

YOUR STABLE PARTNER FOR MANUFACTURING. **MARSTAND.**



The latest information on MARSTAND products can be found on our website:

www.mahr.com, WebCode 210

► | MarStand Indicator Stands, Comparator Stands and Run out Testing Instruments offer high stability which ensures precise measurements. Whether you are using a dial indicator, a dial comparator, a test indicator or a measuring probe you will always have the best possible support. ◀

► | MarStand. Indicator Stands, Comparator Stands, Run out Testing Instruments

Indicator Stands

MarStand 815 GN

8- 2

With Cast Iron Base

MarStand 2400

8- 2

For Electronic Measurements

MarStand 815 MA / 815 MB / 815 MG / 815 P

8- 3

With Magnetic Base

Post & Support Arm Assemblies

MarStand 815 XN / 815 XMA / 815 XMB / 815 XMS / 815 XMG / 815 XP

8- 7

With Mounting Thread and / or T-slot

Magnetic Bases

MarStand 815 Y / 815 YP

8- 7

Center Bench

MarStand 818

8- 8

With moveable Tail Stocks and Support Arms

Comparator Stands

MarStand 820 N / 820 NC / 820 FC / 820 NG / 820 FG 35 B / NB-60

8-10

Small Version

MarStand 821 NG / 821 FG

8-14

Large Version

MarStand 824 NT / 824 FT / 824 GT

8-15

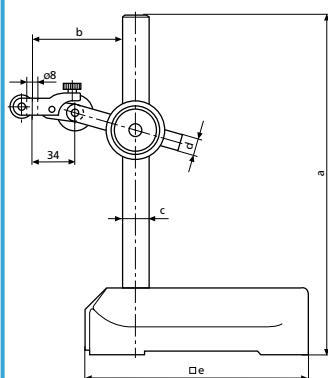
Heavy Version

Modular Units

MarStand 827 b

8-15

Indicator Stand 815 GN



Features

- Rugged base ensures both maximum stability and sturdiness
- The upper side of the base has a convenient hand grip
- Moves easily over surfaces without vibration
- Front of the base is ground to allow movement of the stand along edges and rules
- Stable due to the three point support
- Support arm can be finely adjusted
- Post and support arm are made from stainless steel
- Indicator can be rotated through $\pm 90^\circ$

Technical Data

Total height with base		Max. projection of support arm	Post dia.		Base surface	Fine adjustment range	Weight	Order no.* Mount dia. 8H7	Order no.* Mount dia. 3/8"
a			c	d					
mm	inch	mm	mm	mm	mm	mm	kg		
300	12"	185	18	14	150 x 150	2	4.2	4413000	4413050
500	20"	200	25	18	190 x 180	2	9	4413001	4413051
750	30"	230	35	25	190 x 180	2	10	4413005	4413052

* excludes indicating instrument

Indicator Stand 2400



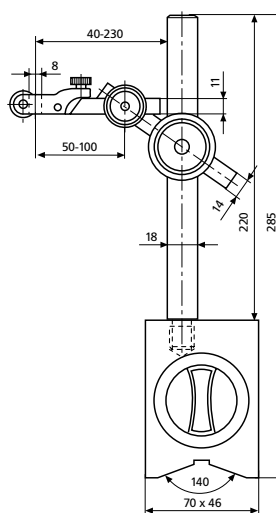
Features

- A stable Height Stand for electronic measurement,
- Fine adjustment in the base allows easy operator set-up, even at high magnification. Up to 3.8 mm / .150" adjustment when arms fully extended
- Collar has Teflon bearings and metal-to-metal clamping.
- Post is thermally isolated from heat transfer from the base.
- Arm lock is independent of the pivot lock.
- Uses vertical lug mounting
- EHE-2056 Lever gage head mounts directly to arm (as shown) EHE-2048 Lever gage head requires an EAM-1071 adaptor
- CP-83 Extra arm and swivel clamp assembly (allows mounting two lever gage heads on one stand)

Technical Data

Total height with base			Arm reach		Post dia. force		Base surface		Fine adjustment range		Order no.*
mm	/	inch	mm	/	mm	/	mm	/	mm	/	
457	/	18"	254	/	31.8	/	161.7 x 94	/	3.8	/	2400

