



COMPANY GROUP

Automated Systems for Inner Diameter Control



Automated systems for Inner Diameter Control



Systems are intended for contactless measuring of inner diameter and profiles of gun barrels, cylindrical and taper pipes, progressive cavity stators, turbodrills and so on.

We offer systems on the base of

TWO WORKING PRINCIPLES

- Multisensor measurement by stationary laser sensors
- Inner surface laser scanning by rotating sensors

SYSTEMS PARAMETERS

- Measured ID – from 9 mm
- Up to several μm accuracy
- Up to 32000 measured points on the surface in 2 seconds
- Calculation of ovality and roundness
- Surface defects detection and measurement
- 3D model of inner surface design
- Measured ID (**beginning of 2017**) – from 5 mm



The basic elements of ID measurement systems

THE SYSTEMS USUALLY CONTAIN:

- Laser measurement module with
 - stationary sensors
 - or
 - rotating sensors
- Translation module intended for transportation of measurement module inside the pipe:
 - self propelled or
 - any kind of pulling machine
- Software for PC
- Calibration rings

THE SYSTEMS CAN CONTAIN:

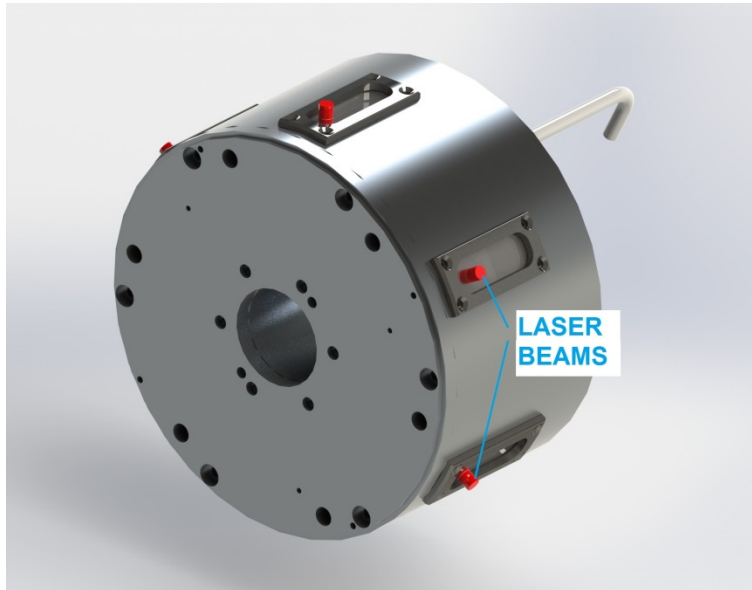
- Centering frame to hold measurement module near pipe axis

OPTIONS:

- Pipe straightness measurement module
- Video inspection module
- Wireless connection (Wi-Fi) module



Multisensor measurement module. Structure and operational principle



THE MEASUREMENT MODULE CONTAINS:

up to 6 laser triangulation sensors located circumferentially in one housing at known fixed angles.

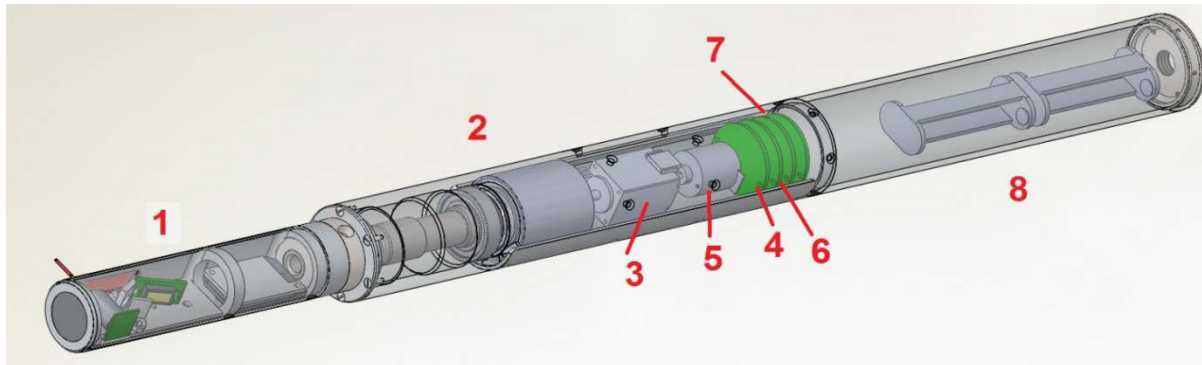
THE SYSTEM OPERATES AS FOLLOWS

The measurement module is inserted into the pipe and moved by translation module to the definite position.

Calibrated laser sensors measure distances to the inner surface

Software calculates diameter of the pipe

Rotating lasers measurement module. Structure



THE MEASUREMENT MODULE CONTAINS:

laser triangulation sensor **1** (one or several with different measurement range and stand-off distance), mounted on rotating platform **2**, which contains motor **3** with electronic driver **4**, and rotary encoder **5** coupled to the motor **3**. The system also includes a tilt sensor **6**, intended for control of inclination of rotating platform during measurement.

Options: in-built Wi-Fi module **7** is used for communication between the system and PC; the system can be powered from internal batteries **8**.

2D laser scanner can be installed instead of points sensor



Rotating sensors measurement module. Operational principle

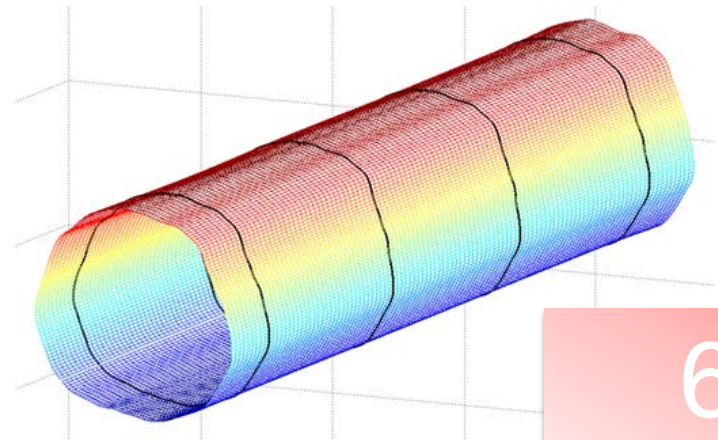
THE SYSTEM OPERATES AS FOLLOWS:

The measurement module is inserted into the pipe and moved by pulling machine to the definite position.

Rotating laser sensor scans inner surface of the pipe and the module transmits polar coordinates of the surface (distance from rotation axis, measured by triangulation sensor and a corresponding angle, measured by encoder).

Software uses the set of transmitted coordinates to calculate:

- ID of measured pipe
- ovality and roundness to find
- surface defects to design
- full profile in definite section.
- 3D model of the pipe inner surface.



