



MYTRI
PRECISION GRANITE



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GRANITE

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MYTRI
PRECISION GRANITE

INTRODUCTION

MYTRI B.V. in Apeldoorn, HOLLAND has been an established name within the precision measuring industry for over 70 years. MYTRI produces, since 1957, precision granite surface plates, concentricity test benches, measuring beams, straight-edges, squares, as well as basic components for various measuring machines. The technical management has 35 years of experience in precision granite, to any measurable accuracy.

As a manufacturer of precision, Mytri gained an international reputation and nowadays our precision equipment and components find their way into high-tech companies in many countries.



GRANITE

The earth offers many varieties and qualities of granite millions of years old. By no means would every variety of granite be suitable. A soft or porous granite variety influences directly the surface plate **STABILITY** and the measuring surface **DURABILITY**.

THREE IMPORTANT PROPERTIES

As to structure, granite used for the production of granite surface plates should satisfy severe qualifications, leading to the following three important properties:

1. **Durability**
2. **Stability**
3. **Accuracy**

MYTRI FINE BLACK GRANITE

ADVANTAGES

Material	Structure	Hardness
----------	-----------	----------

MYTRI uses Fine Black Granite as their standard. This granite has a very fine-grained structure and is homogeneous with grain-size below 1 mm. Normal black, grey or pink granite have a grain-size of 2-3 mm. The hard crystals of normal granite are rough, the twined spaces weak and porous.

DURABILITY

The high homogeneity of Mytri Fine Black Granite (density 20% higher than normal granite) results in a hardness wherever measured (6,5 - 7 according to Mohs' scale). The high homogeneity of Fine Black Granite guarantees longevity and the highest conceivable degree of accuracy and flatness.

Mytri Fine Black Granite is twice as good as normal granite, due to the directional crystal within the granite, thus giving a high bending strength. To obtain the same bending-strength as normal granite, the plate would need to be 44% thicker. Fine Black Granite is fundamentally insensitive to mechanical overloading.

CHEMICAL CHARACTERISTICS

The absorption of humidity of Fine Black Granite is as half as much than of normal granite. Measuring instruments, inspection equipment which are mounted on normal granite tables can rust due to the absorption of the humidity. Mytri Fine Black granite tables are a corrosion-free base for your measuring equipment.

STABILITY OF TEMPERATURE

Due to a low coefficient of expansion (Mytri Fine Black Granite 5×10^{-6} , normal granite 7×10^{-6} meter per degree) the expansion is low as well. Therefore Mytri surface plates are much more stable in temperature. Unequal temperature – unavoidable in work places and measuring rooms (temperature below and above) – changes the granite surface plates much more, and as a result this influences the accuracy of the surface more than Mytri Fine Black granite surface plates.



ACCURACY

The manufacturing and final inspection takes place in temperature controlled rooms. All measuring equipment is to national and international calibration laboratories standards. Higher accuracies, e.g. DIN 876/000 are possible on request. Measurement deviations for surfaces or lengths amount to 1 micron per 1,000 mm in length and are carried out to the German DIN-standard 876 or – at your request – in every measurable accuracy.



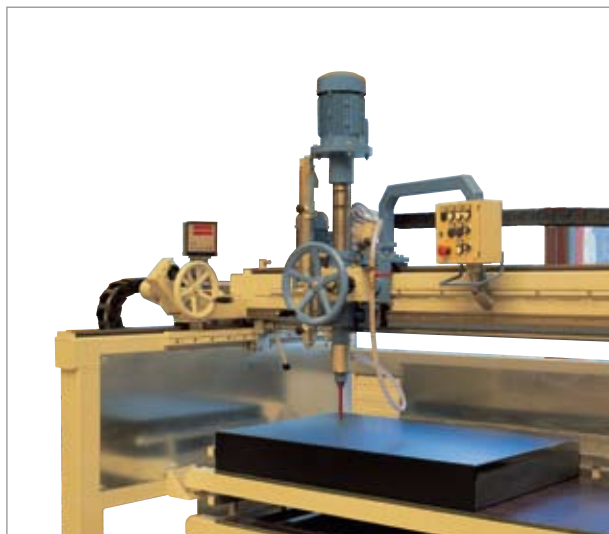
MORE ADVANTAGES....

Totally corrosion free, non-magnetic and di-electric.
All surface plates can be cleaned. Top surfaces are matt and therefore non-reflective. Smooth sliding of measuring equipment and measuring constructions. Because of the high flatness accuracy and density of the upper surface an air cushion is created, on which the measuring tools can slide across very easy.

A large carrying capacity is created by micro accurate lapping of the measuring surface area. Through fine lapping of the surface area, good slide qualities as well as long life and required accuracy is achieved.

Mytri Fine Black Granite has a very fine-grained structure.

This grade is used especially when manufacturing high accurate components and air bearing surfaces.

**ACCURACY BY HAND IS IRREPLACEABLE**

Precision measuring equipment gives very high accuracies by careful manual labour, which achieves the ultimate precision. The maximum accuracy – for example the flatness – of granite surface plates and granite parts can only be achieved by hand.

With our experience for accuracy our experts lap the measuring surfaces of granite parts precise up to 6 decimal places. Due to the high accuracy achieved, an air cushion is created, so that parts can slide easily across the surface and gives excellent durability.

Technical qualities of MYTRI Fine Black Granite:**MATERIAL QUALITIES OF SEVERAL GRANITE SORTS**

Type of stone:	African Black	Mytri Fine Black	Impala	Kuru Grey
E-module (N/mm ²)	70.000	100.000	74.350	52.000
Thickness(kg/dm ²)	2,85	3,1	2,67	2,66
Bending strength ((N/mm ²)	23	38	21,5	24,5
Linear coefficient of expansion (10 ⁻⁶ mm/K)	7,0	5,0	6,8	-
Absorptive power (%)	0,09	0,11	0,35	0,11
Hardness (Mohs' scale)	4,5 - 5,5	6,5 - 7	5 - 6	6,1
Limit of pressure (N/mm ²)	230	280	188	297
Coefficient of friction	0,26	-	0,18	-

All indicated values are average values.

Granite is a natural material where natural deviations can always occur.



SERVICE OFFERED – ALSO ON SITE!

Calibration – Revision

In a production process it is very important, that machined components are produced to the required tolerances.

Unreliable accuracy of the surface plate results in:

- False information about the product
- Dimensional inaccuracy
- Uncommon product dimensions, caused by unknown flatness deviation

Consequently, to manufacture defect-free products, measuring must be carried out on reliable surface plates.

Mytri calibrates and repairs precision granite from all manufacturers!!

On request MYTRI can measure your precision granite tooling in your works and provide it with a test certificate. We also have the facility to lap the plates at your works by one of our experts.

A service, which will save you investment costs and minimises the down time of your measuring equipment!!



MYTRI test certificate to (inter-) national standards.



WYLER top technology in Sensorik and Software.
Where precision and quality count.

MYTRI PRECISION GRANITE SURFACE PLATES

Article No. G-100

Application

As a precision base for control, manufacturing and laboratory purposes.

Construction



Mytri Fine Black homogeneous Granite; top surface lapped to DIN-standard; sides polished; under side sawn. Mytri Fine Black Granite is by far the best, most suitable and most stable granite for use as a precision measuring base for your product. Mytri Fine Black Granite has a very fine-grained structure. Because of its characteristics it is very suitable for high accuracy work pieces, such as air bearing surfaces and linear rail systems.

Dimensions up to 2.000 x 1.000 mm. can be supplied.
For dimensions larger than 2.000 mm the surface plates will be manufactured out of South-African Impala granite.



STANDARD DIMENSIONS MYTRI PRECISION GRANITE SURFACE PLATES

Dimensions (mm)			Deviations (μ)			Weight \pm kg
L	B	H	876/00	876/0	876/I	
200	150	50	2,0	4,0	12,0	4
250	250	50	2,5	5,0	12,5	9
300	200	50	3,0	5,0	13,0	9
300	300	50	3,0	5,0	13,0	13
400	250	60	3,0	6,0	14,0	18
400	400	60	3,0	6,0	14,0	29
500	500	80	3,0	6,0	15,0	60
630	400	80	3,0	7,0	16,0	60
630	630	80	3,0	7,0	16,0	95
800	500	100	3,6	7,0	18,0	120
1000	630	100	4,0	8,0	20,0	190
1000	630	150	4,0	8,0	20,0	285
1000	1000	100	4,0	8,0	20,0	300
1000	1000	150	4,0	8,0	20,0	450
1200	800	150	4,4	8,8	22,0	432
1200	800	200	4,4	8,8	22,0	576
1500	1000	150	5,0	10,0	25,0	675
1500	1000	200	5,0	10,0	25,0	900
2000	1000	200	6,0	12,0	30,0	1200
2000	1000	250	6,0	12,0	30,0	1500
2000	1250	250	6,0	12,0	30,0	1875
2500	1250	300	7,0	14,0	35,0	2800
2500	1500	300	7,0	14,0	35,0	3400
3000	1250	350	8,0	16,0	40,0	4000
3000	1500	350	8,0	16,0	40,0	4600
3000	2000	350	8,0	16,0	40,0	6100
4000	2000	400	10,0	20,0	50,0	9300

	MYTRI FINE BLACK GRANITE
	IMPALA GRANITE

All granite surface plates and granite parts will be delivered with test certificates.