* excludes indicating instrument

Indicator Stand 815 MA with magnetic base**Features**

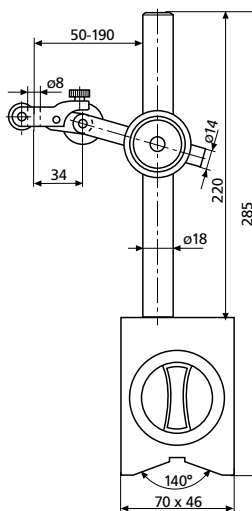
- Support arm with two joints
- Base has a powerful ON/OFF permanent magnet
- Magnetic force is active across the surfaces and the V-shaped bottom plus the front of the base
- Post and support arm are made from stainless steel
- Support arm can be finely adjusted

Technical Data

Total height with base		V-way for shaft dia.	Magnetic force	Fine adjustment range	Weight	Order no.*	Order no.*	Order no. wooden case
mm	inch					Mount dia. 8H7	Mount dia. 3/8"	
285	11.2"	20 - 100	450	2	2.5	4416000	4416050	4416001

* excludes indicating instrument

Indicator Stand 815 MB with magnetic base



Features

- Support arm with one joint
- Base has a powerful ON/OFF permanent magnet
- Magnetic force is active across the surfaces and the V-shaped bottom plus the front of the base
- Post and support arm are made from stainless steel
- Support arm can be finely adjusted
- Indicating instrument can be rotated through $\pm 90^\circ$

Technical Data

Total height with base		V-way for shaft dia.	Magnetic force	Fine adjustment range	Weight	Order no.*	Order no.*	Order no. wooden case.
mm	inch					Mount dia. 8H7	Mount dia. 3/8"	
285	11.2"	20 - 100	450	2	2.2	4417000	4417050	4416001

* excludes indicating instrument

Indicator Stand 815 MG with magnetic base



Features

- 3D indicator Stand, can reach any position within the operating range
- Easy to position all 3 joints, position can be securely fixed with a handle
- Robust well dimensioned components, excellent stability and accuracy
- Maintenance free mechanical clamping system
- Arm components are made of black anodized high quality aluminum
- Dial Indicator holder with mount dia. 8 mm and dovetail for Test Indicators
- Equipped with micro fine adjustment, free of backlash
- Outstandingly easy to set-up, high repeatability
- Very powerful ON/OFF magnet
- Ideal for measuring instruments with μm -resolution (only with 4420380)

Technical Data

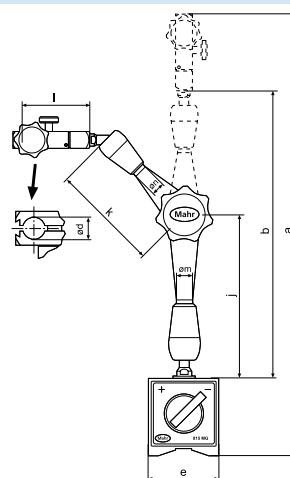
Total height with base	Projection (max.)	V-way for shaft dia.	Magnetic force	Mounting bore	Fine adjustment range	Weight	Order no.*
mm <i>inch</i>	mm	mm	N		mm	kg	
224 8.82"	130		300			1.6	4420350
316 12.44"	200					1.7	4420360
401 15.78"	280	6 – 120	800	8H7	2	1.8	4420370
444 17.48"	330		1000		5	1.9	4420380

* excludes indicating instrument

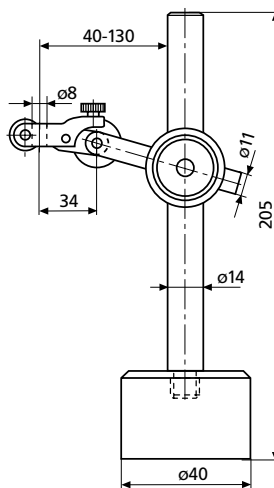
Dimensions

Dimensions in mm

a	b	d	e	j	k	l	m	Order no.
224	130	8	34 x 34	70	60	62	9	4420350
316	200	8	60 x 50	120	80	64	10	4420360
401	280	8	60 x 50	170	110	66	16	4420370
444	330	8	73 x 50	201	129	67	21	4420380



Indicator Stand 815 P with magnetic base



Features

- Support arm has one joint
- Sturdy circular base with permanent magnet
- Post and support arm are made from stainless steel
- Support arm can be finely adjusted
- Indicating instrument can be rotated through $\pm 90^\circ$

