



Technical Data

Graduation: .00001" or 0.001mm
 Counter Resolution: .001" or 0.01mm
 Character Height: .16" / 4mm
 Micrometer Head
 Travel stroke: 1" or 20mm
 Pitch: .025"/rev or 0.5mm/rev
 Hysteresis: .00004" or 1µm
 Provided with inspection certificate.

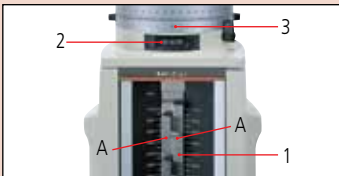
Standard Accessories

Reference Block: 11mm for 515-322
 Reference Block: .3" for 515-310, 515-311

Optional Accessories

515-112: Auxiliary block kit for bore gage (mm)
 515-119: Auxiliary block kit for bore gage (for 515-310)
 515-121: Auxiliary block kit for bore gage (for 515-311)
 ———: Riser block

Reading



Height A

1. Scale	280	mm
2. Counter	5.67	mm
3. Thimble	0.000	mm
		285.670 mm



Height Master

SERIES 515

FEATURES

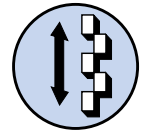
- Models with staggered arrangement of block stack have two measuring faces on the same level, one facing up and the other down (except for 515-310).
- Each height master is supplied with a gage block for zero-setting.
- Supplied in fitted wooden case.



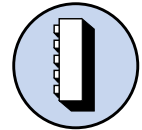
515-322



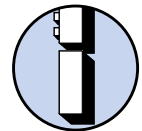
515-310



Staggered 20mm blocks (movable)



Vertical orientation



Riser block

SPECIFICATIONS

Metric

Range (H)	Order No.	Block step	Graduation	Block Pitch Accuracy	Parallelism of Block	Micrometer Head Accuracy	Mass (kg)
5 < H ≤ 310mm	515-322	20mm (staggered)	0.001mm	±1.5µm	1µm	±1µm	23

Inch

Range (H)	Order No.	Block step	Graduation	Block Pitch Accuracy	Parallelism of Block	Micrometer Head Accuracy	Mass (kg)
.2" < H ≤ 12.2"	515-310	.5" (straight)	.00001"	±.00005"	.00004"	±.00005"	23
.2" < H ≤ 12.2"	515-311	1" (staggered)	.00001"	±.00005"	.00004"	±.00005"	23

Digital Height Master

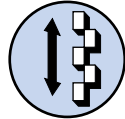
SERIES 515

FEATURES

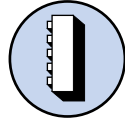
- Standard model with a digital display, featuring all essential specifications required for versatile height standard.
- With SPC output.
- Each height master is supplied with a gage block for zero setting.



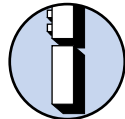
515-374



Staggered 20mm blocks (movable)



Vertical orientation



Riser block



Technical Data

Resolution (LCD): .0001" or 0.001mm
 Graduation: .0001" or 0.002mm
 Character Height .21" / 5.4mm

Micrometer Head

Travel Stroke: 1" or 20mm
 Pitch: .025"/rev or 0.5mm/rev
 Hysteresis: .0001" for all inch models
 0.002mm for 300mm models
 0.0025mm for 450 & 600mm models
 Battery: SR44 (2 pcs.), **938882**
 Battery life: Approx. 1.8 years under normal use

Function

Zero-setting, Presetting, ABS/INC switching, Data hold, Data output, inch/mm conversion (on inch/metric models only)
 Alarm: Low voltage, Counting value composition error

Standard Accessories

Reference Block: 11mm for Metric Height Master **611621-031**
 Reference Block: .6" for Inch Height Master **611196-531**
 Provided with inspection certificate.