6



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Sensors & Instruments

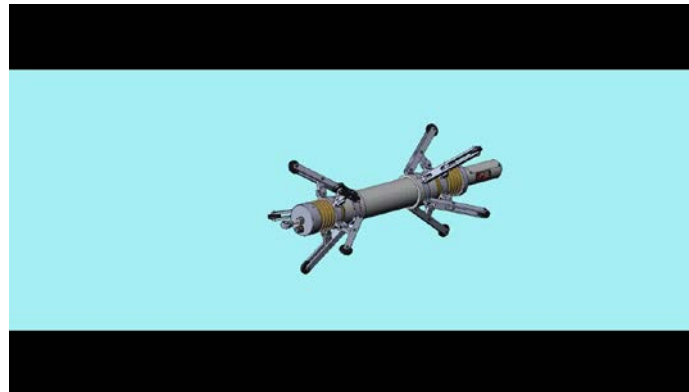
Centering frames for measurement modules



Centering frame is intended to hold measurement module near pipe axis for different pipe diameters.

The frame can contain the set of wheels or rails symmetrically moving according the frame axis

Video demonstration:



<https://youtu.be/yfuouvYADtE>

ID measurement by stationary sensors systems APPLICATIONS

Multisensor laser system for fiberglass pipes deformation measurement



- Six triangulation sensors inside
- Diameter range – 500...1250 mm
- Accuracy - ± 2 mm

Multisensor laser system for smooth gun barrels control



- Six laser sensors inside
- Diameters: 125...132 mm
- Accuracy $\pm 2 \mu\text{m}$
- Barrels straightness measurement accuracy $\pm 5 \mu\text{m}$
- Self-propelled system for device translation



VIDEO: Multisensor laser system for smooth gun barrels control



11

Multysensors module. Four laser sensors inside

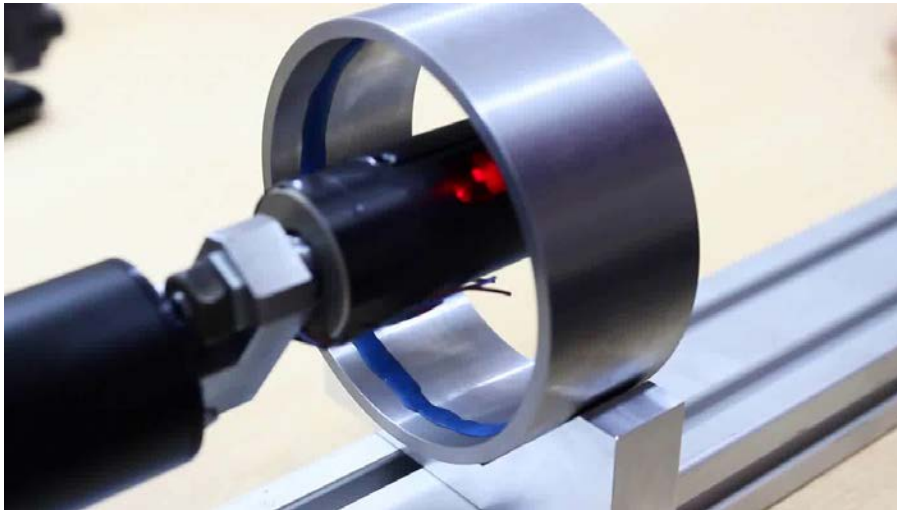


- Diameter of the module – 70 mm
- Measured diameters: 95...195 mm (main range), 160...300 mm (extended range)
- Accuracy: 0,05 mm (main range) and 0,2 mm (extended range)

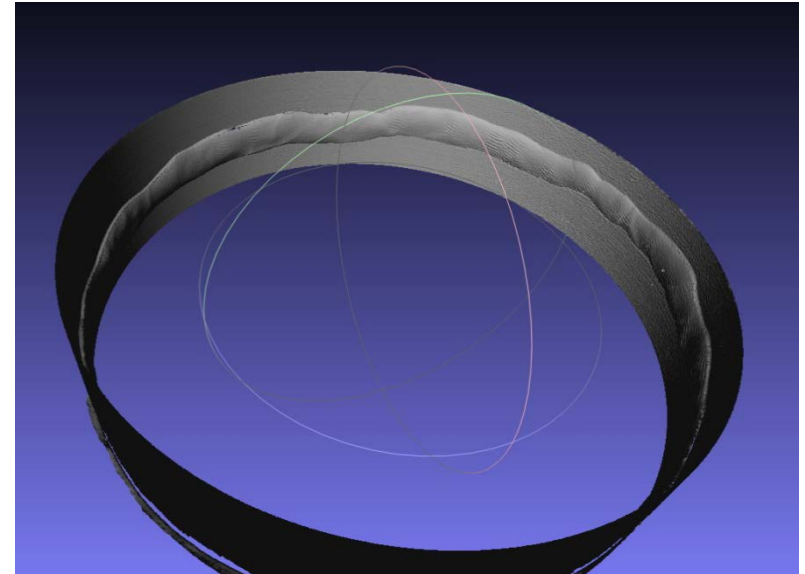
The gage is developed for inner surface inspection and ID measurement of nuclear Power station pipes