Special constructions:

- other dimensions
- other accuracies, e.g. grade DIN 876/000
- other requirements



MYTRI STANDARDS

The bending of granite surface plates is minimised, if supported at 22% from the side (Bessel points). This 3-point support (A) guarantees against the smallest possible defect caused by bending. Surface plates bigger than 1,000 mm need points 4 and 5 (B) for safety against tilting.

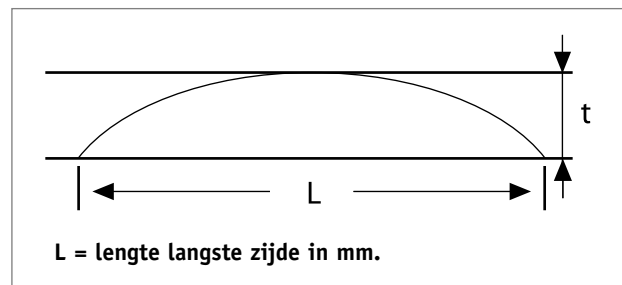
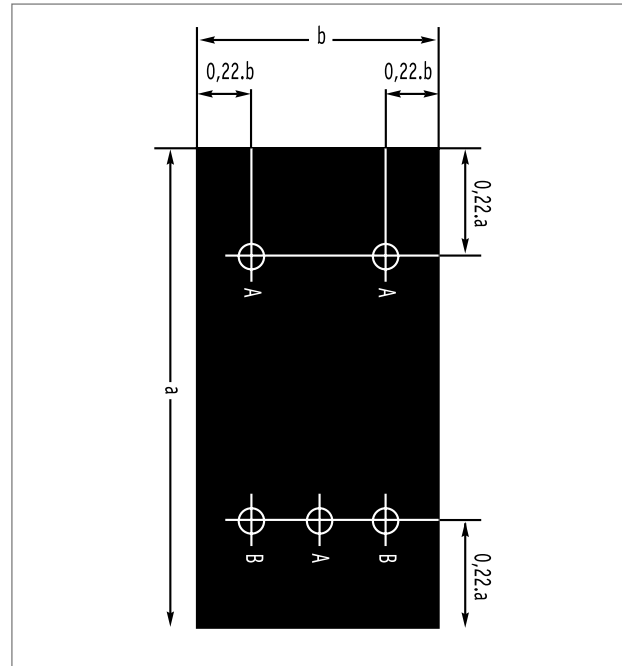
Mytri standards of granite surface plates according to the German DIN-standard 876.

Our standard specification is determined according to DIN-standard 876, in grades 00, 0 and I, and on request, in any measurable grade of accuracy. The flatness for surfaces is described in microns per 1,000 mm. The tolerance for surface flatness is calculated for:

$$\text{Grade 00} \quad 2 \mu + \frac{L}{500}$$

$$\text{Grade 0} \quad 4 \mu + \frac{L}{250}$$

$$\text{Grade I} \quad 10 \mu + \frac{L}{100}$$



STEEL TEE-SLOTS

Application

For accurate movement and tightening of work pieces and applicable holding systems.

Construction

Made of steel; bonded into the surface plate, under flush by approx. 0,5 mm. to the granite top surface. T-slot leading sides are ground square to the measuring surface. The exact position of the T-slot in the surface or in the sides will be determined to customer's request.

Precision TEE-Slot:

Straightness max. deviation 4μ per 500 mm; 14 steel 70; suitable for e.g. precision tailstocks (see page 16).

Tee-nut:

Accurate to H12.

T-slot according to DIN 650; neck width 14 mm.

Article No. G-105



Speciale uitvoeringen:

- andere T-sleuf halsbreedtes (zie normblad volgens DIN 650; bladzijde 25)
- andere nauwkeurigheden

INSERTS

Application

For mounting accessories, clamping work pieces to the surface and sides of the surface plate.

Construction

Manufactured in rust free steel; bonded into plate; with guaranteed pull out torque; mounted $\pm 0,5$ mm. under flush to the granite upper surface.

Solid inserts

To be machined by the customer.
(reamed holes, threaded bores, etc.)

Thread (mm)		Insert Ø (mm)	Pull power (Nm) max.
Size	Depth		
M3	15	10	3
M4	15	10	3
M5	20	14	5
M6	20	14	10
M8	30	20	20
M10	30	20	40
M12	30	20	50
M16	40	30	150
M20	50	40	200

Special requirements:

- other dimensions
- other material

Article No. G-110



ADJUSTABLE ELEMENTS

Application

For setting up and clamping of small surface plates on support stands, etc.

Construction

Manufactured in steel; with swivel foot; height adjustable threaded spindle; quantity dependent on dimensions of the surface plate (for fastening onto the plate, the plate will be provided with inserts).

Adjustable height 50 to 70 mm. with M12 thread.

Foot Ø 50 mm.

Suitable for surface plates up to 1.000 x 630 x 100 mm.

(weights up to ± 200 kg)

Article No. G-115





ADJUSTABLE SUPPORTS

Application

For clamping and levelling of the surface plates to the right working height: suitable for plates from 1.000 x 1.000 mm upwards.

Construction

Manufactured in cast iron; adjustable in height by ball-joints M27 x 100 mm – No. 125; base area machined; unassembled surfaces painted. Colour: RAL 7001.

ADJUSTABLE FROM/TO (mm)	BASE AREA (mm)	WEIGHT (kg)
130 – 155	Ø 90	3
260 – 300	220/220	13
350 – 390	220/220	17
470 – 510	260/260	20
570 – 610	260/260	23
620 – 660	260/260	26
720 – 760	280/280	30

Special constructions:

- other types of paint
- with ball joints M30 x 2
- supports in granite

Article No. G-120



BALL-JOINTS

Application

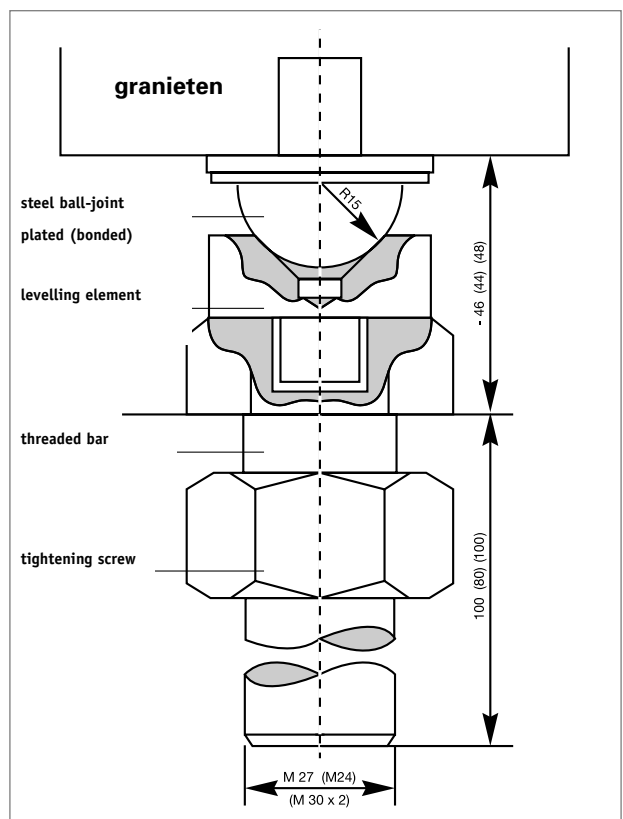
As adjusting- and levelling-element for supporting products such as cabinets, stands etc.

Construction

Manufactured in steel; threaded bar with special machined head to correspond with the levelling element. Levelling-element manufactured in steel, plated. The tightening screw guarantees for the adjusted height to be maintained.

Thread (mm)	
Dimensions	Length
M24	80
M27	100
M30 x 2	100

Article No. G-125



SUPPORT STANDS (safety construction)

The stands are manufactured of a stable welded box section, with 3-point support (Bessel points) and flat plates to avoid tilting. In addition, 4 M16 adjustable screws are mounted in the legs to provide adjustable feet Ø 80 mm out of plated steel. SUVA-CONSTRUCTION.

