RONDCOM NEX series
Measuring instruments for high-precision
form measurements

ACCRETECH | EUROPE

The RONDCOM NEX series NEW

Form measuring instruments with high level of modularity and efficiency

## Form, diameter and roughness measurements in a single system

→ 3-In-1 approach: one instrument for different applications for measuring roundness, diameter and roughness

With its diverse range of functions, the series fulfils a wide range of customer requirements and, in doing so, it does more than simply measure form.

→ Effectiveness-enhancing feature: detector for automatic measurement force adjustment

The automatic switching allows roundness and roughness to be measured in a single sequence. Workpieces no longer need to be clamped and measured in two separate machines.
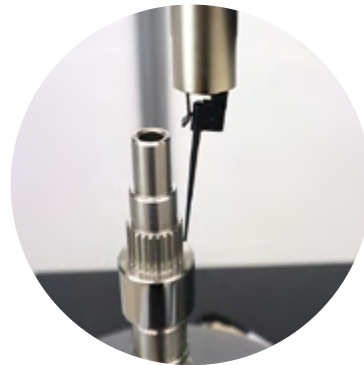
→ Large part batches can be measured simultaneously thanks to CNC-controlled measuring sequences in conjunction with an XY positioning table

The optional CNC positioning table minimises the operating effort and shortens the cycle time for the measurements. All RONDCOM NEX instruments can be retrofitted with this feature.