ID measurement by laser Scanning. APPLICATIONS

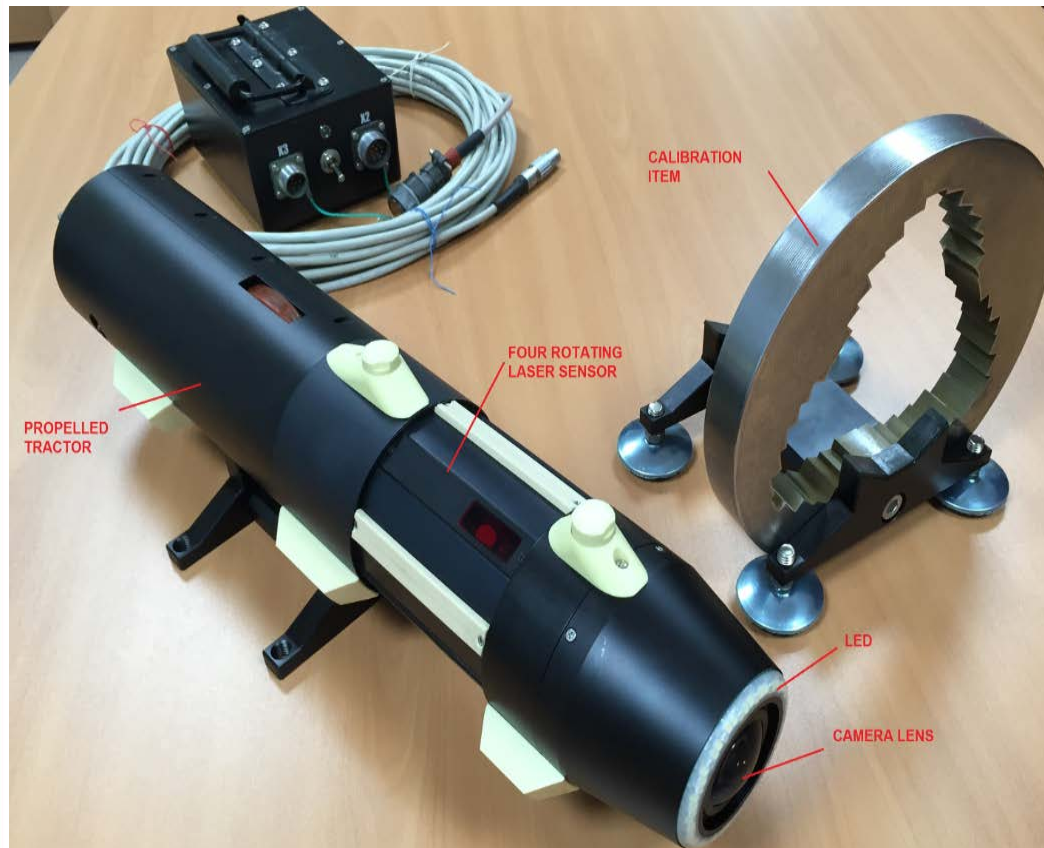
Rotating lasers system. How it works



<https://youtu.be/c8q88ZQ5S5Y>



Rotating lasers system for rifled gun barrels control



- Four rotating laser sensors inside
- Diameters: 57, 81, 90, 105, 120 mm
- Accuracy $\pm 2 \mu\text{m}$
- Barrels straightness measurement option
- Video camera option
- Wi-Fi connection
- Self-propelled translation module

Rotating lasers system for rifled gun barrels control



16

Rotating lasers system for pipes diameter control



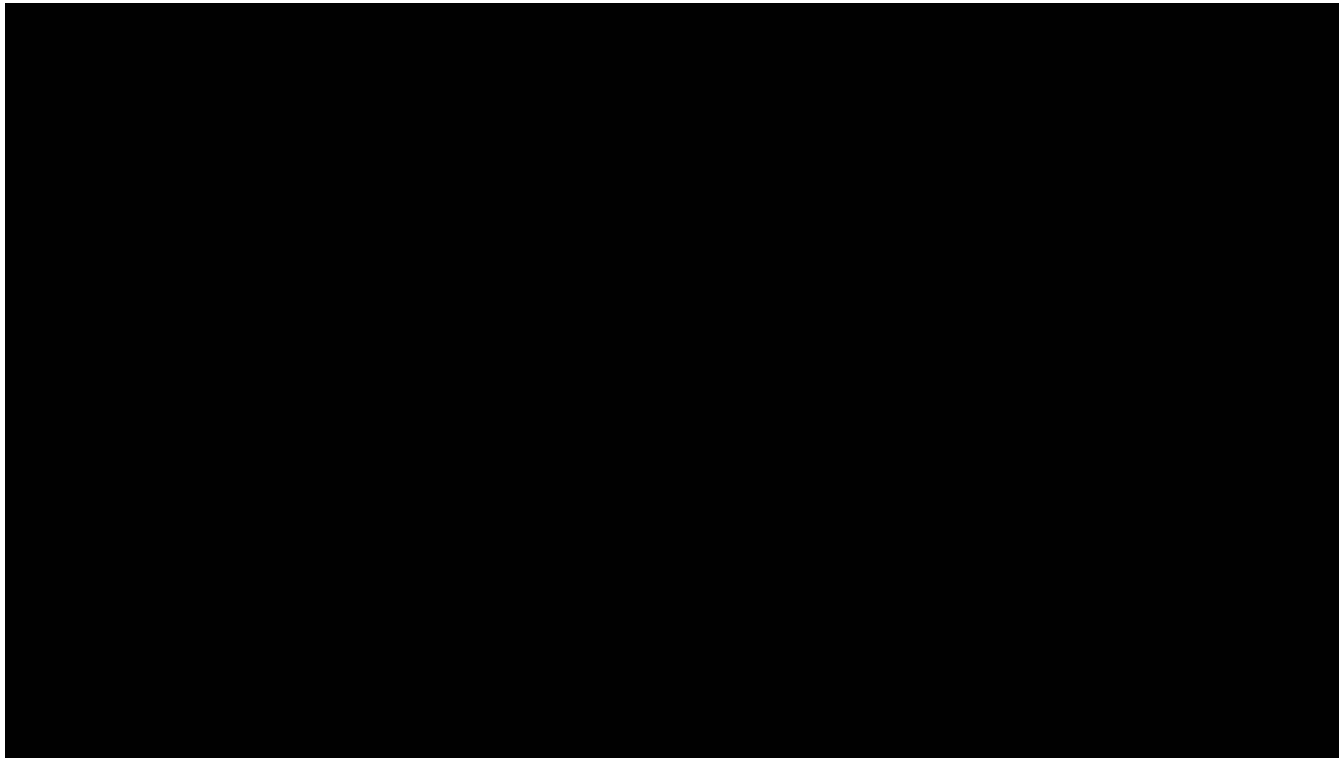
- Diameter range: 45...55 mm
- ID accuracy measurement : $\pm 5 \mu\text{m}$

Rotating lasers system for cylinders diameter control



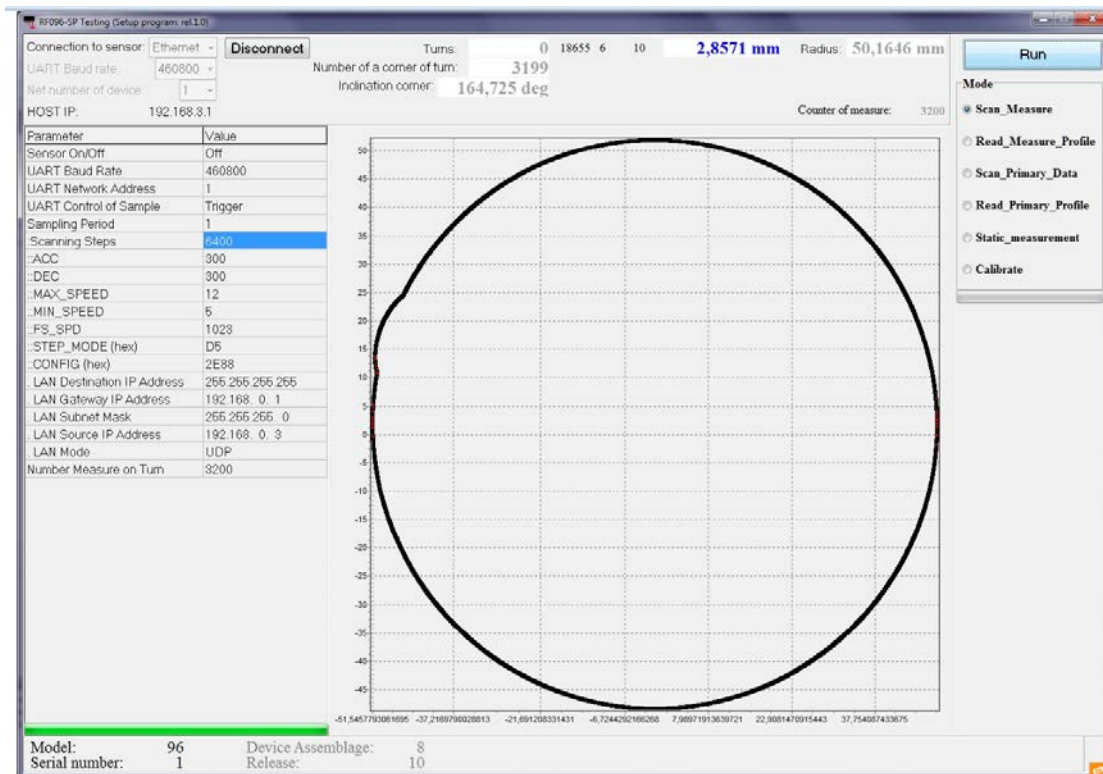
- Nominal diameter: 185 mm
- ID accuracy measurement : $\pm 5 \mu\text{m}$

