

Deflection Tester Bench Centers (P-Type)

Instruction Manual

To ensure correct use, please read this instruction manual carefully before use. After reading, keep it in a safe place where the user can always refer to it.



OBISHI KEIKI SEISAKUSHO Co., Ltd.

Safety Precautions

- ※Before use, please read this instruction manual carefully and use the product correctly.
- ※The precautions shown here are intended to ensure the safe and proper use of the product and to prevent any potential hazards to the user.
- ※The precautions are categorized into three levels — **Danger, Warning, and Caution** — to clearly indicate the severity and urgency of potential harm or damage that may occur if the product is mishandled.

For Safe and Proper Use		
This instruction manual includes various symbols and pictograms throughout the text to ensure correct use of the product and to prevent harm or damage to the user. The symbols and their meanings are as follows. ● Please read the text after fully understanding the symbols and their meanings. ● After reading, be sure to keep this manual in a place where anyone using the product can easily refer to it at any time. ● All of these are safety-related instructions, so please be sure to follow them.		
	Danger	This indicates situations where incorrect handling could result in imminent risk of death or serious injury.
	Warning	This indicates situations where incorrect handling could potentially result in death or serious injury.
	Caution	This indicates situations where incorrect handling may result in injury to persons or only property damage.
Examples of symbols		The △ symbol indicates the presence of danger, warning, or caution messages, with specific precautions described within the figure. (The left figure is used to indicate general danger, warning, or caution without specifying details.)
		The ○ symbol indicates prohibited actions, with specific precautions described within or below the figure. (The figure on the left is used for general prohibition notices without specifying particular actions.)
		The ● symbol indicates mandatory actions, with specific instructions detailed within the figure. (The figure on the left is used for general mandatory actions or instructions without specifying details.)

Bench Centers(P-Type) Instruction Manual

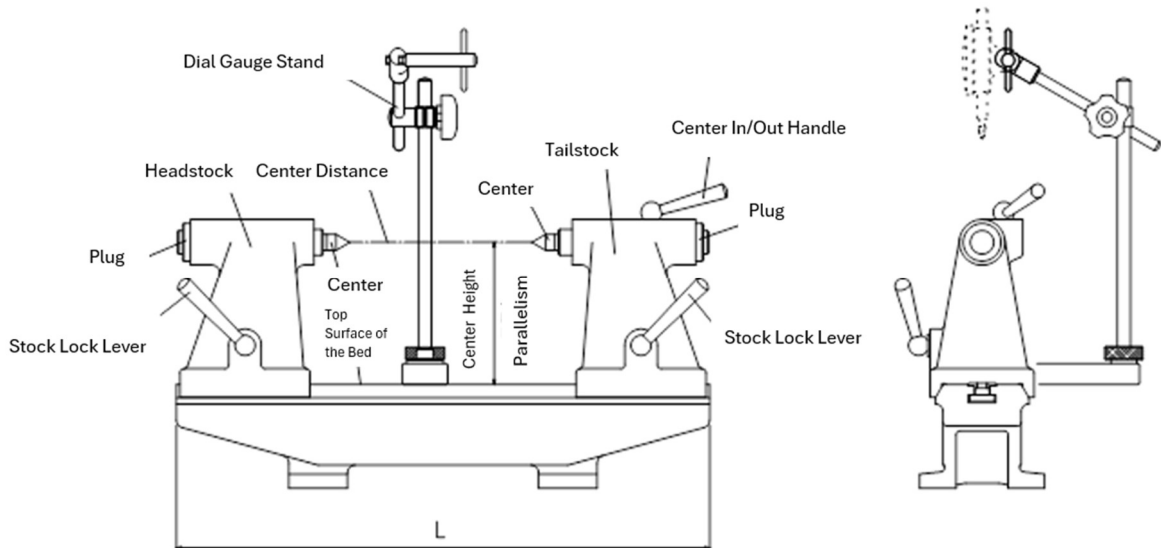
1. Product Features

- This is a compact type of the standard tester.
- Use this instrument for measuring eccentricity and runout of shafts and similar workpieces.
- The parallelism between the top surface of the bed and the centers is ensured.
- The movement of the centers in and out can be operated with a one-touch lever.

Note: Carbide centers or Bevel Centers can be manufactured upon request.

Note: A dial gauge and test bar are not included.