Technical Data

Total height with base		Magnetic force	Fine adjustment range	Weight	Order no.* Mount dia. 8H7	Order no.* Mount dia. 3/8"
mm	inch					
205	8"	250	1.5	0.7	4422000	4422050

* excludes indicating instrument

Post and Support Assemblies 815 X

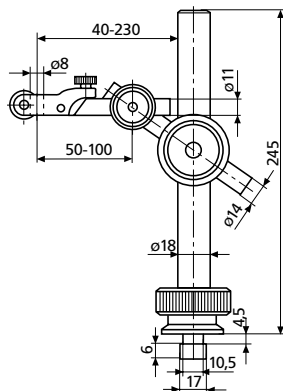
For application in inspection equipment for conducting length and concentricity (run-out) tests

815 XN

for mounting in a T-slot

- Two joints
- Knurled nut for clamping to the post
- Post and support arm are made from stainless steel
- With fine adjustment

Order no. 4424000

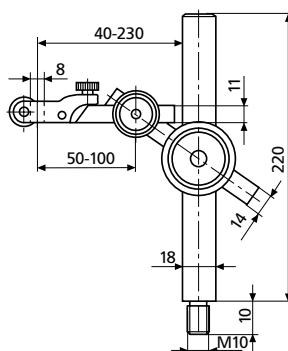


815 XMA

with mounting thread

- Two joints
- Post and support arm are made from stainless steel
- With fine adjustment

Order no. 4424005

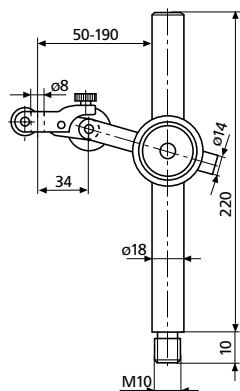


815 XMB

with mounting thread

- One joint
- Post and support arm are made from stainless steel
- With fine adjustment

Order no. 4424006



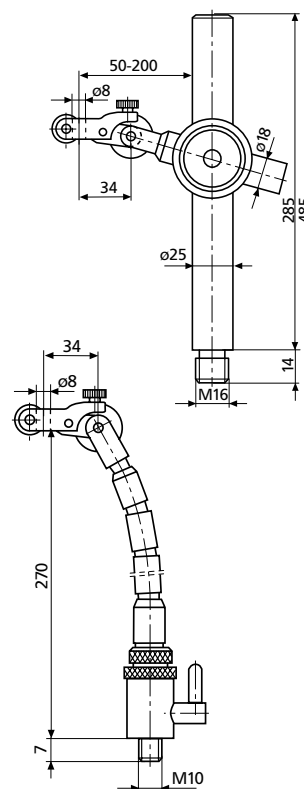
815 XMS

especially stable version with
mounting thread

- One joint
- Post and support arm are made from stainless steel
- With fine adjustment

Post height	Order no.
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285 mm
485 mm

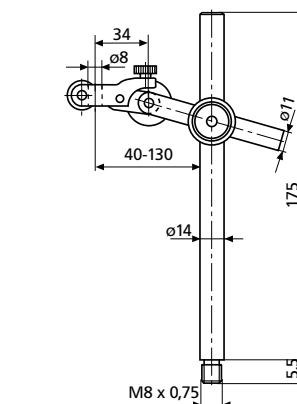


815 XMG

with mounting thread

- Flexible in any direction, arm can be locked in position
- With fine adjustment

Order no. 4424010



815 XP

with mounting thread

- One joint
- Post and support arm are made from stainless steel
- With fine adjustment

Order no. 4424015

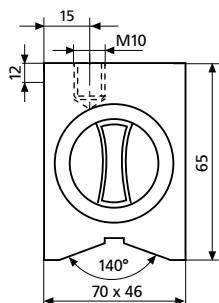
Magnetic Bases 815 Y

For the setting up of inspection equipment or as a base for adjusting devices on machine tools.