**VIDEO: Rotating lasers systems for
cylinders diameter control.
Measurement module is placed
on linear translation stage**

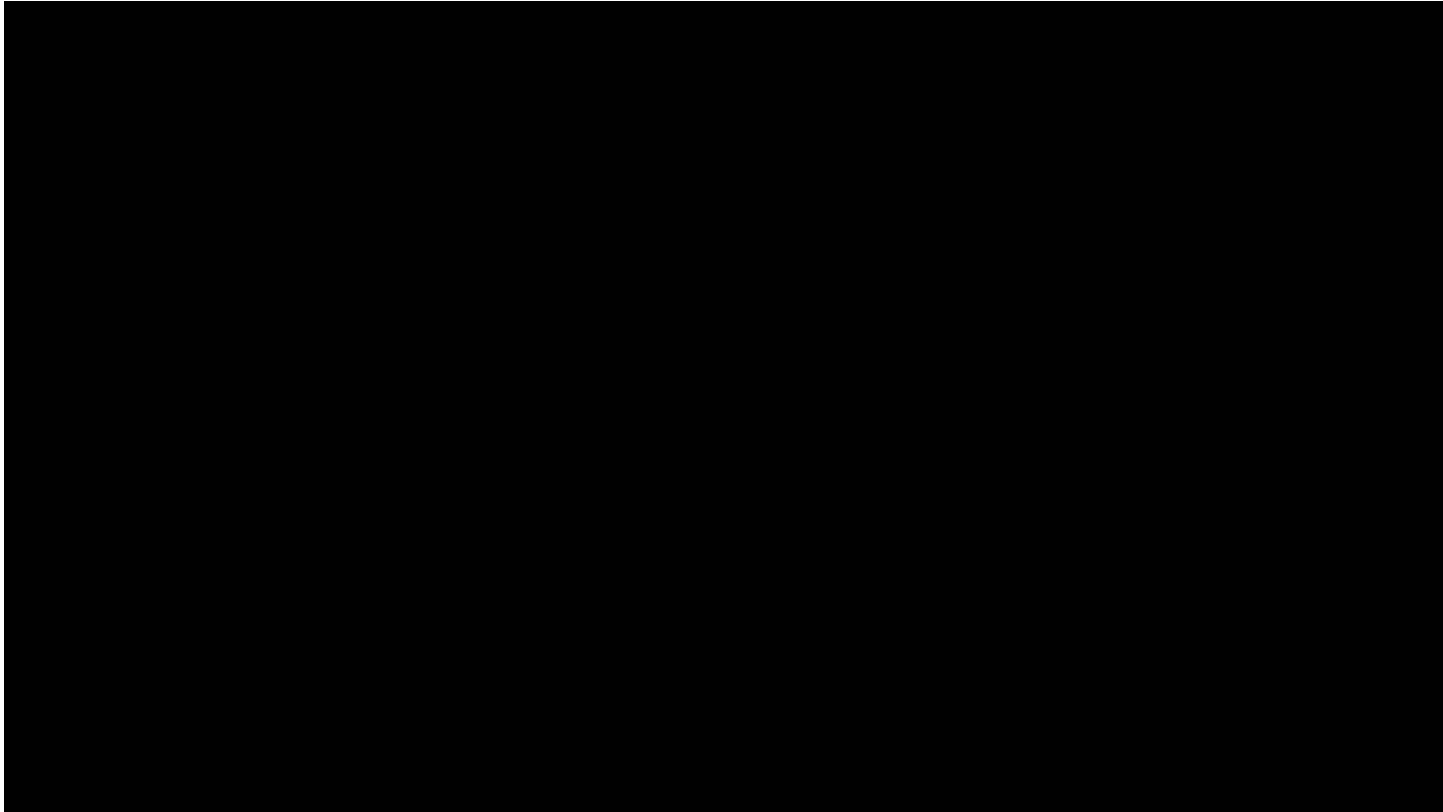


Rotating lasers systems for cylinders diameter control

Results: Diameter of the pipe with defect



Pipe ID Measurement Machine



21

Laser ID scanning module



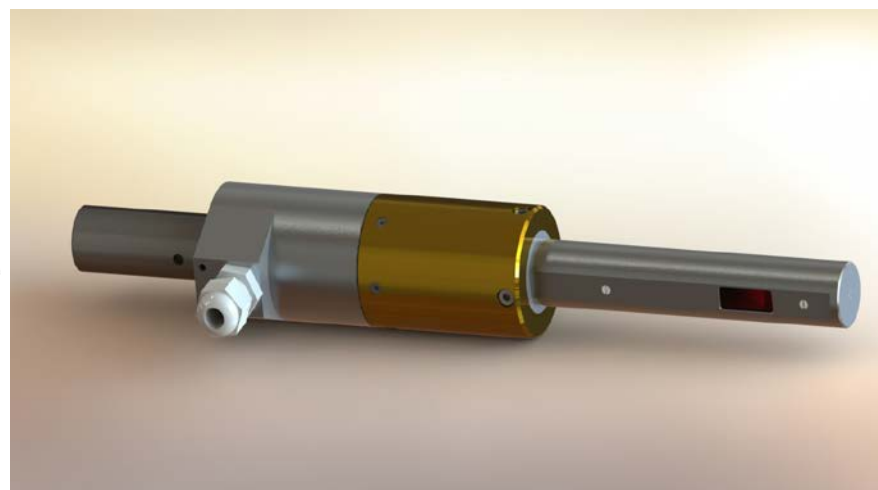
- Diameter of the sensor – 9 mm
- Measurement range – 5 mm (9...19 mm diameter)
- ID accuracy measurement $\pm 5 \mu\text{m}$