The stand has also been provided with a corner angle construction, for protection of the granite plate and particularly against movement of the plate. Working height incl. surface plate is about 900 to 1.000 mm and can be adapted upon request.

Color:

Silver grey – RAL 7001

Powder coating

Special constructions:

- other colours
- other dimensions
- other requirements

Suitable for surface plate dimensions (mm):	
500 x 500	1000 x 1000
630 x 400	1200 x 800
630 x 630	1500 x 1000
800 x 500	2000 x 1000
1000 x 630	

SUPPORT STANDS

The stands are provided with 3 adjustable screws M24x80 fine threads and counter nuts (Bessel points) and 2 additional M16 screws for safety against tilting. In addition, 4 screws M16 are mounted in the legs to provide adjustable feet Ø 80 mm in plated steel. The tables are adjustable to a working height (including surface plate) from 900 up to 1.000 mm and can be adapted to your request.

Color:

Silver grey – RAL 7001

Powder coating

Special constructions:

- other colours
- other dimensions
- other requirements

Suitable for surface plate dimensions (mm):		
630 x 400	1000 x 1000	2000 x 1250
630 x 630	1200 x 800	2500 x 1250
800 x 500	1500 x 1000	
1000 x 630	2000 x 1000	

Stable welded corner construction!

Article No. G-130

- Other options available on request.



- 1200 x 800 mm. granite surface plate with safety support table.

Article No. G-131



- Granite surface plate dimension 1.500 x 1.000 x 200 mm. with pair of tailstocks. Standard stands also available with angle profiles (see picture).



SUPPORT CABINETS (safety construction)

The cabinets are made out of a stable welded square tube profile, with 3-point support (Bessel points) and safety tilt device. In addition, 4 M16 adjustable screws are mounted in the legs to provide adjustable feet Ø 80 mm in plated steel.

Cabinet has been provided with an angle construction, for protection of the granite plate and particularly against movement of the plate. Working height incl. surface plate is about 900 to 1.000 mm and can be adapted on request.

SUVA-construction.

ROOM FOR STORAGE

The drawers are equipped with ball bearing runners. Doors and drawers are centrally lockable with a cylinder lock.

Colour:

Silver grey – RAL 7001

Powder coating

Special constructions:

- other colours
- other dimensions
- other requirements

Article No. G-132



Suitable for granite surface plate dimensions (mm):

630 x 400	1000 x 1000
630 x 630	1200 x 800
800 x 500	1500 x 1000
1000 x 630	2000 x 1000

SUPPORT CABINETS

The cabinet is constructed in a steel sheet fabrication, to support the granite surface plates. The upper side is provided with an adjustable 3-point support (Bessel points) and safety tilt device. The under side is also equipped with adjustable screws M16 and provided with adjustable feet Ø 80 mm out of plated steel. The cabinets are adjustable to a working height (including surface plate) from 900 up to 1.000 mm and can be adapted at request.

The drawers are equipped with ball bearing runners. Doors and drawers are centrally lockable with a cylinder lock.

Colour:

Silver grey – RAL 7001

Powder coating

Article No. G-133



- Normal cabinets are also available with angle profiles (see picture).

Plate dimension (mm)		Cabinet dimension (mm)		Drawers Quantity
Length	Width	Length	Width	
800	500	700	450	1 stuks
1000	630	900	580	1 stuks
1000	1000	900	900	2 stuks
1200	800	1000	700	2 stuks
1500	1000	1300	800	2 stuks
2000	1000	1600	800	2 stuks

Special constructions:

- other colours
- other dimensions

GRANITE CASTINGS

Granitek Ltd. is the only privately-owned company in the UK manufacturing **Precision Granite Castings**. Granitek has many years experience in manufacturing components from a few kilos up to several tonnes in weight, and for a wide variety of industry sectors including machine tools, metrology, semiconductor, medical, photo-imaging, pre-press, laser engraving and ship building. With its customers spread across three continents, Granitek's experienced engineers can offer help with all aspects of design.

Granitek **Precision Granite Castings** are produced by using granite aggregates. Crushed, river washed, kiln-dried and mixed with an epoxy resin system to form a casting which can be moulded into **complicated shapes**. All necessary threaded inserts, pipes, hydraulic pipes, etc., can be cast into the component to an accuracy only dependent upon mould manufacture.

Granitek Precision Granite Castings give the following distinctive benefits:

- Reduced assembly costs
- Competitive price
- Excellent vibration damping
(8 to 10 times better than cast iron)
- Improved thermal stability
- High strength to weight ratio
- High static, dynamic, torsional stiffness
- Excellent noise absorption
- Minimal post-cast machining

MYTRI will work with your company closely from concept through detailed design to finished casting if required.

Metrology tables, columns, precision ground, to accuracies of less than $2\ \mu$ can be achieved. Machine tools like milling, grinding, boring, lapping, drilling, etc. can all benefit from a Granitek precision granite cast bases.

Steel fabrications for bed structures and columns often prove not stiff enough statically and dynamically, taking into consideration the demands for increased performance of today's machines. In certain cases the use of **Precision Granite Castings** may not be economical because of small production runs, mould costs or some other technical constraints.

In this case an inexpensive method of filling the welded fabrication with Granitek material is used to give the advantages you would expect from a **Precision Granite Casting**. Examples of **Precision Granite Castings** are too numerous to list them all.

Article No. G-135

GRANITEK 110 – Machine Tool Structure Mixture

Density	kg/m ³	2300
Compressive strength	N/mm ²	90 – 110
Tensile strength	N/mm ²	18 – 21
Bending strength	N/mm ²	19 – 21
Modulus of elasticity	kN/mm ²	37 – 45
Thermal conductivity	W/m °C	1.56 – 1.63
Thermal expansion	$\times 10^{-6}/^{\circ}\text{C}$	11 – 13
Poisson's ratio		.25





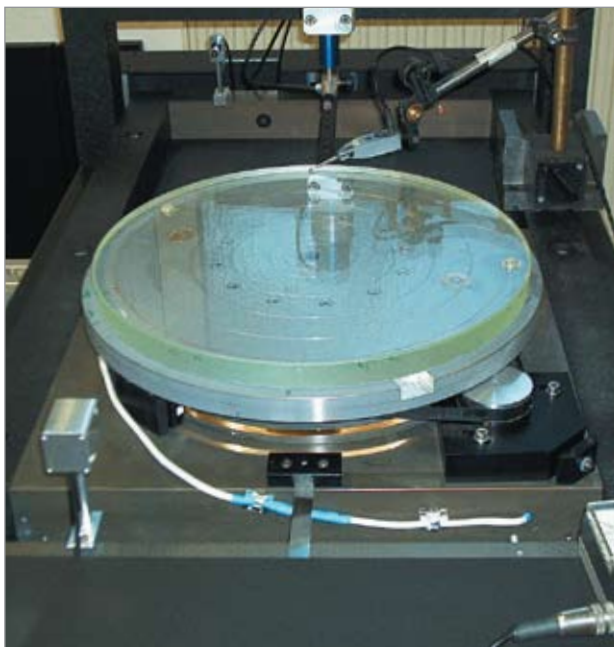
SPECIALE UITVOERINGEN VOLGENS TEKENING /

KWALITEITSBEWUSTZIJN

Naast het fabriceren van granieten vlakplaten en componenten is Mytri gespecialiseerd in het fabriceren van **zeer nauwkeurige machineonderdelen** volgens specificatie van de afnemer en onderdelen voor zowel meet- als bewerkingsmachines. Onze speciale uitvoeringen berusten op decennia lange ervaring in precisie graniet.

Mytri Fine Black Graniet heeft een zeer fijne en homogene structuur. Dit komt vooral tot uitdrukking bij de fabricage van **hoogprecisie werkstukken**, zoals onderdelen voor **luchtgelagerde lineaire geleidesystemen**.

Zie ook blz. 4 + 5.



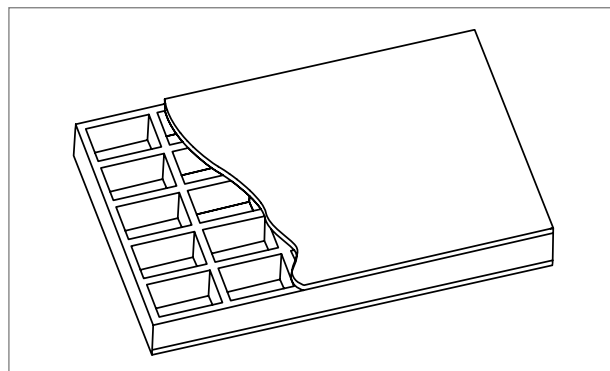
PRECISION LIGHT WEIGHT GRANITE SURFACE PLATES

Article No. G-140

Light weight surface plates in Impala granite. Because of a structured construction, in which several plates out of granite are glued together, it is possible – in comparison with solid plates – to gain a **weight reduction** of 40 to 60%. Another essential advantage can be a faster adaptation in temperature, especially in an environment with great thermal differences.