815 YM Standard Version

- Base has a powerful ON/OFF permanent magnet
- With threaded mounting hole
- V-groove in base
- Front is flat
- Magnetic force 450 N

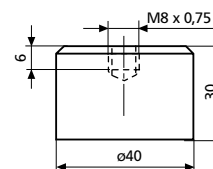
Order no. 4425000



815 YP Round Version

- Permanent magnet plus threaded mounting hole
- Underside of the base is flat
- Magnetic force 250 N

Order no. 4425002



Center Bench 818



Features

- Ideal for quick and accurate concentricity / run-out checks

Bench:

- Flatness of the surface is in accordance to DIN 876/1
- Two T-slots for Tailstock and / or Support Arm

Tailstock:

- Both Tailstocks can be relocated (slide into position)
- The Tailstock on the right side has a retractable (spring actuated) precision aligned center
- The Tailstocks have a peak height of 75 mm with a 90° prism for workpieces without a center, to a diameter of 20 mm (.79")

Support Arm 818 XNB:

- Support arm with one joint
- with fine adjustment

Technical Data

Height of centers mm (inch)	Distance between centers mm (inch)	Base size (L x W) mm	Lateral and/or height difference of Tailstocks mm	T-slot width mm	Weight kg	Order no.*
50 (2")	0 - 200 (0-8")	350 x 110	0.01	10H7	8	4622200
75 (3")	0 - 350 (0-14")	500 x 110	0.01	10H7	12	4622201
100 (4")	0 - 450 (0-18")	700 x 180	0.01	12H7	35	4622202
150 (6")	0 - 450 (0-18")	700 x 180	0.01	12H7	38	4622203

* excludes indicating instrument

Center Bench 818 with V-support

V-support height mm	Base size (L x W) mm	T-slot width mm	Weight kg	Order no. (excludes indicating instrument)
70	350 x 110	10H7	6.5	4622260
70	500 x 110	10H7	9.5	4622261
120	700 x 180	12H7	30	4622262

Center Bench 818 with Roller support

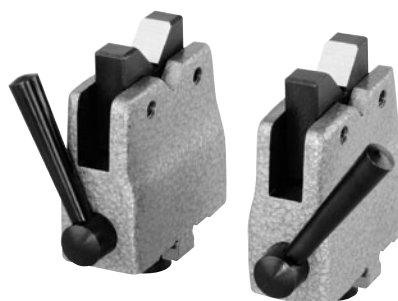
Roller support height mm	Base size (L x W) mm	T-slot width mm	Weight kg	Order no. (excludes indicating instrument)
70	350 x 110	10H7	6.5	4622250
70	500 x 110	10H7	9.5	4622251
120	700 x 180	12H7	30	4622252

Modular Units 818 for individual center benches**Accessories****V-support anvils 818 pe** in pairs

Center height mm	Dia. range mm	Order no.
50 / 75	3 - 15	4622210
100	8 - 45	4622211

818 pe**818 ab****V-support 818 pb** in pairs

Height * mm	Dia. range mm	T-slot width mm	Order no.
65	5 - 20	10	4622215
100	5 - 45	12	4622216

818 pb**Roller support 818 ab** in pairs

Height * mm	Dia. range mm	T-slot width mm	Order no.
65	3 - 20	10	4622220
100	3 - 45	12	4622221

* referred to the center of shaft with dia. 10 mm

Supporting table

Center height mm	Base size (L x W) mm	Order no.
50	350 x 110	4622265
75	500 x 110	4622266
100 / 150	700 x 180	4622267

Pointed support in pairs

Center height mm	Order no.
50	4622270
75	4622271
100	4622272
150	4622273

Support arm 818 XNB

Center height Dia. mm	Support Arm Length mm	mm	Order no.
50 / 75	18	210	4622275
100	18	260	4622276
150	18	360	4622277

Small Comparator Stands 820

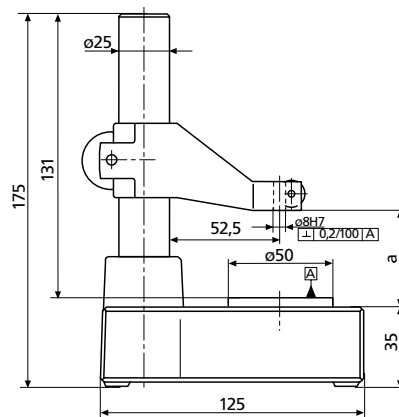
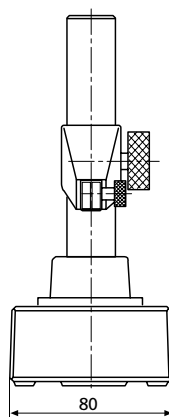
820 N



Indicating instruments are sold separately

Features

- Sturdy design
- Plate is made from either hardened steel or black granite or ceramic
- Rugged ground post made of stainless steel
- Fine adjustment, consisting of a strong, rigid parallel spring assembly (Small Comparator Stands 820 FG and 820 FC)
- Adjustable support arm for a indicating instrument