Laser ID scanning module



23

Laser ID scanning module for CNC machines



- Diameter of the sensor – 15 mm
- Measurement range – 20 mm
- ID accuracy measurement $\pm 5 \mu\text{m}$

24

Laser ID scanning module for CNC machines

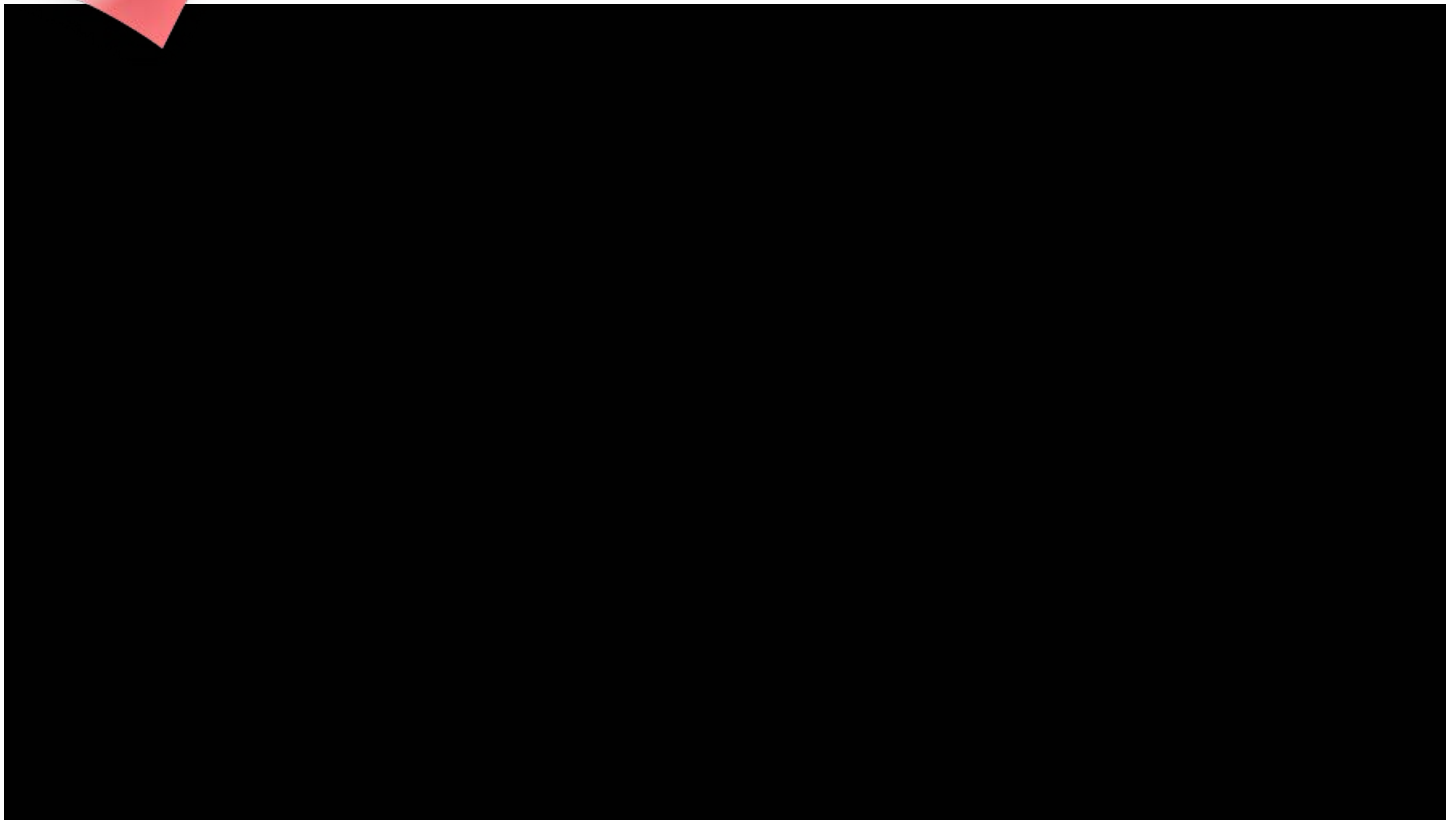