Special constructions:

- other dimensions
- other accuracies



Dimensions (mm)			Weight (Kg)	Deviations (mm)		
Length	Width	Height		876/00	876/0	876/I
2000	1000	250	547	6,0	12,0	30,0
2000	1500	250	820	6,0	12,0	30,0
2500	1000	350	850	7,0	14,0	35,0
2500	1500	350	1275	7,0	14,0	35,0
3000	1000	400	1336	8,0	16,0	40,0
3000	1500	400	2042	8,0	16,0	40,0
3000	2000	400	2679	8,0	16,0	40,0
3500	1000	450	1551	9,0	18,0	45,0
3500	1500	450	2378	9,0	18,0	45,0
3500	2000	450	3108	9,0	18,0	45,0
4000	1500	500	3317	10,0	20,0	50,0
4000	2000	500	4349	10,0	20,0	50,0

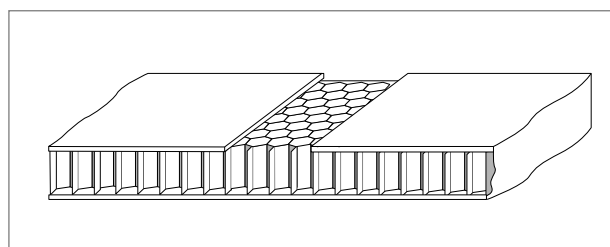
PRECISION GRANITE SURFACE PLATES WITH HONEYCOMB STRUCTURE - SANDWICH

Article No. G-141

This base consists of two plates in Mytri Fine Black or Impala granite, between which a honeycomb structure of aluminium has been mounted, as a 'sandwich-structure'. The 4 outer sides are made in aluminium or granite.

Special constructions:

- other dimensions
- other accuracies



Dimensions (mm)			Strength of the plates	Weight (Kg)	Deviations (mm)		
Length	Width	Height			876/00	876/0	876/I
900	600	190	2 plates of 20 mm	68	4,0	7,8	19,0
1200	600	190	2 plates of 20 mm	96	4,4	8,8	22,0
1200	1200	190	2 plates of 20 mm	185	4,4	8,8	22,0
1600	1200	210	2 plates of 30 mm	360	5,0	10,0	25,0
2500	1250	210	2 plates of 30 mm	580	7,0	14,0	35,0

These 'sandwich-plates' are available up to dimensions of 2,500 x 1,250 mm.



CONCENTRICITY TEST EQUIPMENT

Article No. G-145

Base plate in granite with an integrated T-slot over the length to DIN 650, nominal size 14 - **steel 14H7** (accuracy 0,008 mm per meter).



Lengte	Afmetingen (mm)		Gewicht Kg.	Afwijkingen (μ)		
	Breedte	Hoogte		876/00	876/0	876/I
800	300	120	90	4	7	18
1000	350	150	163	4	8	20
1200	400	150	223	5	9	22
1500	450	200	419	5	10	25
2000	500	250	775	6	12	30
2500	550	300	1.279	7	14	35
3000	600	350	1.953	8	16	40

Accessories: adjustable screws in steel.

PAIR OF TAILSTOCKS

Made of dense, aged and stress relieved special cast iron with high wear resistance. Tailstocks are delivered in pairs, one tailstock with stationary and one with axially adjustable tail spindle. Spindles and dead centres are hardened and precision ground. The sliding blocks have a nominal size of 14 mm. The tailstocks can be fixed to the T-slot with the help of an excentric adjusting device. Hand wheel, adjustable by means of an adjustable tail pressure. To the customers' wishes the tailstocks can be delivered with or without hardened and precision ground prisms, with saving 90°.



Maximum load of the normal tailstocks with tail spindle:

100 mm	centre height	40 kg
150 mm		100 kg
200 mm		150 kg
250 mm		300 kg
300 mm		300 kg

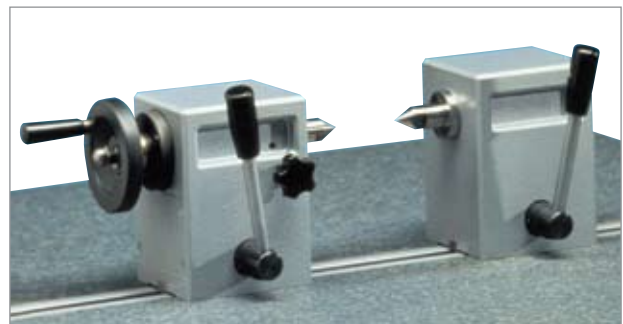
The heavy construction with hand wheel can be maximal loaded with double weight. For more weight special roll blocks are available.

Special construction

Tailstocks with hand wheel, adjustment suitable for heavy work pieces. Height adjustment possible through ground screw-thread with hand wheel (fine adjustment).

Tailstocks with or without prisms.

Article No. G-150



Granite surface plate with tailstocks pair, 200 mm height (normal construction) with tail spindle.

Spitsenhoogte (mm)	Opname MK	Totaallengte (mm)	Gewicht/paar (Kg.)	Klasse 00	Klasse 0	Klasse I
100	2	290	10	± 0,004 mm	± 0,008 mm	± 0,015 mm
150	2	360	25			
200	2	390	30			
250	3	490	55			
300	3	570	80			

MYTRI CLEANING AND MAINTENANCE PRODUCTS

Article No. G-151

MYTRI CLEANER

For simple cleaning of granite parts. Available in a spray bottle of 0,5 litre. Refillable and environment friendly. Also available in a 5 litre can.

MYTRI MAINTENANCE OIL

Mytri maintenance oil is a semi-synthetic oil without aliphatic hydro carbonates. Teflon has been added. Protects precision surfaces against wear and fear and oxidation and makes it possible to move measuring equipment smoothly on the surface plate. Available in a spray bottle of 0,5 ltr. Also available in 1 litre bottle for refilling.





SQUARES 90° TRIANGULAR

Application

For measuring 90° angles.

Construction

Made in MYTRI Fine Black Granite. The two small surfaces are ground and lapped parallel to each other, remaining sides are polished. Straightness relates to the longest side; provided with through-holes for weight reduction and ease of handling.

Article No. G-155

Accessories

Wooden case.



Special constructions:

- Inserts to facilitate transport
- More sides ground to **certificated accuracy** (e.g. setting up machines)
- Other dimensions
- Other accuracies (e.g. DIN 876/000)

Dimensions (mm) Small Length x Width	Thickness	Weight (kg)	Grade 00		Grade 0	
			∥ (μ)	⊥ (μ)	∥ (μ)	⊥ (μ)
300 x 200	60	6	2,5	2,5	5	5
400 x 250	60	10	3 / 2,5	3	6 / 5	6
500 x 300	80	20	3 / 2,5	3,5	6 / 5	7
630 x 400	80	35	3	4	7 / 6	8
800 x 500	100	90	4 / 3	5	7	10
1000 x 630	100	120	4 / 3	6	8 / 7	12
1200 x 800	150	230	4,5 / 4	7	9 / 7	14

All squares are available **with test certificate**.

SQUARES 90° RECTANGULAR

Application

For controlling of 90° squares in vertical position with "turn-back"; suitable for clamping by parallel processing of the functional measuring surfaces.

Construction

Made in MYTRI Fine Black Granite. Four small sides are ground parallel; straightness relates to the longest side; both surfaces are lapped; provided with through-holes to reduce weight and ease of handling.

Article No. G-156

Accessories

Wooden case.

Special constructions:

- Inserts to facilitate transport and / or positioning
- Six sides ground to **certificated accuracy**
- Other dimensions
- Other accuracies (e.g. DIN 876/000)



Dimensions (mm) Small Length x Width	Thickness	Weight (kg)	Grade 00		Grade 0	
			// (μ)	⊥ (μ)	// (μ)	⊥ (μ)
300 x 200	50	7	2,5	2,5	5	5
300 x 300	50	10	2,5	2,5	5	5
400 x 250	60	15	3 / 2,5	3	6 / 5	6
400 x 400	60	21	3	3	6	6
500 x 300	80	30	3 / 2,5	3,5	6 / 5	7
500 x 500	80	42	3	3,5	6	7
630 x 300	80	32	3 / 2,5	4	7 / 5	8
630 x 630	80	68	3	4	7	8
800 x 500	100	84	4 / 3	5	7 / 6	10
800 x 800	100	140	4	5	7	10
1000 x 500	100	120	4 / 3	6	8 / 6	12
1000 x 1000	100	250	4	6	8	12

All squares are available **with test certificate**.