Optional Accessories

- 515-111:** Auxiliary block kit for bore gage (mm)
- 515-120:** Auxiliary block kit for bore gage (inch)
- : Riser block (see page E-27.)
- 959149:** SPC cable (40" / 1m)
- 959150:** SPC cable (80" / 2m)
- 050019:** Fitted mahogany case for 12" / 300mm model
- 050059:** Fitted mahogany case for 18" / 450mm model
24" / 600mm model

SPECIFICATIONS

Metric

Range (H)	Order No.	Block step	Resolution	Block Pitch Accuracy	Parallelism	Micrometer Head Accuracy	Mass (kg)
10 < H ≤ 310mm	515-374	20mm (staggered)	0.001mm	±1.5µm	2µm	±2µm	9.5
10 < H ≤ 460mm	515-376	20mm (staggered)	0.001mm	±2.5µm	2.5µm	±2µm	13.6
10 < H ≤ 610mm	515-378	20mm (staggered)	0.001mm	±3.5µm	2.5µm	±2.5µm	16.0

Inch/Metric

Range (H)	Order No.	Block step	Resolution	Block Pitch Accuracy	Parallelism	Micrometer Head Accuracy	Mass (kg)
.5" < H ≤ 12"	515-375	1" (staggered)	.0001" / 0.001mm	±.0001"	.00005"	±.0001"	9.5
.5" < H ≤ 18"	515-377	1" (staggered)	.0001" / 0.001mm	±.0001"	.0001"	±.0001"	13.6
.5" < H ≤ 24"	515-379	1" (staggered)	.0001" / 0.001mm	±.0001"	.0001"	±.0001"	16.0

Riser Blocks

SERIES 515

FEATURES

- These riser blocks are specially designed for standard/digimatic height masters.



515-113

515-114

515-115

SPECIFICATIONS

Metric			
Height	Order No.	Accuracy of height	Mass (kg)
150mm	515-113	$\pm 0.6\mu\text{m}$	5.7
300mm	515-114	$\pm 1.0\mu\text{m}$	11.3
600mm	515-115	$\pm 2.0\mu\text{m}$	31

Inch			
Height	Order No.	Accuracy of height	Mass (kg)
6"	515-116	$\pm 20\mu\text{in}$	5.7
12"	515-117	$\pm 40\mu\text{in}$	11.3
24"	515-118	$\pm 80\mu\text{in}$	31

Auxiliary Block Kit

SERIES 515 — for Bore Gage

FEATURES

- Used for efficient zero-setting of dial bore gages and tubular inside micrometers (18 - 150mm) on a Height Master.



515-112

Bore gage zero-setting



SPECIFICATIONS

Metric	
Order No.	Applicable height master
515-110	Universal Height Master
515-111	Digimatic Height Master
515-112	Height Master

Inch	
Order No.	Applicable height master
515-119	Universal Height Master, Height Master (515-310)
515-120	Digimatic Height Master
515-121	Height Master (515-311)

Universal Height Master

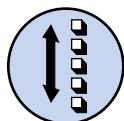
SERIES 515 — Use in Vertical and Horizontal Orientation

FEATURES

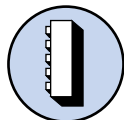
- The Universal Height Master is designed for both vertical and horizontal orientations, providing a wide range of applications, such as accuracy checking of machine tool table movements.
- Fitted wooden case supplied.



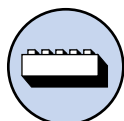
515-520



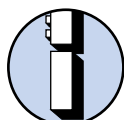
Single-row 10mm blocks (movable)



Vertical orientation



Horizontal orientation



Riser block

SPECIFICATIONS

Metric

Range (R)	Order No.	Block step	Graduation	Block Pitch Accuracy	Parallelism of Block	Micrometer Head Accuracy	Mass (kg)
$5 < R \leq 610\text{mm}$	515-520	10mm (straight)	0.001mm	$\pm 1.5\mu\text{m}$	$1.0\mu\text{m}$	$\pm 1.2\mu\text{m}$	42
$5 < R \leq 1010\text{mm}$	515-523	10mm (straight)	0.001mm	$\pm 3.5\mu\text{m}$	$2.5\mu\text{m}$	$\pm 1.5\mu\text{m}$	63.5