25

NEW

2017

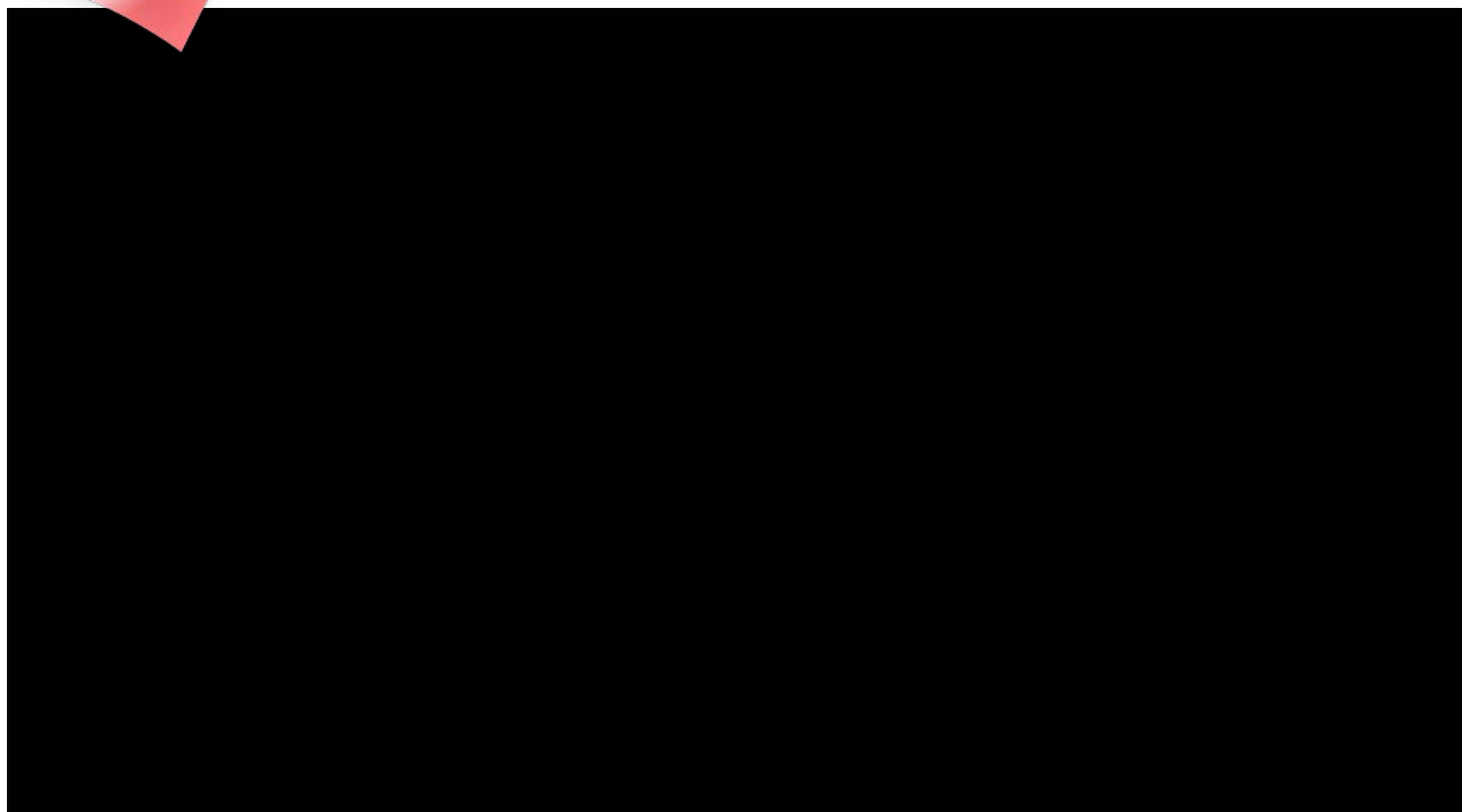
AUTOMATED SYSTEM FOR LAMINATED TUBES GEOMETRY MEASUREMENT



26

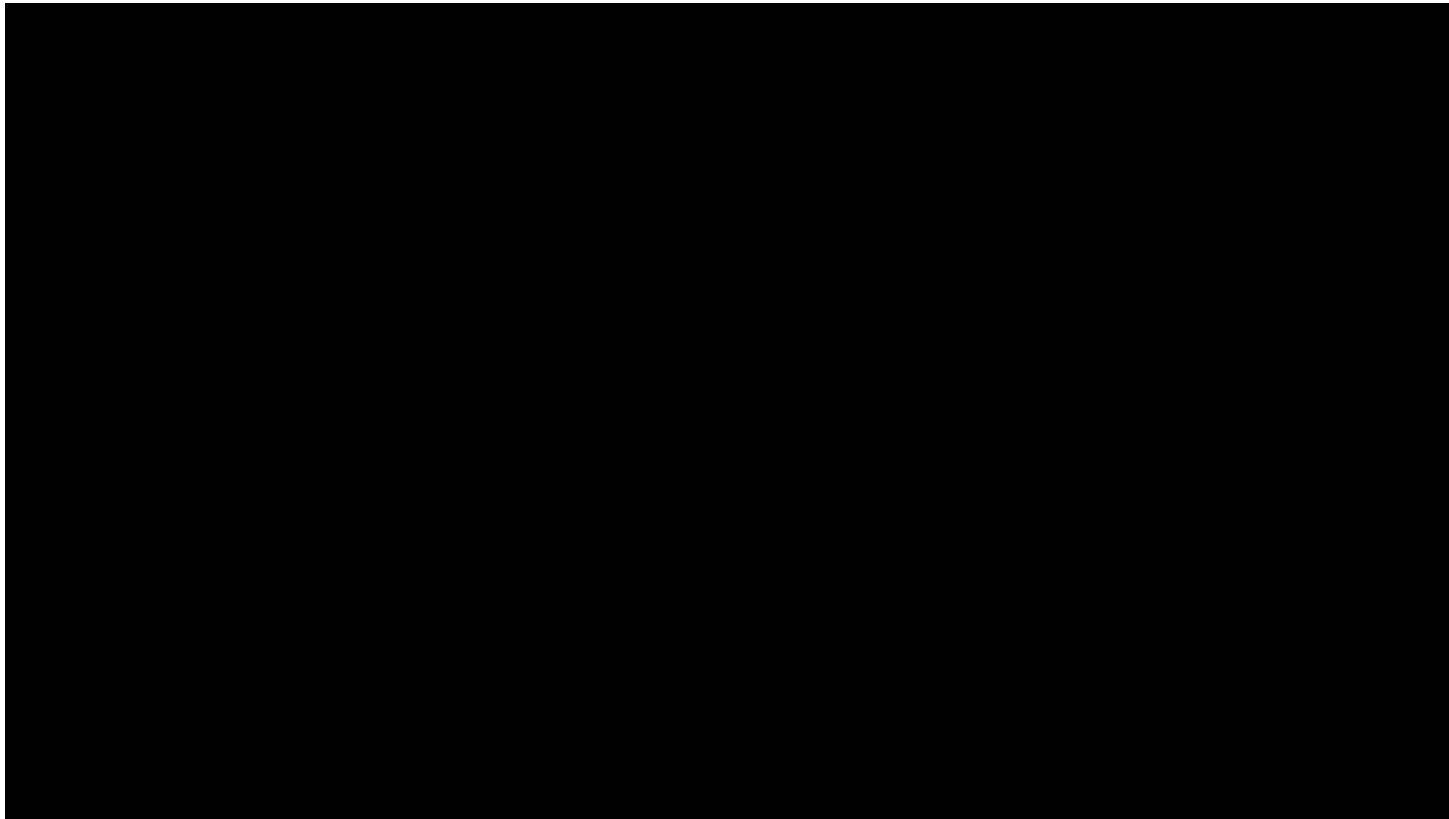
NEW
2017

LEAF SPRINGS HOLES ID MEASUREMENT MACHINE



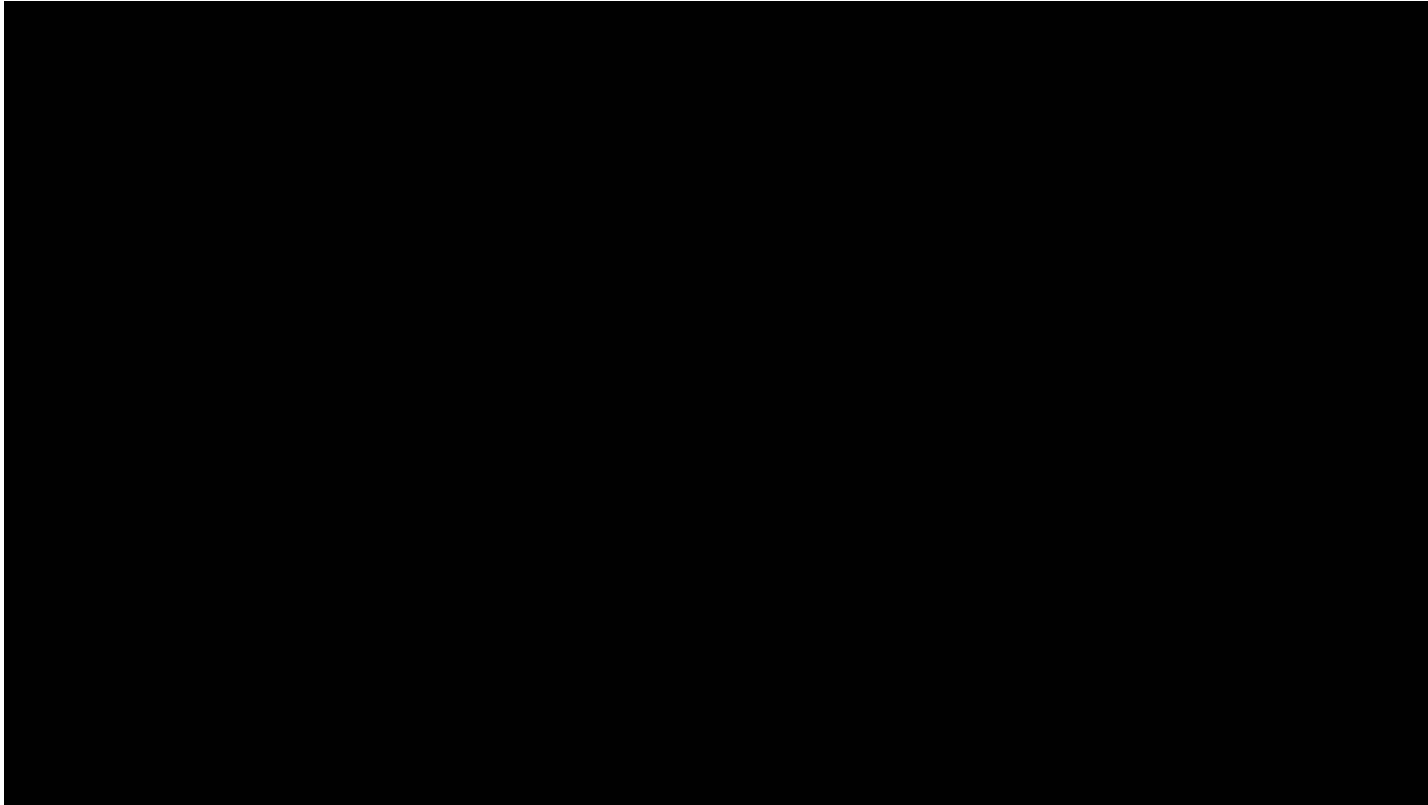
27

