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Ensure Interchangeability of Parts Between Different Manufacturers

The Franco spline gage product line provides a quick method of inspecting involute splines, serration splines and straight sided splines to ensure interchangeability of parts even between different manufacturers.

Franco's INO System is an internal standard for the external dimensional measurement of spline gages based on an average of national and international standards that is suited to even the most sensitive and complex components and systems. Franco spline gages are available in extremely wear-resistant chrome steel, powder metallurgy high speed steel ASP and high-alloy powder metallurgy high speed steel HX.

Material	Description	HRc	Life span (relating to LS)
CS	Chrome steel	60-62	100%
SX	Low-alloy powder metallurgy high speed steel ASP 23	63-65	225%
HX	High-alloy powder metallurgy high speed steel	64-66	750%

This content, as well as the hardness of the material, determines the wear resistance of the spline gage. Use can determine the appropriate time intervals between wear inspections depending on this wear resistance. These highly wear resistant materials allow the inspection intervals to be significantly extended.

Spline gauges are subject to wear during use. To this end a wear tolerance with an allowable wear limit of the worn dimension has been designed. Gauges have to be scrapped as soon as this wear limit is reached. The estimated life span is used as a basis for the monitoring pattern and is expressed in the number of workpiece inspections carried out:

- after 25% of the estimated life span: size check over / between pins.
- after 50% of the estimated life span: size check + additional inspection of the individual form deviations.

As a reference, monitoring intervals of spline gauges, depending on the material, is shown in the table below.

Gauge material		Number workpiece inspections	
		hardened	unhardened
Chrome steel HRc 60-62	estimated life span	8.000	12.000
	Size check after no. of pieces	2.000	3.000
	Size & form inspection after no. of pieces	4.000	6.000
Low-alloy powder HSS HRc 63-65 (SX)	estimated life span	18.000	26.000
	Size check after no. of pieces	4.500	6.500
	Size & form inspection after no. of pieces	9.000	13.000
High-alloy powder HSS HRc 64-66 (HX)	estimated life span	60.000	90.000
	Size check after no. of pieces	15.000	22.500
	Size & form inspection after no. of pieces	30.000	45.000

Along with more advanced diagnosis than the currently applicable standards, Frencos spline gages offer traceability to PTB certified parts ensuring reliable measuring results. The Frencos calibration laboratory is a DKD calibration station for helix profile parts.

The quoted price for Frencos spline gages always includes comprehensive gage drawings (also available in electronic form) as well as "new" certification from the Frencos laboratory. All spline gages are clearly and permanently labeled with profile data, user identification numbers, manufacturer's drawing and drawing number, material, serial number and date of manufacture. Spline gages are reusable and worn gages can be rebuilt. Each gage comes with a 5-year guarantee against material faults. Should a material fault occur within this period it will be repaired at no charge.

Special steels are available for added durability, reduction of test equipment monitoring costs, reduced manufacturing or wear tolerances. These have a higher alloy content and hardness. Special delivery is offered for emergency situations.

Euro-Tech Corporation is the only North American Frencos distributor and will feature INO System Spline Gages at IMTS – The International Manufacturing Technology Show being held at Chicago's McCormick Place September 8-13, 2014. Euro-Tech Corporation can be found in the West Building, Tooling & Workholding Systems Pavilion, in Booth **#W-2453**. For more than 30 years Frencos has been dedicated to gear and spline inspection and offers a broad product line to measure all varieties of gears

Euro-Tech Corporation

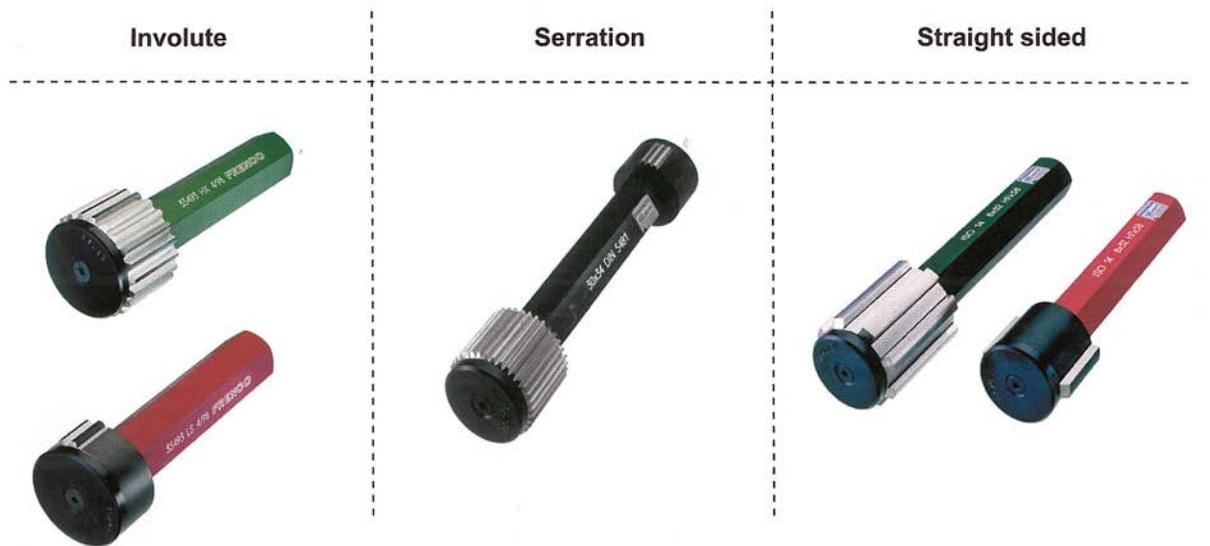
Since 1993, Euro-Tech Corporation has represented unique European-made gages, tooling products such as arbors, chucks, drills, taps, measurement systems and accessories. Euro-Tech also offers the state-of-the-art PG 1000 Cutting Tool Inspection System and the Pinhead Flexible Fixturing Systems for CMMs. Both are manufactured in the U.S.

Euro-Tech is the only North American distributor of Frenco splines and gears. Frenco has specialized in gears and splines since 1978. "In addition to INO Standard gages, Frenco also offers a comprehensive line of variable gaging and workholding products for splines and gears".

Euro-Tech offers custom and standard engineered products geared to increase production for manufacturers in the automotive, aerospace, small engine, medical and wind power industries. The company is headquartered in Menomonee Falls, Wisconsin where a highly skilled team is committed to the continuous development of state-of-the-art solutions.

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Plug gauges Go & No Go



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