2. Names of Parts and External View



3. Specifications

Code No.	Model	Length (L mm)	Center Distance (mm)	Center Height (mm)	Use Center	Height Parallelism (μ m)	Mass (kg)
SAP101	P-1	410	150	110	MT-1	5	14
SAP102	P-2	470	210				15.5
SAP103	P-3	560	300				17.0

4. Instructions for Use

Workpiece Mounting Procedure

Note: Always fix the stock when mounting the workpiece.

Note: Adjust the position of the stock so that the center of gravity is aligned with the center of the instrument. If the center of gravity is near the outside, stable measurement may not be possible and there is a risk of the instrument tipping over.

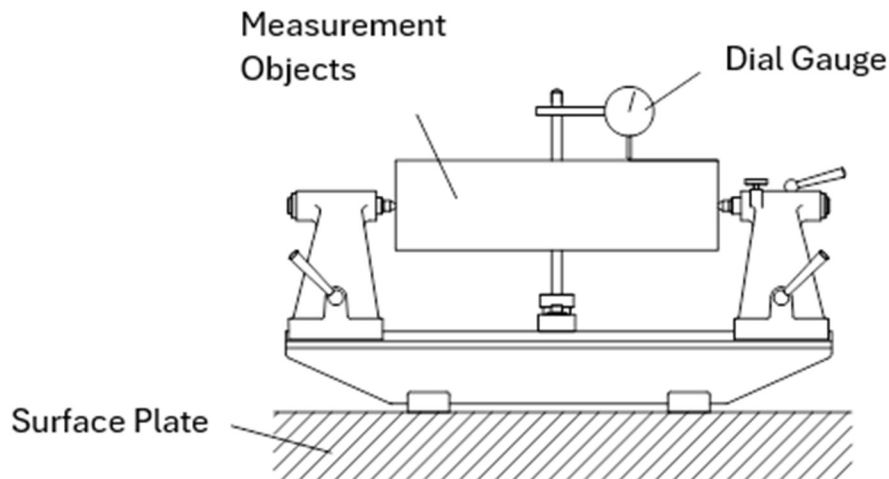
- ① Set the instrument on a stable table.
- ② Loosen the fixing screw of the tailstock, and operate the center in/out handle to confirm that the center moves smoothly. At this time, grasping the amount of center movement will make it easier to adjust the stock position.
- ③ Operate the stock fixing lever to release the lock. (At the time of shipment, the stock fixing lever is in the vertical position and unlocked.)
- ④ Adjust the position of the left and right stocks equally according to the length of the workpiece to be measured.

Note: Move the stocks carefully and little by little, as there is a risk of collision with the opposite stock.

- ⑤ Operate the stock fixing lever to securely fix the stock. The stock is locked when the lever is tilted to either side.
- ⑥ Insert the left center hole of the workpiece into the headstock center.
- ⑦ While supporting the workpiece, operate the center in/out handle and hold the center in the retracted position.
- ⑧ Align the right center hole of the workpiece with the stock center, and slowly operate the center in/out handle to insert the center into the hole.
- ⑨ Confirm that the workpiece is securely held.
- ⑩ After measurement, support the workpiece so that it does not fall, and slowly operate the center in/out handle to remove it. (Follow the reverse order of steps above.)

Measurement Method

- ① Mount the workpiece on the instrument.
- ② Place the stand with the dial gauge on the instrument.
- ③ Lightly bring the stylus of the dial gauge into contact with the highest point of the workpiece.
- ④ Rotate the workpiece and record the needle deflection.



5. Adjustment Method

Adjustment of the Stock Lock Lever

- ① Loosen the stock lock lever.
- ② Move the stock so that the convex piece under the stock protrudes slightly outside the bed T-slot.
- ③ Rotate the convex piece.
- ④ Return the stock onto the bed, tighten the stock lock lever, and check its position.
- ⑤ Move the stock along the bed and make sure it moves smoothly.
- ⑥ If readjustment is required, repeat steps 1–5.

Note: If the convex piece is higher than the top surface of the T-slot, it will not fit into the slot.

Note: The adjustment range is extremely small, so handle with care.

Adjustment of the Center In/Out Handle

- ① As shown in Figure 3, loosen the set screw for fixing the plug and remove the plug.
Since a spring is inserted, take care not to let the plug fly out.
- ② Loosen the set screw for fixing the center in/out handle, lift the handle, and remove it.
- ③ Rotate the center in/out handle to the desired position and insert it so that it meshes with the rack.
- ④ Move the center in/out handle back and forth and check its position again.
- ⑤ After confirmation, install the set screw for fixing the center in/out handle.