Inch

Range (R)	Order No.	Block step	Graduation	Block Pitch Accuracy	Parallelism of Block	Micrometer Head Accuracy	Mass (kg)
$.2" < R \leq 18.2"$	515-512	.5" (straight)	.00001"	$\pm .00005"$.00006"	$\pm .00004"$	42
$.2" < R \leq 24.2"$	515-510	.5" (straight)	.00001"	$\pm .0001"$.00006"	$\pm .00004"$	50
$.2" < R \leq 40.2"$	515-513	.5" (straight)	.00001"	$\pm .00015"$.00008"	$\pm .00006"$	63.5



Technical Data

Graduation: 0.001mm or .00001"
 Counter Resolution: .001" or 0.01mm
 Character Height: .16" / 4mm
 Block arrangement: Straight arrangement

Micrometer Head

Travel stroke: 1" or 20mm
 Pitch: .025"/rev or 0.5mm/rev
 Hysteresis: .00004" / 1.2μm up to 24.2" / 610mm
 .00006" / 1.5μm for 40.2" / 1010mm

Block pitch accuracy: $\pm 1.5\mu\text{m}$ ($0 < R \leq 310\text{mm}$)
 $\pm 2.5\mu\text{m}$ ($310 < R \leq 610\text{mm}$)
 $\pm 3.5\mu\text{m}$ ($610 < R \leq 1010\text{mm}$)

Parallelism of blocks: $1.0\mu\text{m}$ ($0 < R \leq 310\text{mm}$)
 $2.5\mu\text{m}$ ($310 < R \leq 1010\text{mm}$)

Provided with inspection certificate.

Optional Accessories

- 900574***: Supporting base for vertical operation
 Mass: 3kg
 (*supplied as a standard for **515-523** and **515-513**)
- 515-112**: Auxiliary block kit for bore gage (mm)
515-119: Auxiliary block kit for bore gage (inch)



Using in horizontal orientation



Supporting base



High-Accuracy Check Master HMC-H

SERIES 515

Technical Data

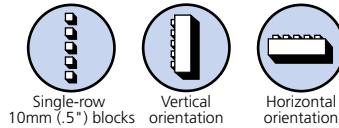
Measuring range (R): Refer to the list of specifications.
 Block pitch accuracy: $\pm 1.2\mu\text{m}$ ($0 < R \leq 310\text{mm}$)
 $\pm 1.8\mu\text{m}$ ($310 < R \leq 610\text{mm}$)
 $\pm 2.5\mu\text{m}$ ($610 < R \leq 1010\text{mm}$)
 $\pm 4.0\mu\text{m}$ ($1010 < R \leq 1510\text{mm}$)
 Parallelism of blocks: $1.0\mu\text{m}$ ($0 < R \leq 450\text{mm}$)
 $1.5\mu\text{m}$ ($450 < R \leq 1010\text{mm}$)
 $2.0\mu\text{m}$ ($1010 < R \leq 1510\text{mm}$)
 Provided with inspection certificate.

FEATURES

- Designed to check the accuracy of table movements of machine tools and calibrate CMMs. Permanently wrung stack of gage blocks is housed in a rigid frame.
- Can be used in either vertical and horizontal orientation.
- Fitted wooden case supplied.

Specifications for Ceramic Check Master:

- Each measuring block is made of zirconia-based ceramic that requires no anti-corrosion treatment for measuring faces.
- Free from deterioration and dimensional changes over time.



SPECIFICATIONS

Range (R)	Order No.		Pitch		Accuracy of block pitch for the range shown below as measured from the bottom block				Length	Parallelism	Mass (kg)
	Steel	Ceramic	P	P	up to 300mm	300-600mm	600-1000mm	1000-1500mm			
					$\pm 1.2\mu\text{m}$	$\pm 1.8\mu\text{m}$	$\pm 1.8\mu\text{m}$	$\pm 2.5\mu\text{m}$			
300mm	515-740	515-760	20mm	10mm	$\pm 1.2\mu\text{m}$	—	—	—	331mm	$1\mu\text{m}$	3.6
450mm	515-741	515-761	20mm	10mm	$\pm 1.2\mu\text{m}$	$\pm 1.8\mu\text{m}$	—	—	482mm	$1\mu\text{m}$	5.4
600mm	515-742	515-762	20mm	10mm	$\pm 1.2\mu\text{m}$	$\pm 1.8\mu\text{m}$	—	—	631mm	$1.5\mu\text{m}$	7.2
1000mm	515-743	515-763	20mm	10mm	$\pm 1.2\mu\text{m}$	$\pm 1.8\mu\text{m}$	$\pm 2.5\mu\text{m}$	—	1037mm	$1.5\mu\text{m}$	12.0
1500mm	515-744	515-764	20mm	10mm	$\pm 1.2\mu\text{m}$	$\pm 1.8\mu\text{m}$	$\pm 2.5\mu\text{m}$	$\pm 4.0\mu\text{m}$	1546mm	$2\mu\text{m}$	18.0