Laser Inspection System. RF096-Insp



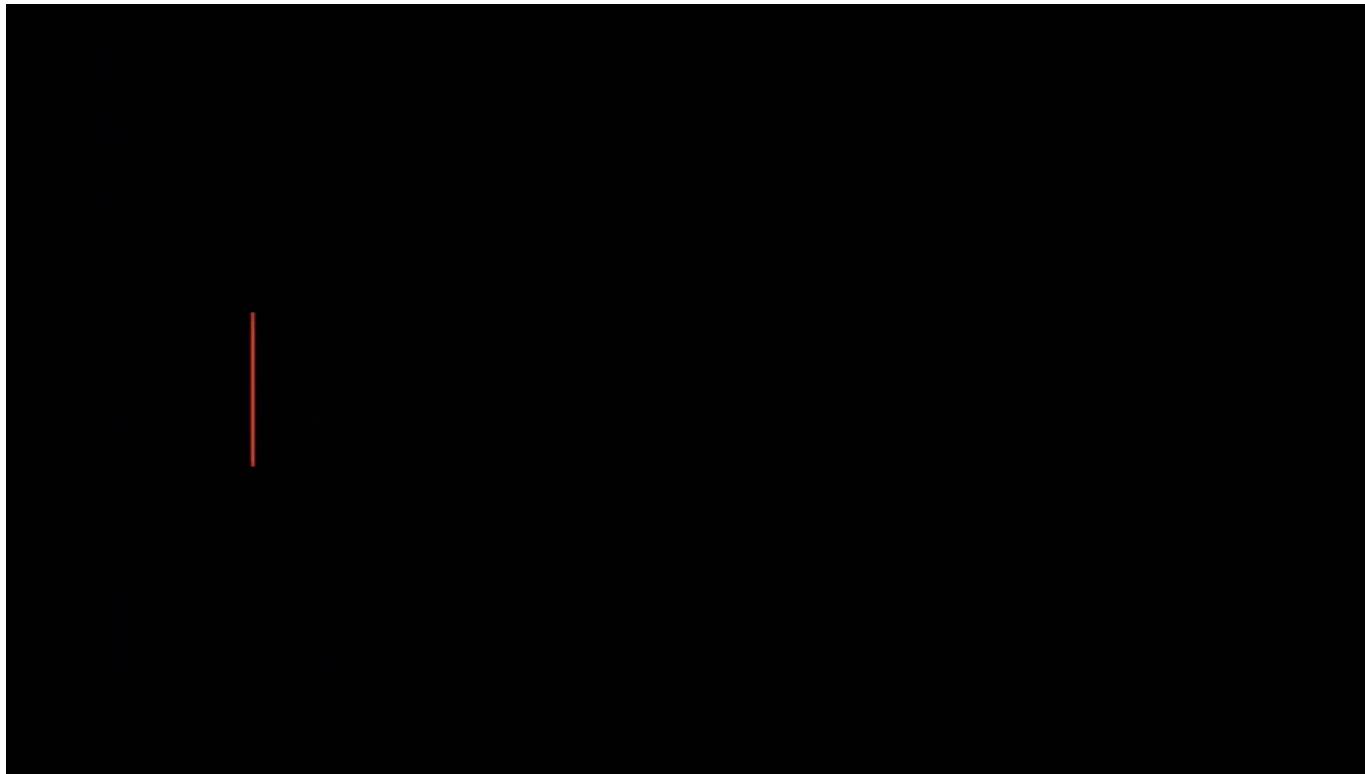
28

The system for measurement of ID and OD high temperature pipes



29

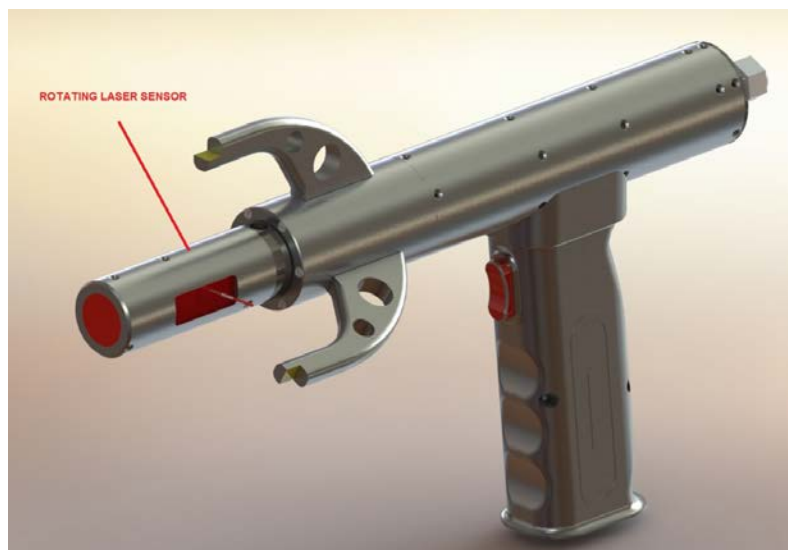
Laser measurement (by rotating triangulation sensors) of ID and OD of large diameter pipes