820 N

Technical Data

	Working range a		Flatness tolerance (DIN 876)	Fine adjustment range	Weight	Order no.* Mount dia. 8H7	Order no.* Mount dia. 3/8 inch	Remarks
	mm	(inch)	mm		kg			
820 N	0 - 110	(0 - 4.3")	steel	00	2.6	4430000	4430018	
820 NG	0 - 130	(0 - 5.1")	granite	0	3.2	4430100	4430110	
820 FG	0 - 130	(0 - 5.1")	granite	± 0.2	3.2	4431100	4431110	fine adjustment
820 NC	0 - 110	(0 - 4.3")	ceramic	00	4.0	4432100	4432120	
820 FC	0 - 110	(0 - 4.3")	ceramic	± 0.2	4.0	4433100	4433110	fine adjustment

* excludes indicating instrument

Small Comparator Stands 820

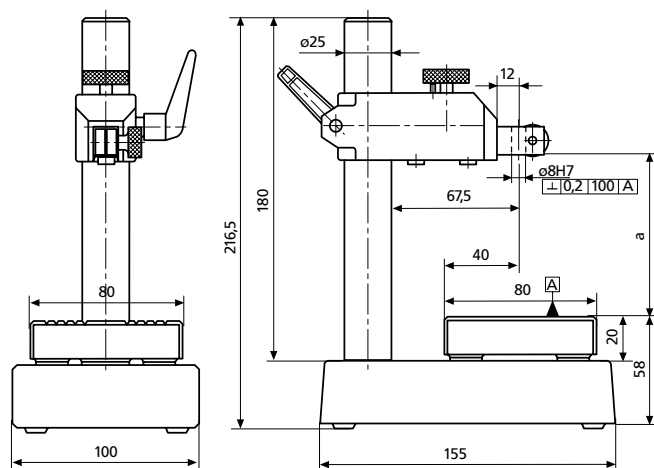
820 FC / 820 NC



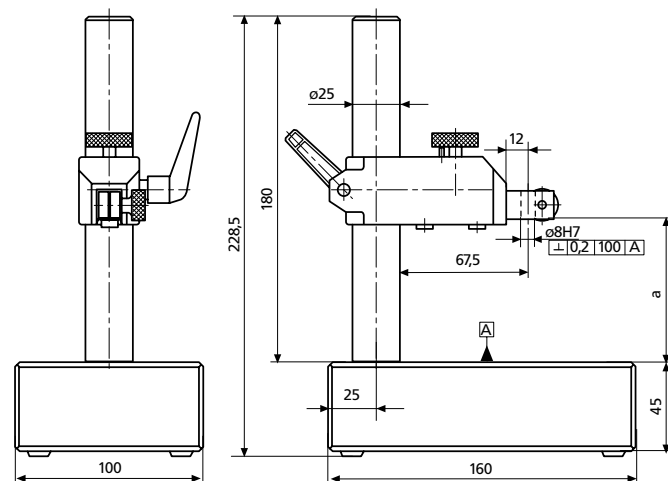
820 FG / 820 NG



820 FC / 820 NC



820 FG / 820 NG



Accessories

V-Block 108° for checking small, cylindrical work pieces for out of roundness and polygon errors (for further details please refer to Page 12-9)

107 V

(Single)
(Pair)

Order no.

4229000
4229001

Comparator Stands 35 B



Features

- Model 35B has a precision ground base. Indicator arms with and without fine adjustment are available. Models are also available with lapped anvils for the highest precision work.
- Alternate post lengths, Indicators, Anvils and special fixturing available upon request. Contact Mahr Federal Technical Assistance

Excludes indicating instrument. Only indicating instruments that have a horizontal lug back can be used.

Technical Data

Capacity	Post Diameter	Throat Depth	Reference Surface	Gaging Arm	Anvil	Order no. (w/o indicator)
0 - 8.75" 0 - 222 mm	1.25" 31.75 mm	2.5" 62.5 mm	1 x 3" 25 x 75 mm	adjustable AM-146 plain AM-3 adjustable AM-146 adjustable AM-146	plain none none serrated	OMI-35B-21 OMI-35B-30 OMI-35B-32 OMI-35B-41

Accessories

Replacement Anvils

- Anvils for Comparator Stands 35B-21 and 35B-41 are available: Surface is lapped flat to within .00001"