PARALLEL BEAMS

Article No. G-160

Application

Made in MYTRI Fine Black Granite. Both small sides are ground accurate and parallel. From 800 mm length 2 grips are provided.

Accessories

Wooden case.

Special constructions:

- Four sides lapped parallel and flat to each other
- Other dimensions
- Other accuracies (e.g. DIN 876/000)



On request all beams can be provided with through-holes for weight reduction and ease of handling.

Lengte	Afmetingen (mm)		Gewicht (kg)	Klasse 00 // (μ)	Klasse 0 // (μ)
	Breedte	Hoogte			
630	50	100	10	3	7
800	50	120	15	3	7
1000	60	150	27	4	8
1200	60	180	39	4	8
1500	70	200	63	5	10
2000	80	250	120	6	12

STRAIGHT-EDGES

Article No. G-165

Made in MYTRI Fine Black Granite. Both small sides are lapped accurate and parallel in pairs.

Application

Wooden case.

Special constructions:

- Four sides lapped parallel and flat to each other
- Other dimensions
- Other accuracies (e.g. DIN 876/000)



Dimensions (mm)			Weight (kg)	Grade 00 // (μ)	Grade 0 // (μ)
Length	Width	Height			
100	15	25	0,2	2	4
150	20	30	0,5	2	4
200	25	40	1,2	2,5	5
250	30	50	2,2	2,5	5
300	40	70	5	3	5
400	50	100	12	3	6

All straight-edges are available **with test certificates**.



DIAL GAUGE STAND WITH GRANITE BASE

Granite base; measuring table made in MYTRI Fine Black granite. The columns are hard-chromed and ground.

Accuracy of the measuring surface DIN 876/00
Maximum deviation 2,5 μ

The under side of the columns are ground with M10 or M12 thread (adjustable).

All dial gauge stands are available with test certificates.

Artikel Nr. MT-170 – MT 300



Table size 400 x 400 mm. Measuring height 400 mm.

DIAL GAUGE STAND MT 170-HG Base in MYTRI Fine Black Granite.

Technical data	MT 170-HG
Measuring height	180 mm
Extension	100 mm
Table size	300 x 200 x 60 mm
Surface measuring table	240 x 200 mm
Column Ø	35 mm
Weight	13,5 kg
Dial gauge bore	8H7

Other table dimensions, accuracies or measuring heights on request.



DIAL GAUGE STAND MT 170 b-HG Base in MYTRI Fine Black Granite.

Technical data	MT 170 b-HG
Measuring height	180 mm
Extension (max.)	200 mm
Length cross arm	230 mm
Table size	300 x 200 x 60 mm
Surface measuring table	240 x 200 mm
Column Ø	35 mm
Column Ø cross arm	22 mm
Weight	14,0 kg
Dial gauge bore	8H7



* **The dial gauge readings are interchangeable.** Extra dial gauge readings with dial gauge bore 10H7 are also available, as well as an adaptor for current electronically 'length measuring dials'.

Colour of the dial gauge holder: silver black

- Also available with rotation safety.
- Other table dimensions, accuracies or measuring heights on request.

DIAL GAUGE STAND MT 171-HG

Base made in MYTRI Fine Black Granite

Columns with screw-thread, hard chromed and ground, height adjustment through adjusting ring, also anti-fall block.

Technical data	MT 171-HG
Measuring height	180 mm
Extension	100 mm
Table size	300 x 200 x 60 mm
Dimension measuring table	240 x 200 mm
Column Ø	35 mm
Weight	13,5 kg
Dial gauge bore	8H7

Other table dimensions, accuracies or measuring heights on request.

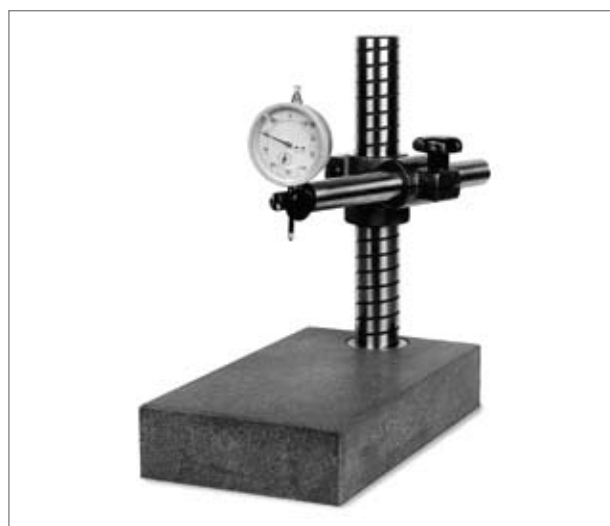


DIAL GAUGE STAND MT 171 b-HG

Base in MYTRI Fine Black Granite.

Columns with screw-thread, hard chromed and ground, height adjustment through adjusting ring, also anti-fall block.

Technical data	MT 171 b-HG
Max. measuring height	180 mm
Extension	max. 200 mm
Length crossing arm	230 mm
Table size	300 x 200 x 60 mm
Dimensions measuring arm	240 x 200 mm
Column Ø	35 mm
Column Ø crossing arm	22 mm
Weight	14,0 kg
Dial gauge bore	8H7



- Also available with rotation safety.
- Other table dimensions, accuracies or measuring heights on request.

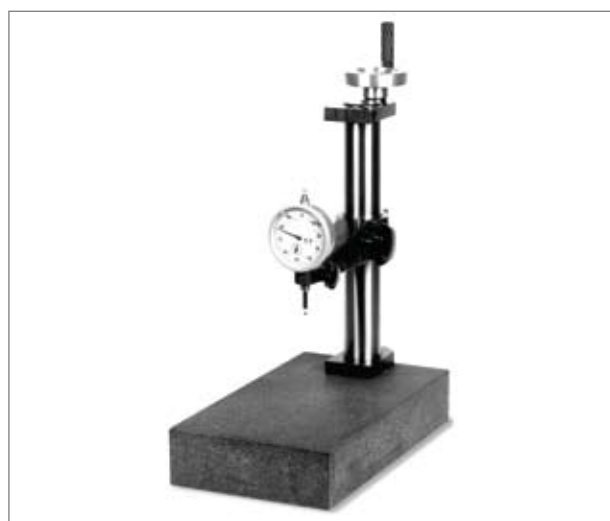
MEASURING TABLE MT 172-HG

Made in MYTRI Fine Black Granite.

Height adjustment through ground precision screw-thread with hand wheel (fine adjustment). Column hard chromed and ground.

Technical data	MT 172-HG
Total height with hand wheel	405 mm
Measuring height	320 mm
Extension	100 mm
Dimension measuring table	300 x 200 x 60 mm
Measuring surface	240 x 200 mm
Column Ø	35 mm
Weight	14,0 kg
Dial gauge bore	8H7

Other table dimensions, accuracies or measuring heights on request.



Colour of the dial gauge holder: silver black



DIAL GAUGE STAND MT300 b-HG

Surface plate with movable horizontal measuring arm, column hard-chromed with screw-thread and adjusting ring, also anti-fall block.

The base of our measuring table MT300 b-HG is in natural MYTRI Fine Black Granite. The columns are hard-chromed and ground. **Surface accuracy to DIN 876/00.** Maximum deviation 3 μ .

Technical data	MT 300 b-HG
Max. measuring height	420 mm
Extension (max.)	220 mm
Table size	400 x 300 x 80 mm
Measuring surface	310 x 300 mm
Column-Ø	50 mm
Column-Ø of the horizontal measuring arm	32 mm
Weight	45 kg
Dial gauge bore	8H7

DIAL GAUGE STAND MT 300 b-HGV

Measuring table with movable horizontal measuring arm, columns hard-chromed with thread and adjusting ring, also anti-fall block. **Horizontal arm with rotation safety.**

- **The dial gauge readings are interchangeable.** Extra dial gauge readings with dial gauge bore 20H7, 25H7, 28H7 and 30H7 are also available, as well as an adaptor for current electronic 'length measuring dials'.

Colour of the measuring dial holder: silver black.