Caution: If overtightened, the center in/out handle will not move.

- ⑥ Insert the spring, press in the plug, and install the set screw for fixing the plug.
- ⑦ If readjustment is required, repeat steps 1–6.

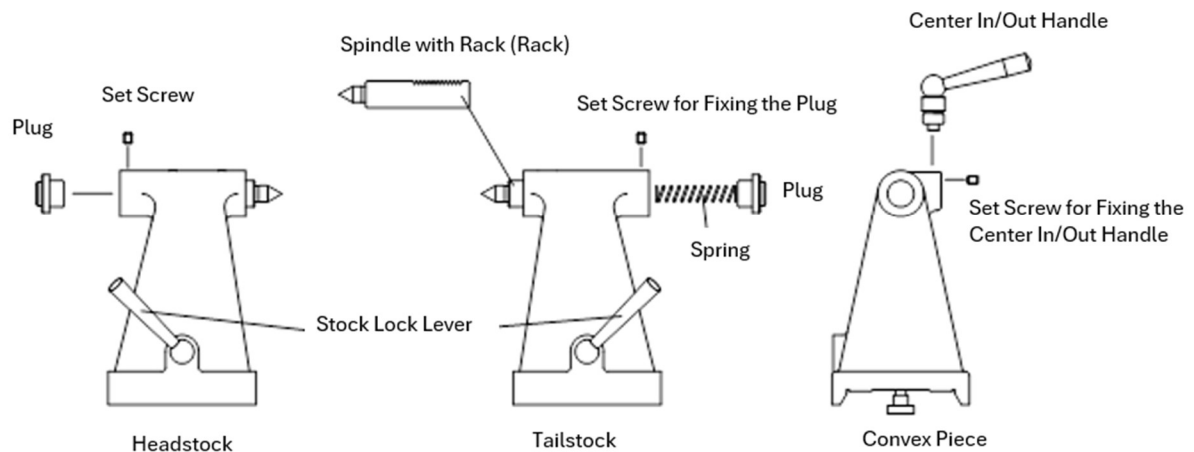


Figure 3. Adjustment of the Convex Piece and the Center In/Out Handle

6. Replacement of the Center

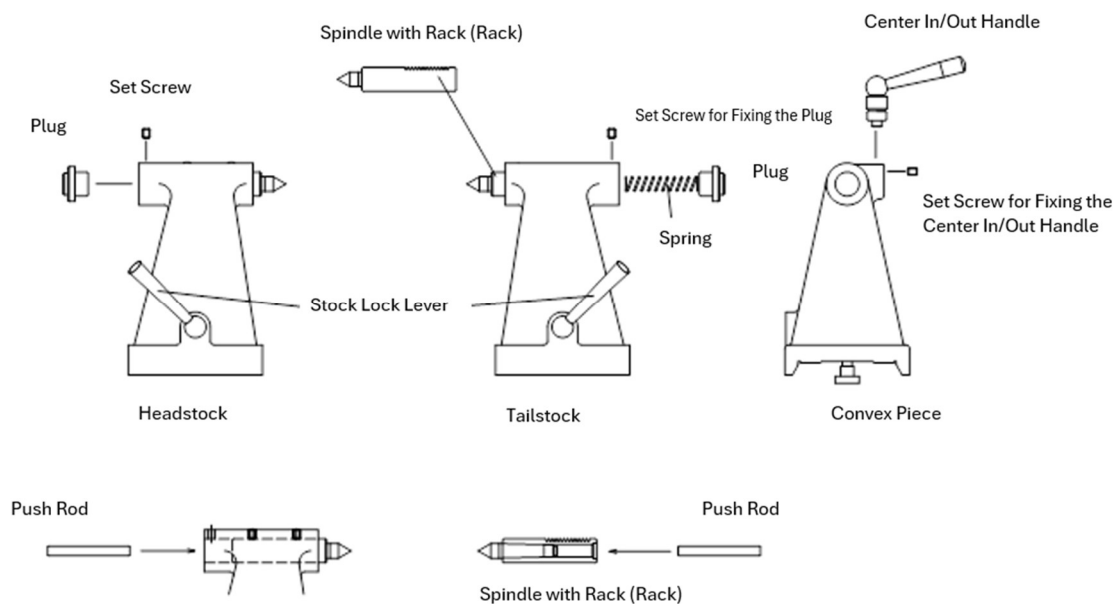
If damage (such as chipping or wear) is found on the tip of the center, replace the center with a new one immediately.