Type	Dimensions	Order no.
plain surface	25 x 25 x 75 mm (1 x 1 x 3")	AL-96
serrated surface	25 x 25 x 75 mm (1 x 1 x 3")	AL-97

Fine Adjustment Arm

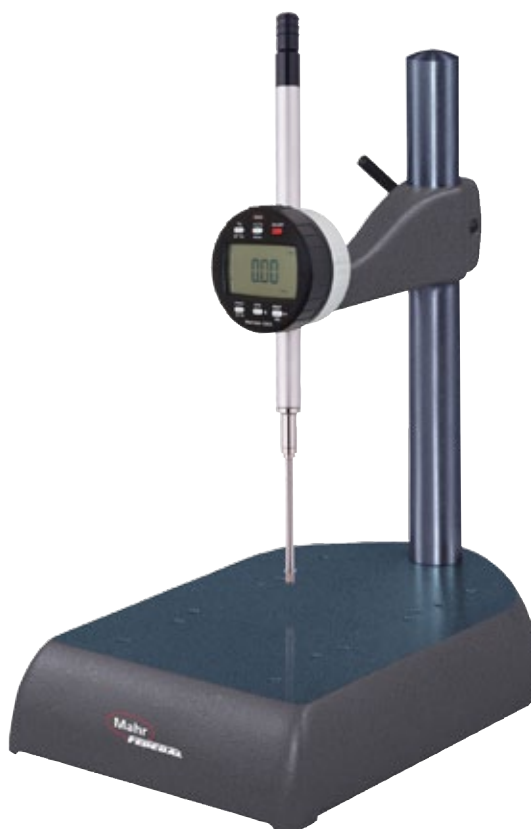
- The Fine Adjust Arm is available separately to convert 35B Comparator Stands with plain arms

Range	Order no.
1.5 mm / 0.060"	AM-146

Readout Specification: Because of the versatility of the Series 35B and NB-60 Stands, almost any type of readout can be used.

- With Dial or Digital Indicators having a horizontal lug back

Comparator Stand NB-60



Features

- Model NB-60 and NB-61 have the largest base and greatest throat depth. Indicator arms with and without fine adjust are available. Base has a pattern of 1/4-20 tapped holes for mounting platens or special tooling

Shown with optional 1086 indicating instrument. Only indicating instruments that have a horizontal lug back can be used.

Technical Data

Capacity	Post Diameter	Throat Depth	Reference Surface	Gaging Arm	Anvil	Order no. (w/o indicator)
0 - 8"	1.25"	4.88"	9.38 x 6.5"	plain AM-10011	none	OMI-NB-60
0 - 203 mm	31.75 mm	124 mm	238 x 165 mm	adjustable AM-147	none	OMI-NB-61

Accessories

Platens

Type	Dimensions	Order no.
serrated	114 x 152 mm (4.5 x 6")	PL-99
serrated	152 x 203 mm (6 x 8")	PL-147

Note: (4) screws SW-1338 are required

Fine Adjustment Arm

- The Fine Adjustment Arm is available separately to convert NB-60 Comparator Stands with plain arms

Range	Order no.
1.5 mm / 0.060"	AM-147

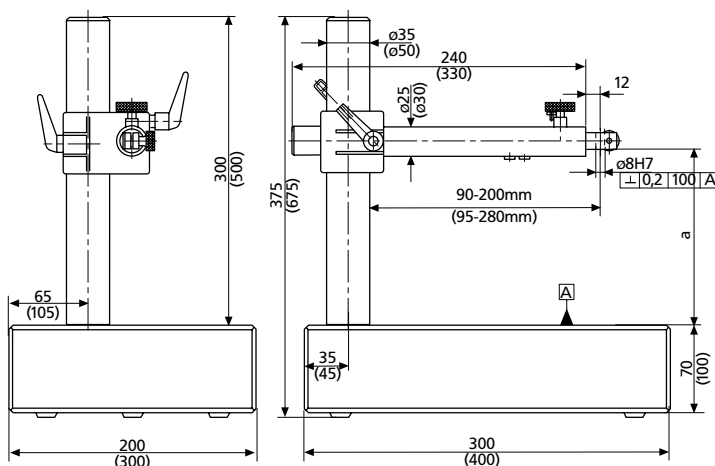
Readout Specification: Because of the versatility of the Series 35B and NB-60 Stands, almost any type of readout can be used.