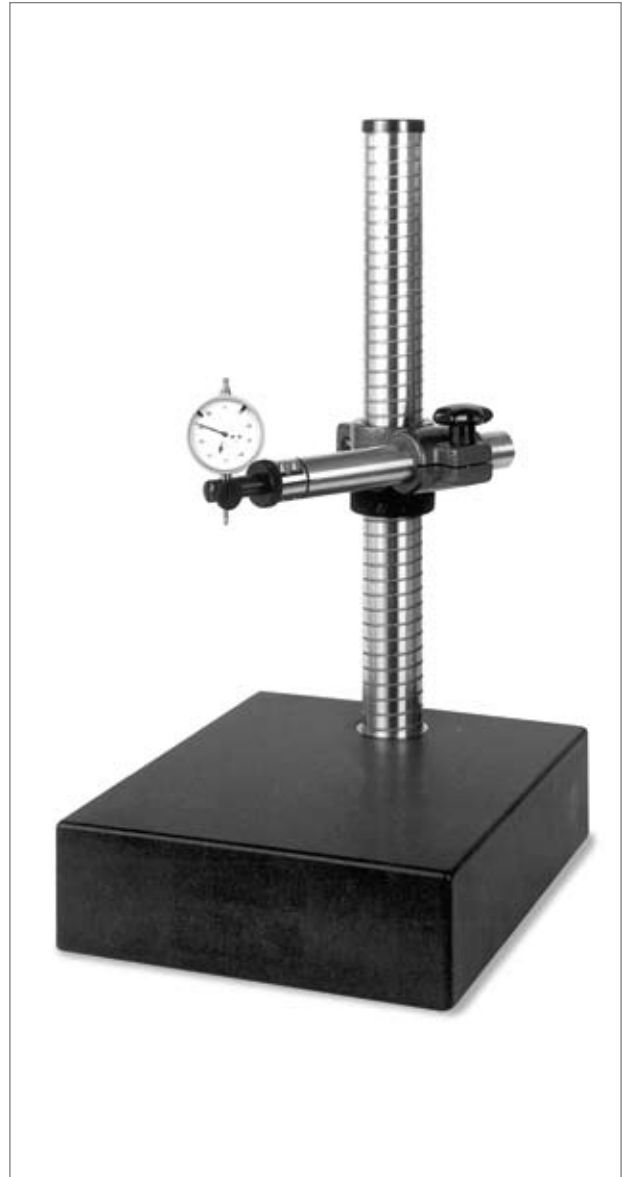
The base plates are also available in other dimensions, accuracies and in steel. **Maximum column height: 600 mm.**

UNIVERSAL MEASURING DIAL STAND

Measuring dial stand with granite triangular base for granite surface plates.
The underside of the granite base is provided with grooves!
Foot provided with M8 thread.
The under and upper side are finely ground within 5 microns. Ease of vibration free movement.
Front ground square, arm **with fine adjustment.**

Max. Measuring height :	max. 280 mm
Stem diameter :	Ø 8 mm. and dovetail
Base dimension* :	length 150 mm width 120 mm thickness 50 mm

* Made in MYTRI Fine Black Granite



Artikel Nr. MT-350



MYTRI MARKING OUT TABLES IN SPECIAL CAST IRON

Article No. S-900

Mytri marking out tables are distinguished by their highly dense and even surface structure. **Exceptional strength and durability of the surface** are guaranteed by a special cast iron/steel alloy. The high stiffness and stability of the plates is achieved by the special rib design with T-shape reinforcements and controlled cooling process.

Providing the plates are stored and supported correctly, subsequent distortion of the top surface of the plate is eliminated due to the various finishing stages. The surface of the plates can be finished to DIN 876/III, II or I.

The sides are machined square to the top surface.

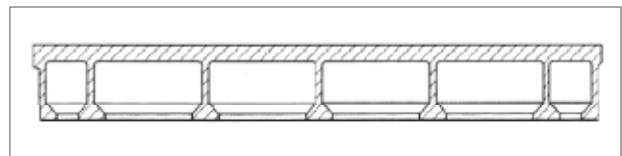
On request the top surface of the plate can be marked with a precise grid pattern of lines, or machined T-slots to DIN 650. A special finish is also possible on the sides to facilitate the fitting of measuring machines (see 'Standards'-page according to DIN 650; page 25).

Our supports on page 26 and 27 are recommended for the installation of these tables.

Marking out plates with ribbing or solid construction available from 200 x 200 mm.

On request we can take over the mounting or clamping activities as well.

Traceable test certificates to (inter-) national standards can be offered.



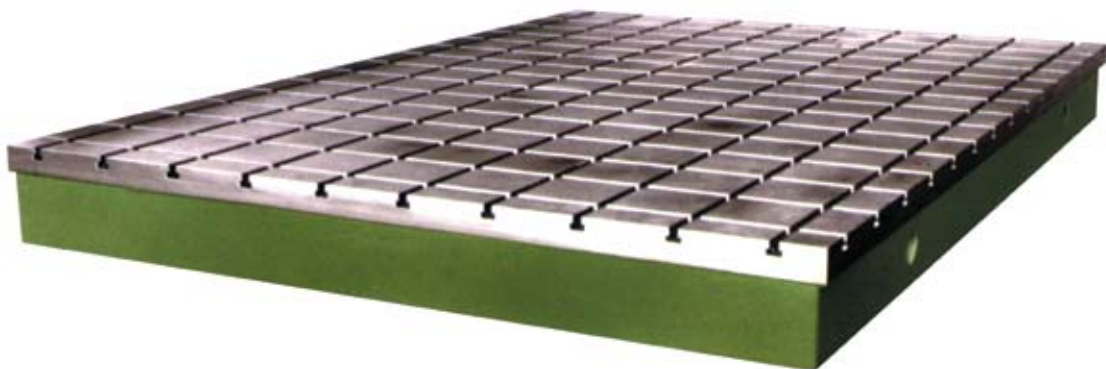


**MARKING OUT PLATES
MADE IN SPECIAL CAST IRON**

to DIN 876/III fine planed
to DIN 876/II very fine planed

Dimensions (ca. mm)	Plate thickness (ca. mm)	Rib height (ca. mm)	Plate height (ca. mm)	Weight (ca. kg)	Dimensions (ca. mm)	Plate thickness (ca. mm)	Rib height (ca. mm)	Plate height (ca. mm)	Weight (ca. kg)
2000 x 1250	50	200	250	1600	5000 x 2000	50	250	300	6540
2000 x 1500	50	200	250	2040	5000 x 2500	50	250	300	8500
2000 x 2000	50	200	250	2530	6000 x 1500	50	250	300	6340
2500 x 1000	50	200	250	1730	6000 x 2000	50	250	300	7770
2500 x 1250	50	200	250	2020	6000 x 2500	50	250	300	10100
2500 x 1500	50	200	250	2470	7000 x 1500	50	250	300	7350
2500 x 2000	50	200	250	3050	7000 x 2000	50	250	300	9050
3000 x 1000	50	200	250	2100	7000 x 2500	50	250	300	11650
3000 x 1500	50	200	250	2980	3000 x 3000	50	300	350	6190
3000 x 2000	50	250	300	3940	4000 x 3000	50	300	350	8320
3000 x 2500	50	250	300	5100	4500 x 3000	50	300	350	9200
3500 x 1000	50	200	250	2460	5000 x 3000	50	300	350	10230
3500 x 1500	50	200	250	3500	5500 x 3000	50	300	350	11300
3500 x 2000	50	250	300	4630	6000 x 3000	50	300	350	12250
3500 x 2500	50	250	300	5970	6500 x 3000	50	300	350	13210
4000 x 1000	50	200	250	2820	7000 x 3000	50	300	350	14180
4000 x 1500	50	200	250	4000	7500 x 1500	50	300	350	8500
4000 x 2000	50	250	300	5300	7500 x 2000	50	300	350	10280
4000 x 2500	50	250	300	6850	7500 x 2500	50	300	350	13240
4500 x 1500	50	200	250	4450	7500 x 3000	50	300	350	15240
4500 x 2000	50	250	300	5850	8000 x 1500	50	300	350	9150
4500 x 2500	50	250	300	7600	8000 x 2000	50	300	350	10940
5000 x 1000	50	250	300	3780	8000 x 2500	50	300	350	14180
5000 x 1500	50	250	300	5330	8000 x 3000	50	300	350	16360

Other sizes available on request.



SURFACE ACCURACY TO DIN 876

Surface accuracy for marking out tables and surface plates in cast iron.

Constructional features

The underside of the measuring surface has to be provided with at least three support points. The design of the plate will be such as to allow the forces acting on the table to be directed towards the support points in order to minimise distortion.

Surface qualities:

DIN 876/III	broad planed finish
DIN 876/II	fine planed finish / scraped finish
DIN 876/I	fine scraped
DIN 876/0	fine scraped with bluing

Flatness tolerance:

Measured at standard temperature of 20°C. Allowable variation of the measuring surface to a true plane in microns (μ) where L (mm) is the length of the longest side of the plate.