Choice of numerous features and variants for individual requirements

RONDCOM NEX 200 DX2-12

RONDCOM NEX Rs 200 DX2-12

RONDCOM NEX standard model

Model with additional surface roughness measurement RONDCOM NEX Rs

→   Max. workpiece weight: 30 kg

→   Max. measuring height: 300 / 500 mm

→   Alignment: manual / CNC

→   Probing direction of the detector: manual / CNC

→   SD2: standard version without table

→   DX2: with integrated anti-vibration table

→   System can be upgraded from manual to CNC-controlled system

→   Max. workpiece weight: 30 kg

→   Max. measuring height: 300 / 500 mm

→   Alignment: CNC

→   Probing direction of the detector: manual / CNC

→   SD2: standard version without table

→   DX2: with integrated anti-vibration table

→   Enables measurement of the surface parameters

**Optional column height 900 mm
RONDCOM NEX α 300 SD2-23**

**Optional column height 500 mm
RONDCOM NEX Rs α 200 SD2-22**

Model for heavy workpieces
RONDCOM NEX α

→ Max. workpiece weight: 60 kg

→ Max. measuring height: 300 / 500 / 900* mm

→ Alignment: manual / CNC

→ Probing direction of the detector: manual / CNC

→ SD2: standard version without table

→ DX2: with integrated anti-vibration table

Model for measuring surface quality and
## for heavy workpieces RONDCOM NEX Rs α

→ Max. workpiece weight: 60 kg

→ Max. measuring height: 300 / 500 / 900* mm

→ Alignment: CNC

→ Probing direction of the detector: manual / CNC

→ SD2: standard version without table

→ DX2: with integrated anti-vibration table

→ Enables measurement of the surface parameters

*Only valid for SD variant

Wide range of models and accessories for measuring different types of workpieces
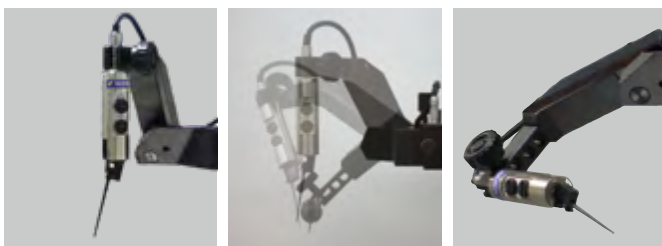
NEX | NEX Rs | NEX α | NEX Rs α
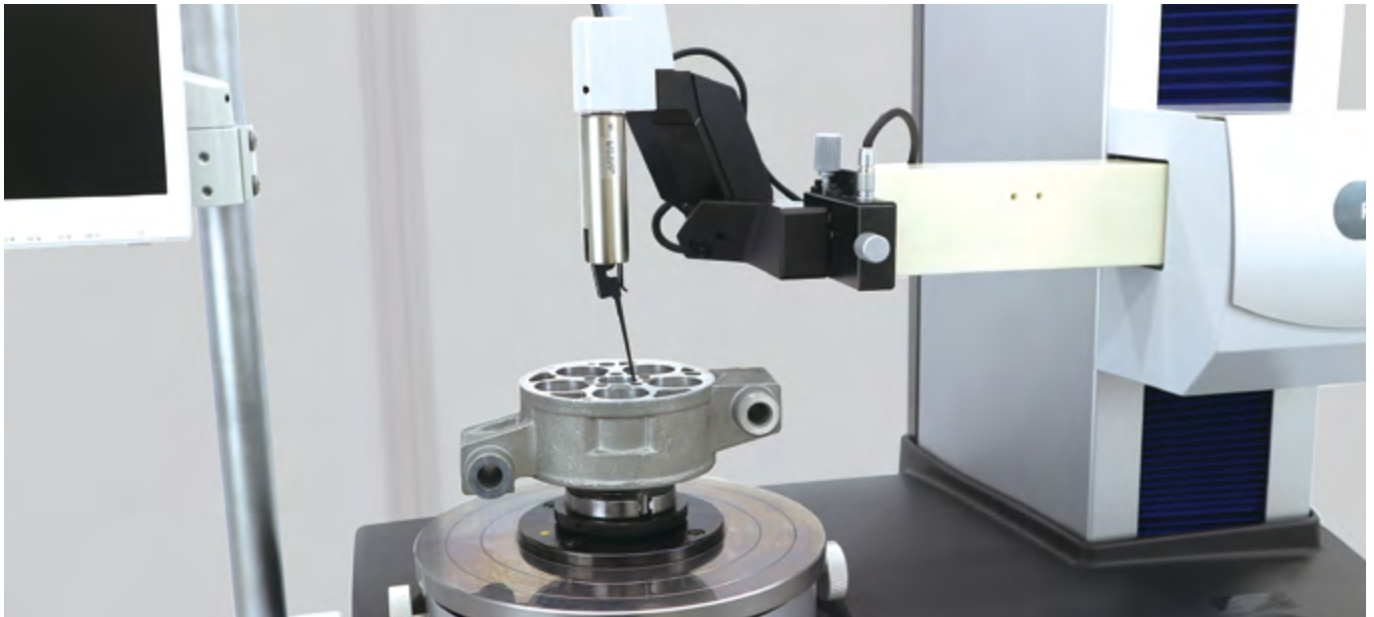
Offset detector holder enables measurements below the R-axis

The patented detector holder prevents possible collisions between the R-axis arm and large workpieces, as the probe measures 80 mm below the R-axis.
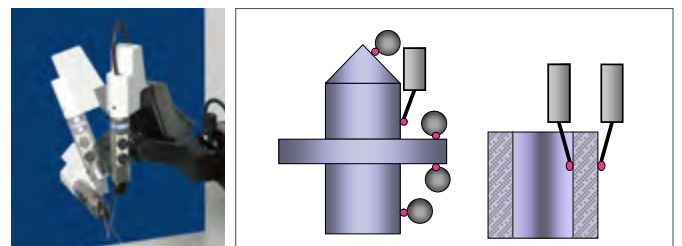
RONDCOM NEX 100/200 manual detector holder   Patented

If the offset detector holder is flipped, the detector automatically changes its alignment by 90 degrees.

RONDCOM NEX 300 CNC detector holder

The CNC program can automatically change position of the CNC detector holder in order to measure inner/outer diameter or upper/lower or conical surface.

For measuring heavy workpieces
Maximum workpiece weight: 60 kg

NEX α | NEX Rs α

The "α" series is equipped with a low-vibration air bearing table, which allows a maximum load of up to 60 kg while maintaining measurement accuracy.

For measuring long workpieces
Maximum measuring height: 900 mm

NEX α | NEX Rs α

In the "α" series, the customer can choose between a 300, 500 and 900 mm* Z-column depending on their requirements.

*Only valid for SD2. Optional anti-vibration table E-VS-R86B/87B required.

Offset detector holder for extending the maximum measuring diameter by φ 50 mm
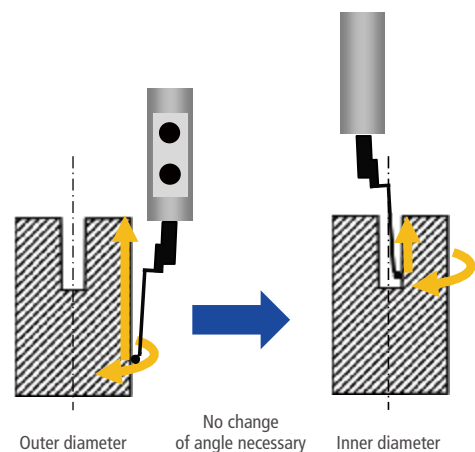
NEX | NEX Rs | NEX α | NEX Rs α