- With Air Probes or Electronic Probes having a 3/8 in dia., order Mounting Adapter **AAD-66**

Large Comparator Stands 821

Features

- Extremely sturdy design
- Plate is made from lapped black granite
- Heavy duty post and adjustable support arm for maximum stability
- Post made from stainless steel and precision ground
- Support arm has a fall brake
- Fine adjustment, consisting of a strong, rigid parallel spring assembly (Large Comparator Stand 821FG)



821 FG

Technical Data

	Working range a		Flatness tolerance (DIN 876)	Fine adjustment range	Weight	Order no.* Mount dia. 8H7	Order no.* Mount dia. 3/8 inch	Remarks
	mm	(inch)	Grade	mm	kg			
821 NG	0 - 250	(0 - 10")	0	—	15.8	4435100	4435150	
	0 - 430	(0 - 17")	0	—	48	4435110	4435160	
821 FG	0 - 250	(0 - 10")	0	± 0.2	15.8	4435101	4435151	Fine adjustment
	0 - 430	(0 - 17")	0	± 0.2	48	4435111	4435161	Fine adjustment

* excludes indicating instrument

Accessories

V-Block 108° for checking small, cylindrical work pieces for out of roundness and polygon errors (for further details please refer to Page 12-9)

Order no.

107 V	(Single)	4229000
	(Pair)	4229001

Heavy Comparator Stands 824



Precision Stand 824 NT

Without fine adjustment



Precision Stand 824 FT

With fine adjustment, consisting of a strong, rigid parallel spring assembly



Precision Stand 824 GT

For Large Type Millimess. With fine adjustment by way of vertical movement of the mounting socket

Features

Basic Units

- Sturdy, T-shaped base which is made from a special cast iron
- Extremely stable
- Fine adjustment, consisting of a strong, rigid parallel spring assembly
- Support arm has a rotation lock, height of the arm via the toothed rack is adjustable

Plates

- Measuring faces are hardened and lapped
- Longitudinal grooves
- Plates for sum measurements have a 8H7 mm mounting hole for Inductive Probes

Technical Data

Basic Unit

	Working range		Fine adjustment range	Weight	Order no.*	Order no.*	Order no.*
	mm	(inch)	mm	kg	Mount dia. 8H7	Mount dia. 28H7	Mount dia. 3/8 inch
824 NT	0 - 210	(0 - 8.2")	—	17	4442100		4442105
824 FT	0 - 210	(0 - 8.2")	± 0.2	19	4443100		4443105
824 GT	0 - 200	(0 - 8.0")	± 1.5	18		4444200	

* excludes indicating instrument, excludes plate

Plates

	Plate size			Flatness tolerance	Mounting hole	Weight	Order no.	Remarks
	mm			µm	mm	kg		
827 b 31	100	x	40	1		1.2	4082731	for single measurement
827 b 32	100	x	40	1	8H7	1.0	4082732	for sum measurement
827 b 33	130	x	130	1		2.5	4082733	for single measurement
827 b 34	130	x	130	1	8H7	2.5	4082734	for sum measurement

Accessories

V-Block 108° for checking small, cylindrical work pieces for out of roundness and polygon errors (for further details please refer to Page 12-9)

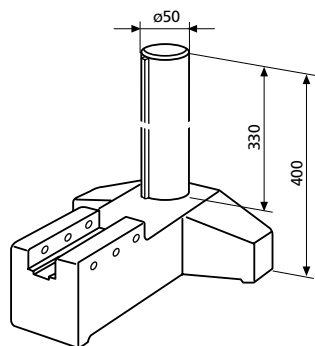
	Order no.
107 V	(Single) 4229000 (Pair) 4229001

Modular Units 827 for individual comparator stands

For the combination of comparator stands for special tasks, to adapt existing stands as well as the incorporation into inspection equipment for all types of length measurements.