Inch

Range (R)	Order No.		Pitch		Accuracy of block pitch for the range shown below as measured from the bottom block				Length	Parallelism	Mass (kg)
	Steel	Ceramic	P	P	up to 12"	12-24"	24-40"	40-60"			
					$\pm 50\mu\text{in}$	$\pm 70\mu\text{in}$	$\pm 70\mu\text{in}$	$\pm 100\mu\text{in}$			
12"	515-730	515-750	1"	.5"	$\pm 50\mu\text{in}$	—	—	—	13.0"	$40\mu\text{in}$	3.4
18"	515-731	515-751	1"	.5"	$\pm 50\mu\text{in}$	$\pm 70\mu\text{in}$	—	—	19.0"	$40\mu\text{in}$	5.2
24"	515-732	515-752	1"	.5"	$\pm 50\mu\text{in}$	$\pm 70\mu\text{in}$	—	—	25.0"	$60\mu\text{in}$	6.9
40"	515-733	515-753	1"	.5"	$\pm 50\mu\text{in}$	$\pm 70\mu\text{in}$	$\pm 100\mu\text{in}$	—	41.0"	$60\mu\text{in}$	11.5
60"	515-734	515-754	1"	.5"	$\pm 50\mu\text{in}$	$\pm 70\mu\text{in}$	$\pm 100\mu\text{in}$	$\pm 158\mu\text{in}$	61.5"	$80\mu\text{in}$	17.3

Optional Accessories

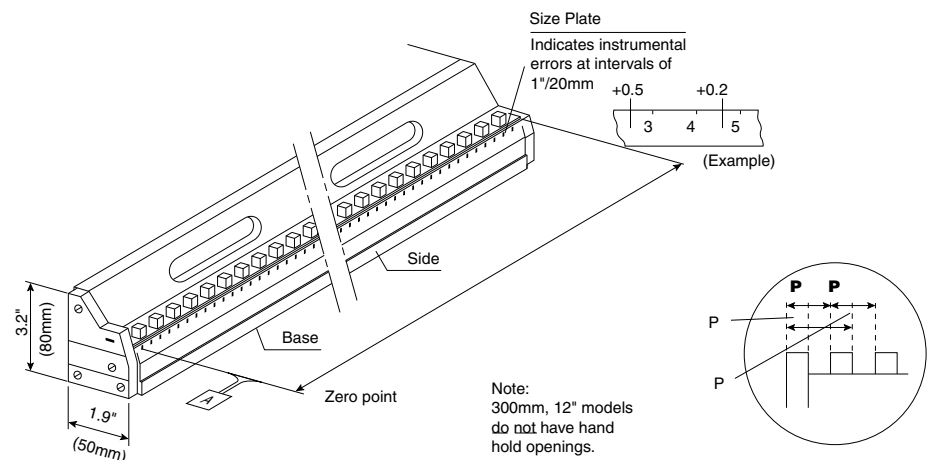
601167: Supporting base for vertical operation

Dimensions: 14.2" (W) x 8.7" (D) x 8.3" (H)
 360mm (W) x 220mm (D) x 210mm (H)

Mass: 3kg



Supporting base



CERA Straight Master SM-C

SERIES 311 — Straightness Measuring Instrument

FEATURES

CERA Straight master is a master gage used for the straightness inspection of each axis movement such as a CMM, machine tool, semiconductor-related equipment and form measuring machine.

- Made from Alumina-ceramic
- 50mm/2" pitch gradation scales
- Precision-lapped measuring surface
- Double-faced type is lapping the double face, which can be used for straightness in horizontal and vertical as a reference square.
- Lightweight
- Supplied with fitted wooden case.