DIN 876/III	=	40 +	L:	25	=	μ m
DIN 876/II	=	20 +	L:	50	=	μ m
DIN 876/I	=	10 +	L:	100	=	μ m
DIN 876/0	=	4 +	L:	250	=	μ m

TOLERANTIETABEL:

L	200	300	500	800	1000	1200	1500	2000	2500
DIN 876/III	48	52	60	72	80	88	100	120	140
DIN 876/II	24	26	30	36	40	44	50	60	70
DIN 876/I	12	13	15	18	20	22	25	30	35
DIN 876/0	4.8	5.2	6	7.2	8	8.8	10	12	14
L	3000	3500	4000	4500	5000	5500	6000	6500	7000
DIN 876/III	160	180	200	220	240	260	280	300	320
DIN 876/II	80	90	100	110	120	130	140	150	160
DIN 876/I	40	45	50	55	60	65	70	75	80
DIN 876/0	16	18	20	22	24	26	28	30	32

Dimensions in μ m.

Article No. S-950

T-SLOTS TO DIN 650

Machined T-slots to 650

Tolerance on slot width H12. T-slots as per tolerance H7 and H8 are available on request.

Dimension: a	for screw	b	c	H	e
10	M8	17,5-18	8	18	1,0
12	M10	20,5-21	9	21	1,0
14	M12 1/2"	23,5-24	10	24	1,0
16	M14	26,5-27	11	27	1,0
18	M16 5/8"	29,5-30	12	30	1,5
20	M18	33,5-34	14	34	1,5
22	M20 3/4"	37,5-38	16	38	1,5
24	M22 7/8"	41,0-42	18	42	1,5
28	M24 1"	47,0-48	20	48	1,5
32	M27 1 1/8"	54	22	54	1,5
36	M30 1 1/4"	60	25	61	2,0
42	M36 1 1/2"	70	29	74	2,0



SURFACE PLATES IN SPECIAL CAST IRON/STEEL ALLOY

These lightweight surface plates are made in special cast iron/ steel alloy and have a standard rib design.

The surface of the plates are available to DIN 876/III, II or I.
The sides are machined square to the top surface.

DIN 876/III fine grained
DIN 876/II very fine grained

Article No. S-1101 - S-1121

Optional extras include protective covers, lifting handles for smaller plates and lifting hooks for larger plates, as well as adjusting elements. Also available with a precise grid pattern of lines, bores or T-slots to DIN 650 (see page 25).

A traceable test certificate to (inter-) national standards is available.

Article No.	Sizes		Weight ca. kg	Accuracy in microns			
	Length	Width		Grade 0	Grade 1	Grade 2	Grade 3
1101	160	160	3,5	5	12	24	46
1102	200	200	7	5	12	24	48
1103	250	250	9	5	13	26	50
1104	300	200	11	5	13	26	52
1105	300	300	15	5	13	26	52
1106	400	250	25	6	14	28	56
1107	400	300	25	6	14	28	56
1108	400	400	35	6	14	28	56
1109	500	400	40	6	15	30	60
1110	500	500	50	6	15	30	60
1111	600	500	65	7	16	32	64
1112	630	400	44	7	16	32	64
1113	630	630	70	7	16	32	64
1114	800	500	95	7	18	36	72
1115	1000	600	140	8	20	40	80
1116	1000	750	190	8	20	40	80
1117	1000	800	210	8	20	40	80
1118	1000	1000	270	8	20	40	80
1119	1200	800	310	9	22	44	88
1120	1600	1000	700	10	25	50	100
1121	2000	1000	1000	12	30	60	120



TABLE SUPPORT FRAMES

This support frame is especially used for marking out tables and surface plates. Manufactured from welded steel sections for maximum rigidity. For precision plates it is recommended that optional levelling screws be specified to allow the plates to be aligned accurately in the horizontal plane.

Colour:

green varnished.
Other colours possible.

Article No. S-1108.108 - S-1121/121



Working height approx. 900 mm.

BASE CABINETS

Base cabinets for marking out plates and surface plates with storage for work pieces and measuring equipment. Stability is guaranteed by the sheet metal construction with – depending on the dimensions – 1-3 doors and drawers. Including ball joints and adjusting feet for bottom inaccuracies.

Working height: adjustable from 900 – 950 mm.

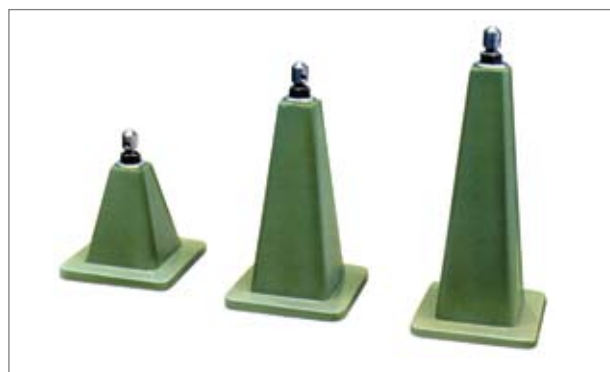
Article No. S-1114/214 - S-1121/212

ADJUSTABLE HEIGHT SUPPORTS

Manufactured in cast iron and recommended for the support and accurate levelling of marking out tables and larger straightening and welding tables. In cast iron, upper base surface machined, remaining surfaces varnished, incl. adjustable elements. Ball joints M24 – M27 or M30 x 100 mm. Base 260 x 260 mm. Suitable for plates as from 630 x 630 mm.

Article No.	Adjustable height / mm
1010	350 – 400 mm
1011	450 – 500 mm
1012	550 – 600 mm
1013	650 – 700 mm

Article No. S-1010 - S-1013



DUPLEX LAPPING AND MASTER PLATES

Duplex plates are made in special cast iron, aged and stress relieved, with a flat master side and a quadratic lapping side, which are **both precision ground**. The combination of both plates saves a lot of space.

Accuracy to DIN 876/I (14μ).

On request the plate can be delivered in a wooden box (article No. 1001). The upper and underside of the wooden box can be taken off, in order to keep the unused plate always protected.

	Length mm	
Article No. 1000	Width mm	360
	Height mm	260
	Weight ca. kg	65
	Accuracy/μm	24
		14

Article No. S-1000 - S-1001



Duplex lapping and master plates are also available in MYTRI



Fine Black granite in several dimensions and accuracies.

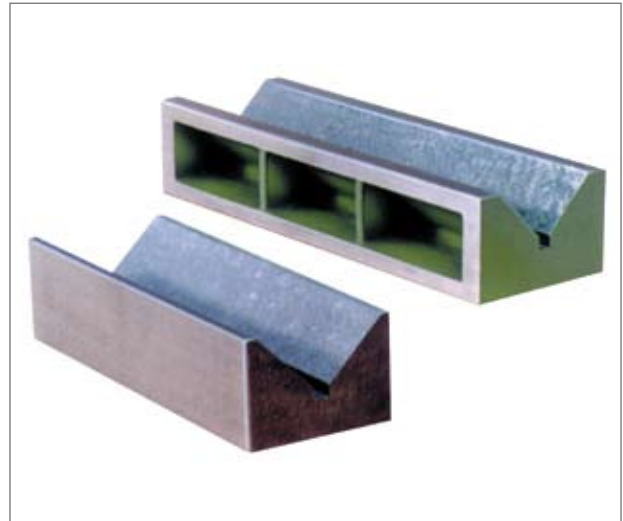
V-BLOCKS - lapped in pairs

V-Blocks are made in special highly wear resistant cast iron. The 90° V-block is parallel to the base and manufactured in pairs, for scribing, adjusting and testing cylindrical parts.

- Grade 0 Supporting surface, prism and outer surfaces fine ground and lapped. Front surfaces machined - Parallelism 0,008 mm
- Grade 1 Supporting surface, prism and outer surfaces fine ground and lapped. Front surfaces machined - Parallelism 0,016 mm
- Grade 3 Supporting surface, prism and outer surfaces fine milled. Front surfaces machined - Parallelism 0,060 mm

Article No.	Dimensions (mm)			Weight ca. kg	Receiver for workpiece/mm
	L	B	H		
1201	100	40	30	2	6 - 50
1202	150	50	40	4	8 - 60
1203	200	70	50	8	8 - 75
1204	250	85	60	13	10 - 100
1205	300	100	70	18	15 - 120

Article No. S-1201 - S-1205



DOUBLE V-BLOCKS – lapped in pairs

Double V-Blocks are made in dense special highly wear resistant cast iron. With 4 recesses in different sizes, angle 90°, made in pairs. These recesses are made **in pairs**, parallel to the base, for scribing, adjusting and testing cylindrical parts.

Article No.	Dimensions (mm)			Weight ca. kg	Receiver for workpiece/mm
	L	B	H		
1301	120	100	60	6	8 - 90
1302	150	130	75	12	8 - 110
1303	200	170	90	25	8 - 150
1304	300	200	90	40	14 - 220

- Grade 0 all surfaces lapped parallelism 0,008 mm
- Grade I all surfaces ground parallelism 0,016 mm

Article No. S-1301 - S-1304



Four sides ground in pairs. Prism angle 90°. Usable on all sides.