30

ID measurement: Projects

Hand-held ID measurement gauge



- From 2017

Hand-held ID Measurement Gauge Model RF096-200/600-HH (prototype tests)

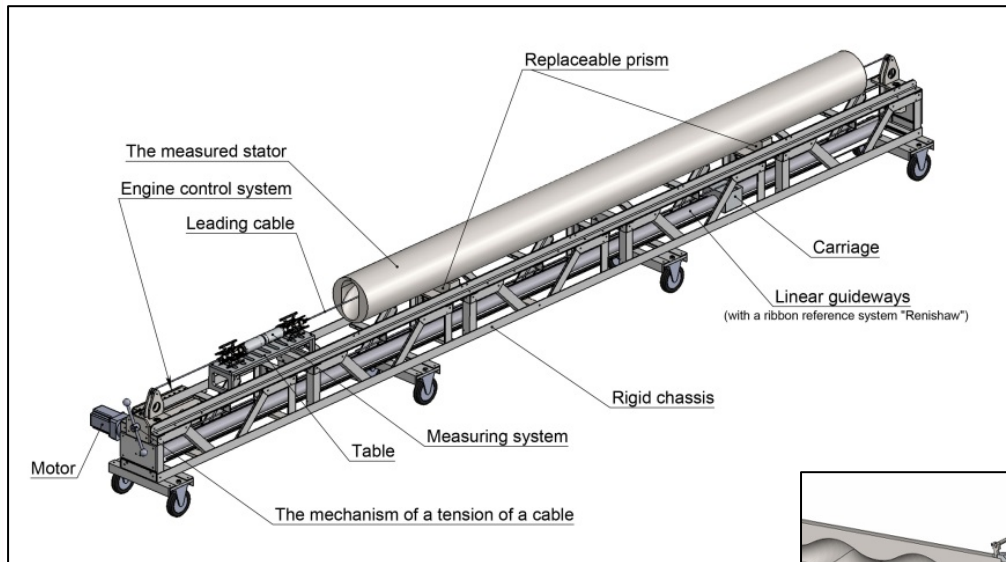


Basic specification:

| | |
|--------------------------|------------|
| Measured ID range, mm | 200...600 |
| Accuracy, mm | ±0.1 |
| Depth of measurement, mm | on request |
| Measurement time, s | 2 |
| Sensors laser power, mW | 1 |
| Laser Class | 2 |

<https://youtu.be/1BKwPpssy7U>

Laser Systems for Inner Surface Scanning



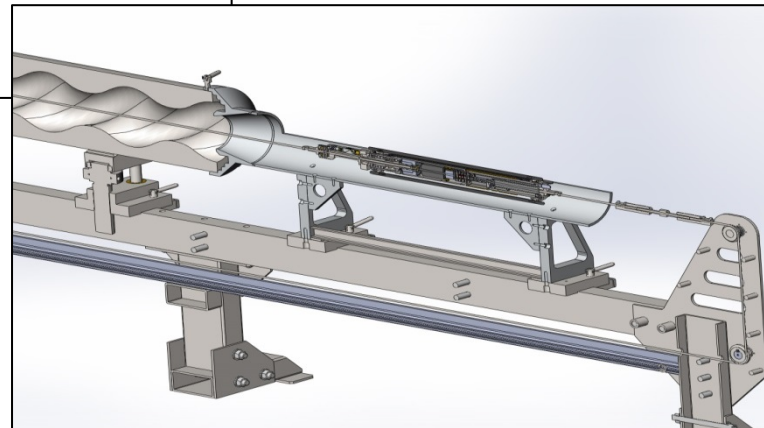
Designed use: Progressive cavity stators, tubes and pipes, gun barrel bore (rifled and smooth)

ID range: 10...300 mm

Accuracy: from $\pm 2\mu\text{m}$

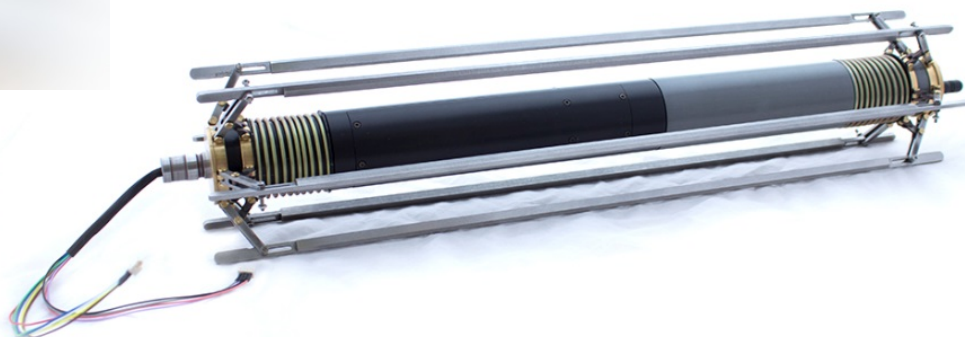
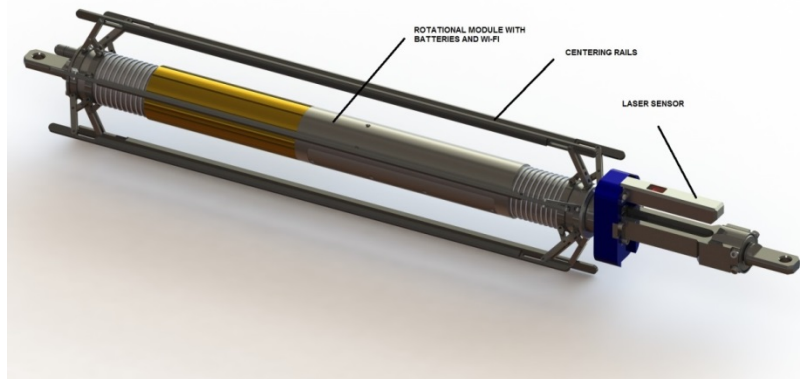
Angle resolution: 4 arcminutes

Linear resolution: 20 μm



■ From 2017

Laser Scanning Modules



34

**THANK YOU
FOR YOUR ATTENTION!**

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