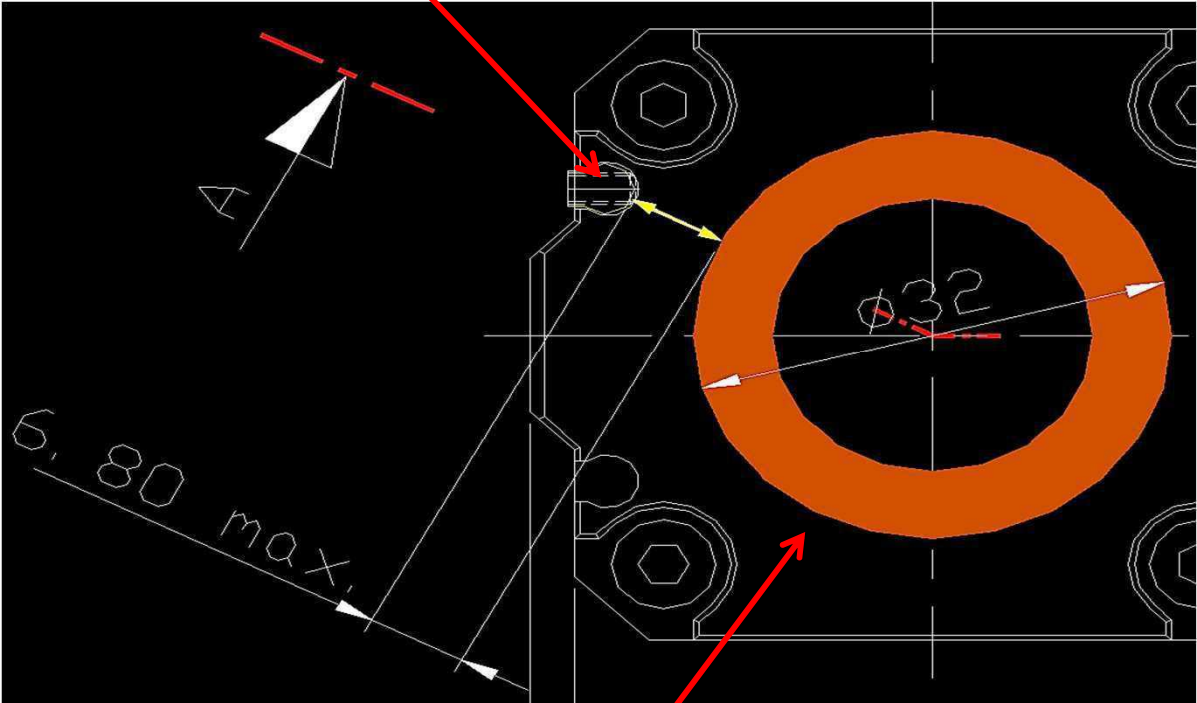


Size	Basic major Dia. of Gauge Plane	Number of Threads <sup>a</sup>	ISO (Rc)		Appendix (PT)		S-PT Thread		Thread Limit			
			Thread Length $l$	Basic Diameter Position $d_2$	Thread Length $l$	Basic Diameter Position $d_2$	Thread Length $l$	Basic Diameter Position $d_2$	Basic Size	Tolerance ( $\mu\text{m}$ )	Basic Size	Tolerance ( $\mu\text{m}$ )
M <sub>6</sub>	7.723	28	14	10.1	—	—	—	—	0.291	0~+30	0.291	±15
1/8	9.728	28	15	10.1	19	13	16.5	10.5	0.291	0~+30	0.291	±15

15-10.1= 4.9mm      16.5-10.5= 6.0mm

⚠ Cylinder Magnet

W8H Auto switch



Rubber Magnet Ring  
"1 place cutting"  
( $\phi 32 \times \phi 22 \times 5T$ )

⚠ Gaussmeter checking



⚠ Bubble test



⚠ Anodizing



⚠ Normally, cylinder is checked by dimensionaonal inspection, machining roughness of Surface by naked eye. Bubble test, gaussmeter is conducted only in special circumstances