Article No. S-2001 - S-2006

TRIANGULAR STRAIGHTEDGES with two handles

The triangular straightedges are made of dense special cast iron and cored-out for weight reduction. Heavily ribbed to avoid bending and distortion. Available with two handles on both sides (screwed in). For prismatic guide way levelling.

Constructions with several angles: 1 x 90°, 2 x 45° or 3 x 60°. The two surfaces are scraped together for angles of 45° or 60°. Accuracy to DIN 876/0 and DIN 876/I.

ANGLE 45°

Article No.	Dimensions (mm)		Weight ± kg	Straightness/μm		Tendency ± μ	
	Length	Width		Grade 0	Grade 1	Grade 0	Grade 1
2201	250	50	2	5	13	4	6
2202	500	75	7	6	15	4	7
2203	750	90	15	7	18	5	8
2204	1000	120	27	8	20	6	9
2205	1500	120	48	10	25	6	10

ANGLE 60°

Article No.	Dimensions (mm)		Weight ± kg	Straightness/μm		Tendency ± μ	
	Length	Width		Grade 0	Grade 1	Grade 0	Grade 1
2301	250	45	3	5	13	4	6
2302	500	60	6	6	15	4	7
2303	750	80	16	7	18	5	9
2304	1000	100	28	8	20	6	10
2305	1500	110	50	10	25	6	10

Grade 0 all surfaces lapped; Grade I all surfaces ground.

Article No. S-2001 - S-2006

LEVELLING STRAIGHTEDGES

The levelling straightedges are made of dense special cast iron and are ribbed to avoid bending and distortion. For levelling small guide ways and surfaces. Accuracy according DIN 876. Measuring surfaces scraped, outer sides and front milled.

Article No.	Dimensions (mm)		Weight ± kg	Accuracy/μm	
	Length	Width		Grade 0	Grade 1
2001	500	40	6	6	15
2002	750	45	9	7	18
2003	1000	50	17	8	20
2004	1500	60	45	10	25
2005	2000	70	65	12	30
2006	3000	90	210	16	40



Grade 0 all surfaces lapped
Grade I all surfaces ground



PARALLEL STRAIGHT EDGES with 2 handle

Article No. S-2101 - S-2105

The parallel straightedges are made of dense cast iron, provided with ribs against bending and distortion. Suitable for measuring and levelling small guide ways and surfaces.

Both surfaces are scraped flat and parallel in pairs, the outer sides are machined.

Accuracy to DIN 876/0 and DIN 876/I.

Parallelism to DIN 874/0 and DIN 874/I.

Article No.	Dimensions (mm)		Weight ± kg	Flatness, parallelism/μm	
	L	B		Grade 0	Grade 1
2101	500	35	5	6	15
2102	750	50	15	7	18
2103	1000	56	25	8	20
2104	1500	70	65	10	25
2105	2000	80	90	12	30

Grade 0 all surfaces lapped; Grade I all surfaces ground.

ANGLE PLATES 90° WITH SEVERAL CLAMP BOLT SLOTS

Made in special cast iron, aged and stress relieved. With strengthened outer sides. Accuracy to DIN 876, straightness to DIN 875, grade 0, I and 3.

Construction AS with cast clamp bolt slots in both surfaces

Length mm	150	200	275	300	400	500
Width mm	75	100	150	150	225	300
Height mm	100	150	200	250	300	400
Weight ca. kg	4	8	20	24	45	85
Grade 0	7	7	9	11	12	15
Grade 1	15	15	20	22	25	30
Grade 3	30	30	40	45	50	60

Larger dimensions on request.

CAST IRON ANGLE PLATES 90°

Made in high density cast iron, with strengthened outer sides. Accuracy to DIN 876/0 or DIN 876/I, square to DIN
Construction AT with cast clamp bolt slots in supporting surface and Tee-slots in front surface. Tee-slots to DIN 650 with accurate cast clamp bolt slots (see page 25).

Length mm	150	200	275	300	400	500
Width mm	75	100	150	150	225	300
Weight approx. kg	6	11	24	33	54	105

Accuracy, straightness/μm

Grade 0	7	7	9	11	12	15
Grade 1	15	15	20	22	25	30
Grade 3	30	30	40	45	50	60

Larger dimensions on request.



Article No. S-1401 - S-1406



Article No. S-1501 - S-1506





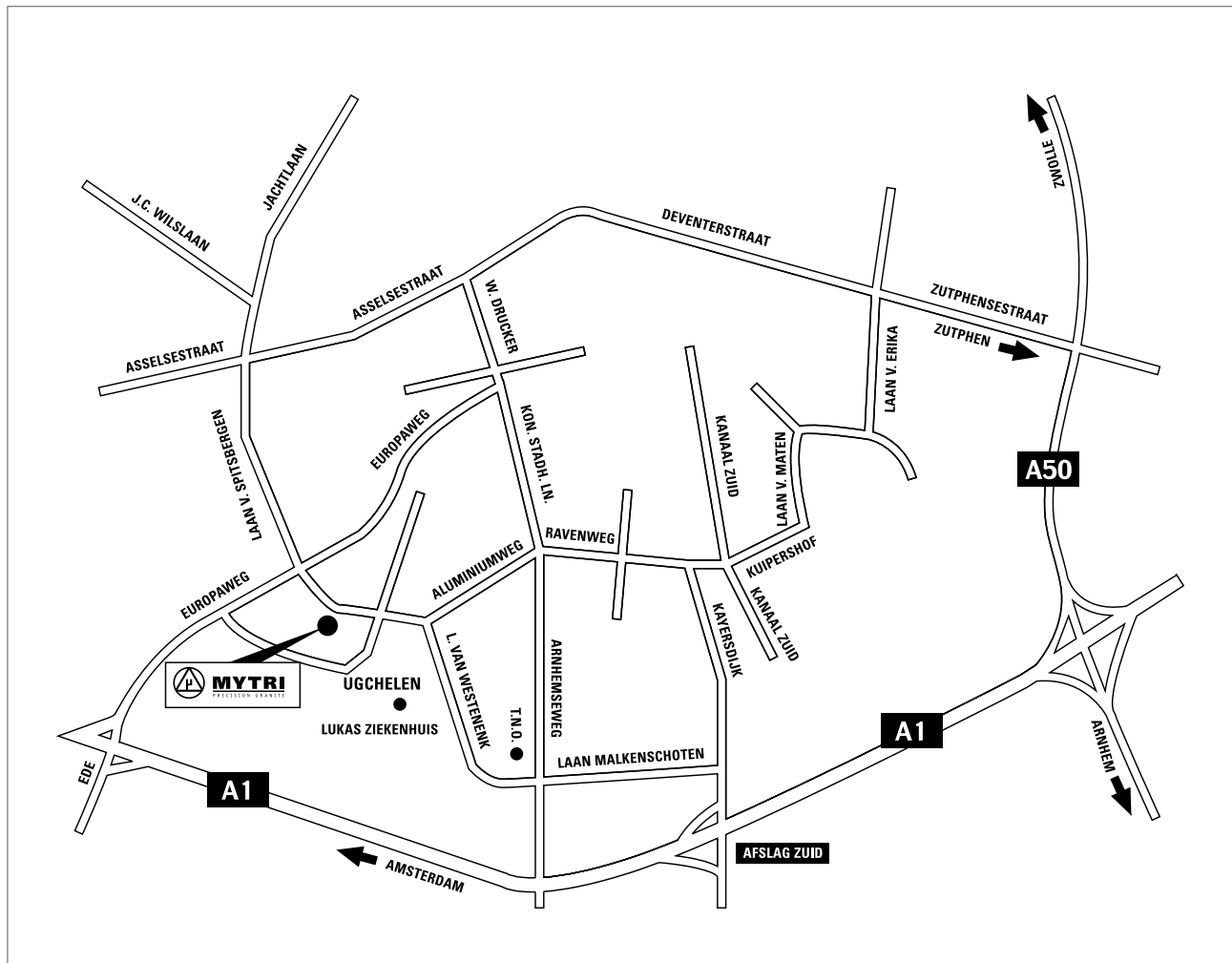
How to find us:

From Amsterdam or Hengelo:

A1, direction Apeldoorn West / Ede-Hoenderloo No. 19
Direction Apeldoorn
At first traffic lights turn right
Third exit right (after ± 500 mtr.)
(Plate 'Bedrijvenpark Ugchelen')

From Zwolle / Arnhem:

A1, direction Amersfoort
Direction Apeldoorn West / Ede-Hoenderloo Nr. 19
Direction Apeldoorn
At traffic lights turn right
Third exit right (after ± 500 mtr.)
(Plate 'Bedrijvenpark Ugchelen')





MYTRI
PRECISION GRANITE



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