Headstock Side

- ① Loosen the set screw and remove the plug.
- ② Prepare a push rod and insert it into the stock to remove the center.
- ③ Insert a new center.
- ④ To protect the tip of the center, place a wooden block or similar material against it and tap lightly with a plastic hammer.
- ⑤ Reattach the plug and set screw.

Tailstock Side

- ① Loosen each set screw, and remove the plug and the center in/out handle.
Note: Be careful not to let the plug fly out, as a spring is inside.
- ② Pull out the rack spindle.
- ③ Insert a push rod into the rack spindle and lightly tap to remove the center.
- ④ To protect the tip of the center, place a wooden block or similar material against it and lightly tap with a plastic hammer.
- ⑤ Insert the spindle and the center in/out handle, and adjust their position.
- ⑥ Secure the spindle, insert the spring, and then attach the plug and set screw.



7. Precautions for Use

- ① Clean the Precision Surface and the measurement surface of the workpiece before use.
- ② Handle the instrument carefully during use and storage to avoid impact or shock.
- ③ Allow the instrument to acclimate to the ambient temperature before use.
- ④ Do not use or store the instrument in places with drastic temperature changes.
- ⑤ Set this instrument on a stable location with a solid foundation, free from twisting or tilting.
If it is placed on an unstable surface, the accuracy of the bed surface may be affected, and there is a risk of the instrument tipping over or falling due to its weight.
- ⑥ When installing this instrument on a surface plate, check the load capacity of the surface plate (maximum concentrated load mass, JIS B 7513 Table 5).
- ⑦ Do not apply excessive load or impact to the bed or centers.
- △ ⑧ Before mounting the workpiece, always make sure that the stock is securely fixed.
If the stock is not fixed, the spring force inside the tailstock may cause the stock to move, resulting in the workpiece coming off the centers and falling.
- ⑨ Check that the center holes of the workpiece are properly engaged with the centers of this instrument.
If they are not properly engaged, the workpiece may fall when released.
- ⑩ When removing the workpiece, firmly support it with your hand or an equivalent fixture while removing it..

- ⑪ When moving the stock, always move it gradually and carefully.

If it is moved too much at once, the stock may slip on the bed and collide with the opposite stock, causing damage to the centers.

In particular, when the distance between the centers is narrow, lightly tap the rear of the stock and adjust it slowly.

- ⑫ The parallelism between the bottom surface of the bed and the centers is not guaranteed in the initial state.

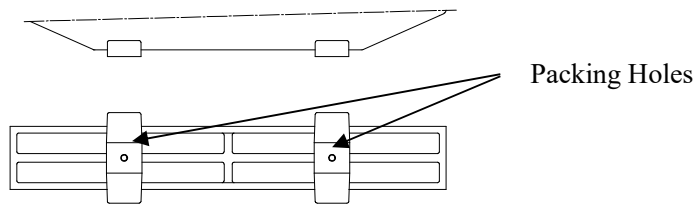
Always check the parallelism during use and make adjustments as necessary.

- ⑬ When moving this instrument, always move it with the stocks fixed.

Note: When transporting by vehicle, insert cardboard or similar material between the two stocks and secure them firmly with string or other means to prevent movement, even if the fixing handle loosens due to vibration.

- ⑭ Do not place this instrument in locations subject to vibration or other similar conditions.

- ⑮ When fixing this instrument, use the packing holes provided for transport.



- ⑯ After use, always perform rust prevention treatment on the instrument.

- ⑰ If there are scratches or damage, have the instrument repaired and inspected. Remove minor scratches on the Precision Surface locally with an Arkansas stone or similar before use.

- ⑱ Check the instrument for abnormalities before use in the following cases:

- When the instrument has been dropped.
- When an object has been dropped onto the instrument.

- ⑲ Use the instrument only after regularly checking for any abnormalities.

- △ ⑳ If the product has sharp edges, handle it carefully to avoid injuring your fingers or other parts of your body.

- △ ㉑ Wear protective gloves and safety glasses as necessary to prevent injury while working.

- △ ㉒ Do not use this product if it is damaged or deteriorated, as it may cause injury or accidents.

- △ ㉓ If an injury occurs, give first aid immediately and seek medical attention if necessary.

Contact Information



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Head Office and Factory

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Design, development, manufacturing, and calibration services for precision measuring instruments (levels, surface plates, straight edges, reference measuring instruments, square rulers, blocks, dial gauge stands, comparators, angle measuring instruments, bench centers, squareness measuring instruments).