The detector holder is available as a special optional accessory. (Outer diameter φ 350 mm, inner diameter φ 410 mm)

* Offset detector holder
350 mm

Standard detector holder
300 mm
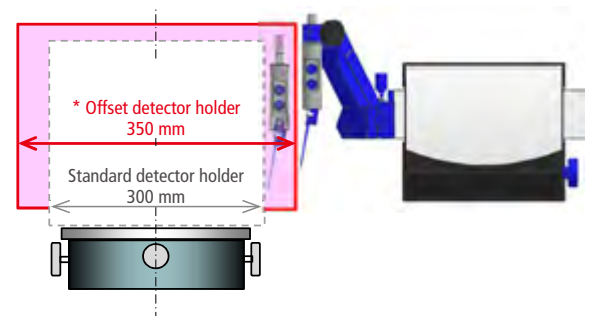
Versatile probe range   Patented

NEX | NEX Rs | NEX α | NEX Rs α

Thanks to the specially designed probe arm concept, the inner diameter of a hole can also be measured after an outer diameter measurement without the need to change the probe arm angle.

Outer diameter   No change of angle necessary   Inner diameter

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MULTIFUNCTIONAL

Various measuring functions that go beyond those of a conventional form measuring instrument
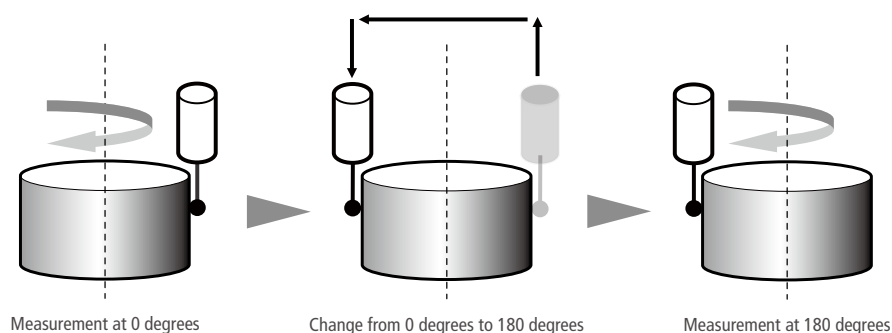
NEX | NEX Rs | NEX α | NEX Rs α
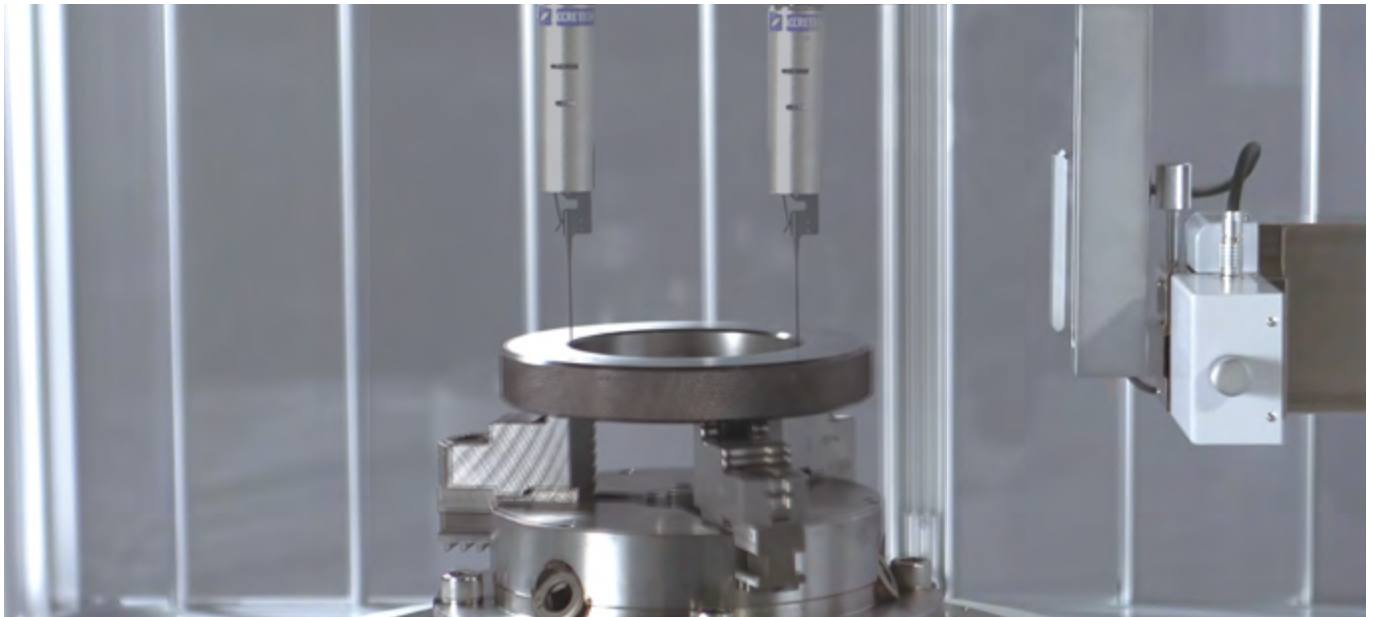
Measurement of inner and outer diameters with high level of repeatability