Base with Post

827 b 5

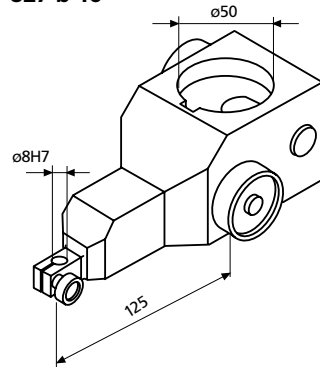


- T-shaped base which is made from a special cast iron
- Post has a chrome finish

Order no. 4082705

Support Arms

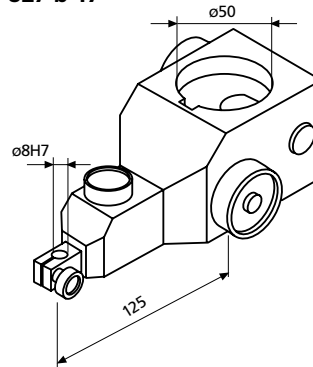
827 b 16



- Mounting hole 8 mm
- Without fine adjustment

Order no. 4082716

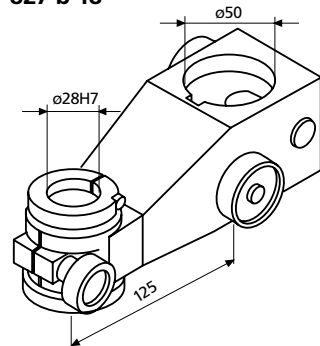
827 b 17



- Mounting hole 8 mm
- Fine adjustment, consisting of a strong, rigid parallel spring assembly

Order no. 4082717

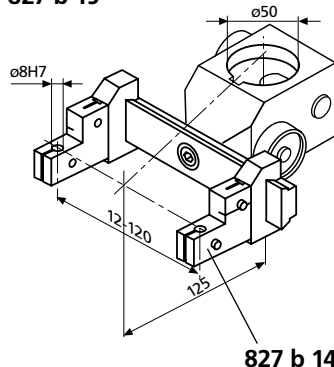
827 b 18



- Mounting hole 28 mm
- With fine adjustment

Order no. 4082718

827 b 19



- Support arm with dovetail guide

Order no. 4082719

827 b 14

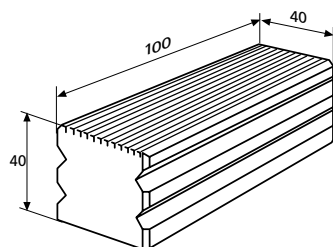
- With probe holder, mounting hole 8 mm

Order no. 4082714

Modular Units 827 for individual comparator stands

Plates

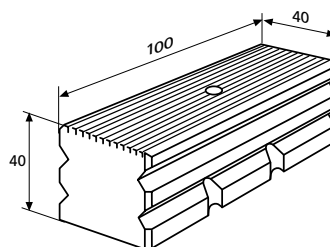
827 b 31



- For single measurement
- Hardened and lapped
- Reversible
- Measuring surface has longitudinal grooves
- Flatness deviation 1 μm

Order no. 4082731

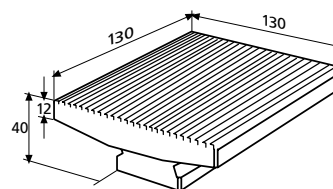
827 b 32



- For sum measurement
- Measuring surface has longitudinal grooves, hardened and lapped
- With mounting hole 8H7 mm/.375" and a clamp for inductive probes
- Flatness deviation 1 μm

Order no. 4082732

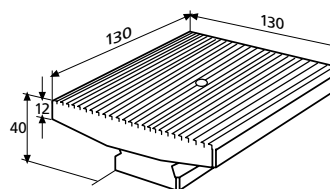
827 b 33



- For single measurement
- Large measuring surfaces which have longitudinal grooves, hardened and lapped
- Flatness deviation 1 μm

Order no. 4082733

827 b 34

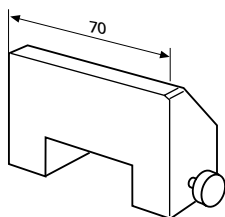


- For sum measurement
- Large measuring surfaces which have longitudinal grooves, hardened and lapped
- With mounting hole 8H7 mm/.375" and a clamp for inductive probes
- Flatness deviation 1 μm

Order no. 4082734

Adjustable Stop

827 b 35

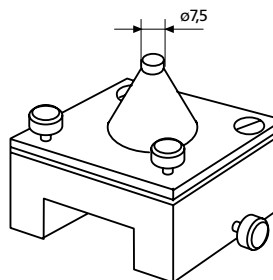


- Ensures that a work piece is correctly positioned
- To be attached to plates 827 b 31 and 827 b 32

Order no. 4082735

Attachment Stand

827 b 36



- With adjustment screws for parallel alignment of 2 plan surfaces
- Particularly suitable for mounting Pin Gages 426 M
- To be attached to plates 827 b 31 and 827 b 32

Order no. 4082736