

GAGE-LINE CHECKING DIAGRAM

LOCHER, INC.

Spindle Information:
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<==== TOOLHOLDER ====>

<===== IS INSERTED INTO =====>

<===== THE INTERNAL TAPER =====>

<==== AT END OF SPINDLE SHAFT ====>

“Your Complete Spindle
Management Resource”

PH: 800-956-2437

PH: 740.654.8888

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BT STANDARDS:

Measure Gage-Line
same as CAT but
the dimension varies
by Taper Size:

BT30 = .866”

BT35 = .866”

BT40 = 1.063”

BT45 = 1.299”

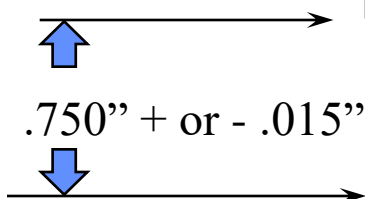
BT50 = 1.496”

CAT STANDARDS:

The Gage-Line for
all CAT Tapers:

#30, #40, #45
#50 and #60

is: .750”



TOOL HOLDER FLANGE

Measure the GAGE-LINE with a depth mic, measuring from the outer surface of tool-holder flange to the face of spindle nose. Compare your mic reading with the appropriate Standards (above left for CAT, above right for BT tool-holders).

Max. OEM Tolerance Limit is usually “plus -or- minus .015”. Exceeding that Tolerance Limit may affect tool changer operation, collet gripping position or pull force pressure. Some machines tolerate Gage-Lines below the “-.015 limit” with no problems or adjust to compensate. Others may use unique non-standard Gage-Lines. Check with your Machine Manufacturer if questions.