Function for measuring opposing diameters **Patented**

The standard integrated evaluation algorithm for correcting errors and measuring the opposite diameter means that measurement deviations due to temperature fluctuation are eliminated.

Measurable diameter
With standard holder: max. φ 30 mm. With holder for measuring the opposite diameter (optional): max. φ 100 mm

Measurement at 0 degrees   Change from 0 degrees to 180 degrees   Measurement at 180 degrees

Roughness measurement as per ISO standard

NEX Rs | NEX Rsα

The RONDCOM NEX RS series enables highly accurate roughness measurements through the use of special roughness detectors. In addition to the linear roughness measurements in the Z and R directions, it is also possible to measure the roughness parameters on the circumference of the workpiece. A rotary table with an air bearing is used, providing an extremely low noise floor. With the RS variant, roughness measurements in the high Z-measuring range, e.g. 500 mm, as well as twist measurements are also possible.
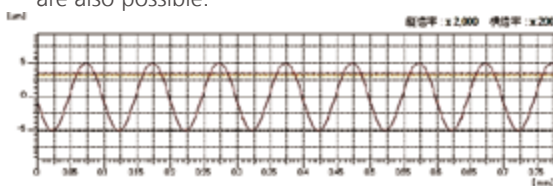
Measurement example: linear roughness measurement along the R-axis (roughness standard sample)

Roughness measurement towards Z-, R- and T-axis

Z   R   T
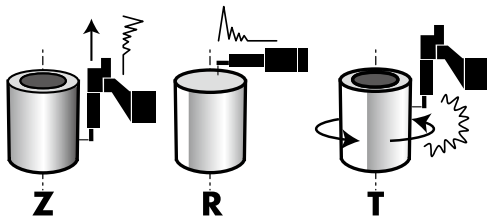
Angle measurement by moving the R-axis

NEX | NEX Rs | NEXα | NEX Rsα

This function is used for cone angle measurement with a high measuring range. R- and Z-axes move simultaneously and follow the surface, which allows the cone angle to be determined with precision.

Comparison with a contour measuring instrument

RONDCOM NEX   ACCRETECH contour measuring instrument

36.202°   18.085°
                 (36.170°)
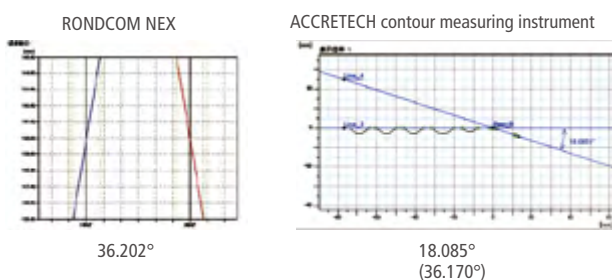
Twist measurement option