SPECIFICATIONS

Metric		Inch		High-accuracy model		
Nominal length	Order No.*	Nominal length	Order No.*	Straightness	Size (L x H x W)	Mass
400mm	311-302-33	16"	311-322-33	0.3μm	440 x 35 x 50mm	1.8kg
700mm	311-305-33	28"	311-325-33	0.5μm	740 x 35 x 50mm	3kg
1000mm	311-307-33	40"	311-327-33	1.0μm	1040 x 45 x 80mm	8kg
1300mm	311-309-33	52"	311-329-33	1.5μm	1340 x 45 x 80mm	10kg

Metric		Inch		Ultra-high accuracy model		
Nominal length	Order No.*	Nominal length	Order No.*	Straightness	Size (L x H x W)	Mass
400mm	311-332-33	16"	311-342-33	0.2μm	440 x 35 x 50mm	1.8kg
700mm	311-335-33	28"	311-345-33	0.4μm	740 x 35 x 50mm	3kg
1000mm	311-337-33	40"	311-347-33	0.5μm	1040 x 45 x 80mm	8kg
1300mm	311-339-33	52"	311-349-33	0.7μm	1340 x 45 x 80mm	10kg

Double-faced type



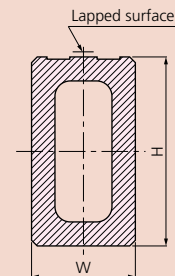
SPECIFICATIONS

Metric		Inch		Double-faced model		
Nominal length	Order No.*	Nominal length	Order No.*	Straightness	Size (L x H x W)	Mass
400mm	311-352-33	16"	311-362-33	0.3μm	440 x 45 x 80mm	3.2kg
700mm	311-355-33	28"	311-365-33	0.5μm	740 x 45 x 80mm	5.5kg
1000mm	311-357-33	40"	311-367-33	1.0μm	1040 x 45 x 80mm	8kg
1300mm	311-359-33	52"	311-369-33	1.5μm	1340 x 45 x 80mm	10kg

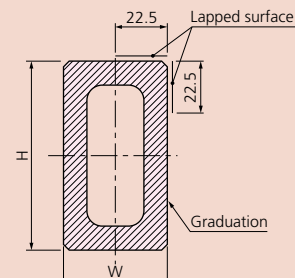
Technical Data

Provided with inspection certificate.

Cross section



Double-faced type



Square Master

SERIES 311 — Squareness / Straightness Measuring Instrument

Technical Data

Squareness: Refer to the list of specifications
 Straightness: Refer to the list of specifications
 Dial test indicator provided
 Range: 0.2mm
 Graduation: 0.002mm
 Accuracy: 3µm

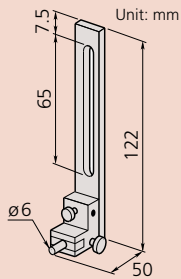
Optional Accessory

—: Riser blocks (see page E-27.)*
900571: Adjustable holder
900551: Extension holder
900565: Feeler**

*Not available for 450mm model.
 Adapter (902803**) is required for metric model.

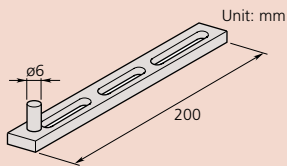
Adjustable holder

No.900571



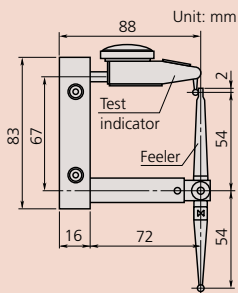
Extension holder

No.900551



Feeler

No.900565



FEATURES

- Squareness (perpendicularity) and straightness measurements can be performed accurately and efficiently by moving a lever.
- With a dial test indicator for reading displacements.
- Its own squareness is adjustable for high-accuracy measurement.



311-215



311-225



311-245

SPECIFICATIONS

Metric				
Vertical travel	Order No.	Squareness	Straightness	Mass (kg)
150mm	311-215	3µm	2µm	13.7
250mm	311-225	6µm	2.5µm	16.2
450mm	311-245	9µm	3.5µm	24