Measurement of periodic and fine twist structures

9
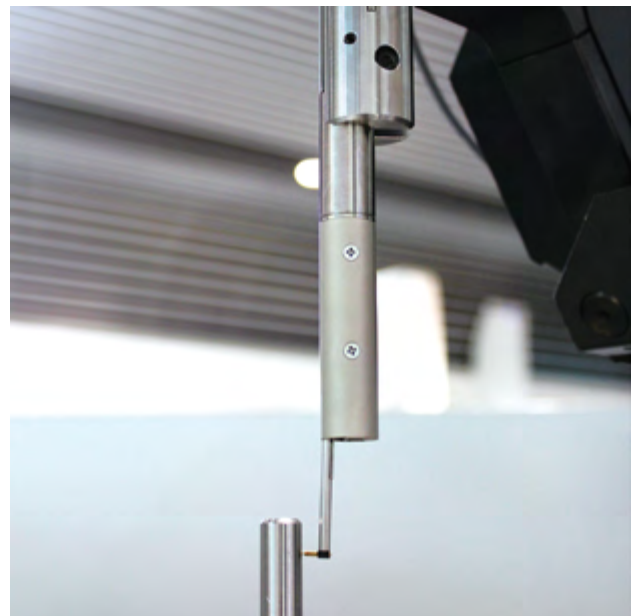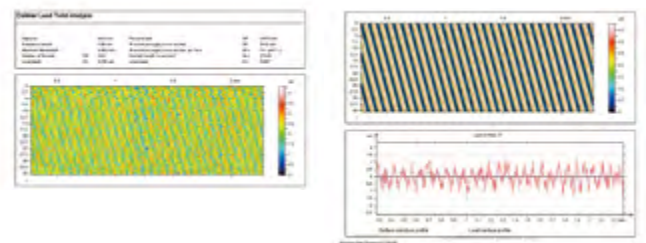
Accessories for automating the measuring sequences

Automatic force detector (AFD)*[1]

NEX | NEX Rs | NEX α | NEX Rs α
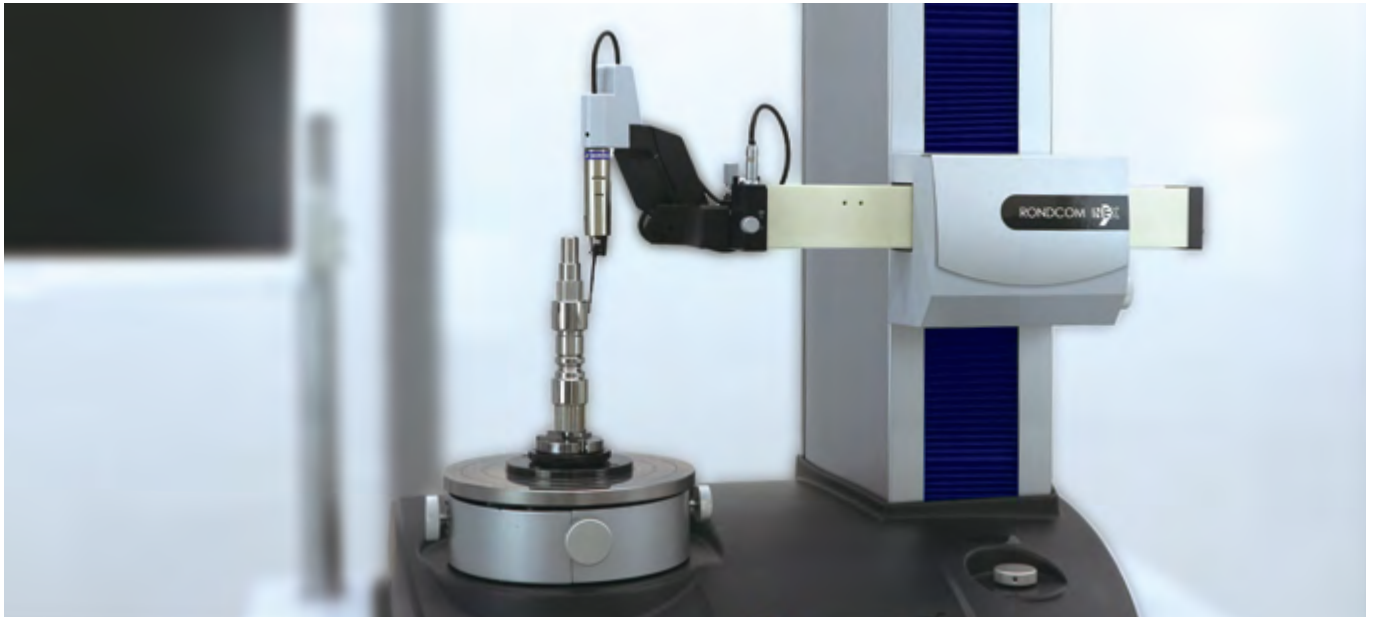
Automatic setting of the measuring range

The movement range can be adjusted via the software in such a way that allows measurements to be conducted via holes or grooves, for example.

Measurement of roundness and roughness*[2]
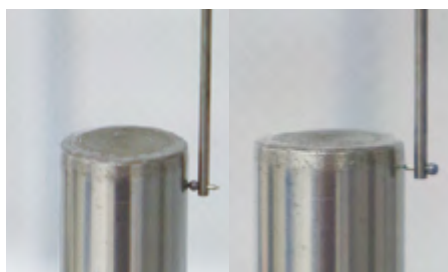
The automatic force adjustment enables the measurement of form and roughness in a single measuring sequence without the need to change detectors.

Automatic change between roundness and diameter measurement
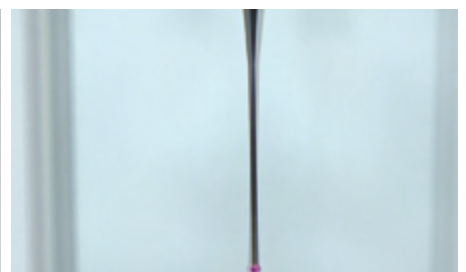
With the AFD, the adjustment that is normally made manually is made via the automatic function of the software.

*[1] Optional accessory for RONDCOM NEX 200/300
*[2] Only RONDCOM NEX Rs/ NEX Rs α

Automatic XY-axis positioning table `Patented`

NEX | NEX Rs | NEX α | NEX Rs α

CNC-controlled positioning table for pallet measurements
involving several workpieces or for off-centred measuring axes,
e.g. on crankshafts

Repeated measurements involving several workpieces or positions in one clamping operation

Video about measuring
operation available.

Flexible retrofitting

The XY-axis positioning table can be mounted
and removed again depending on the application
and workpiece.
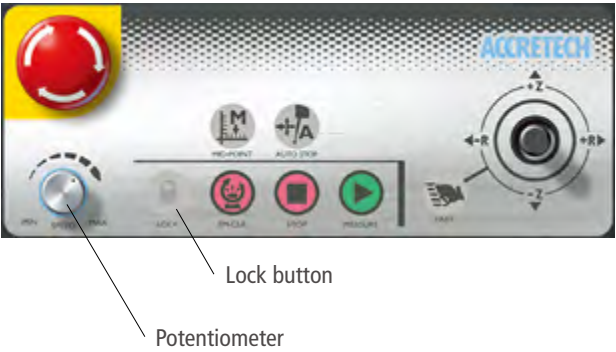
Control panel with intuitive symbols and safety functions

Lock button

Potentiometer

→ Potentiometer

→ Prevents any collisions during the first execution of the CNC programme; ensures safe measuring sequences, e.g. when conducting measurements in confined spaces.

→ Lock button prevents accidents by locking the joystick function.

Ergonomic DX table

G/RONDCOM NEX SD version

RONDCOM NEX DX version
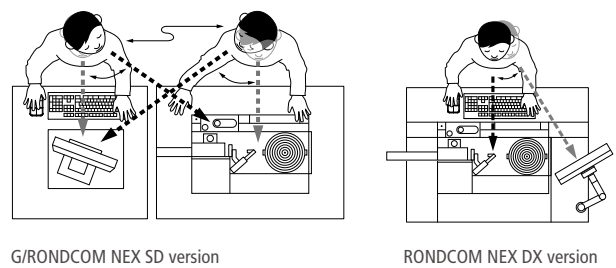
Anti-vibration table with system housing and integrated screen, improved operability with minimal floor space.
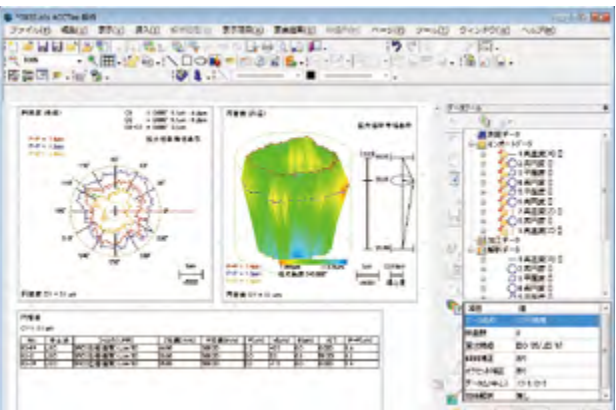
Integrated ACCTee measurement analysis software

Intuitive user guidance for calibration and alignment, measurement and analysis of measurement results. Simple creation of CNC programmes thanks to teach-in programming. Arbitrary arrangement of measurement values and 3D colour tables on the measurement report; storage of all data in the all-in-one document.

LOW MAINTENANCE

Automatic system oiling

The software-controlled oiling of the Z-axis column keeps the maintenance effort to a minimum.

Corrosion-free stainless steel rotary table

Ceramic R-axis arm

Low coefficient of thermal expansion with fluctuating room temperature.

Specifications

Hardware

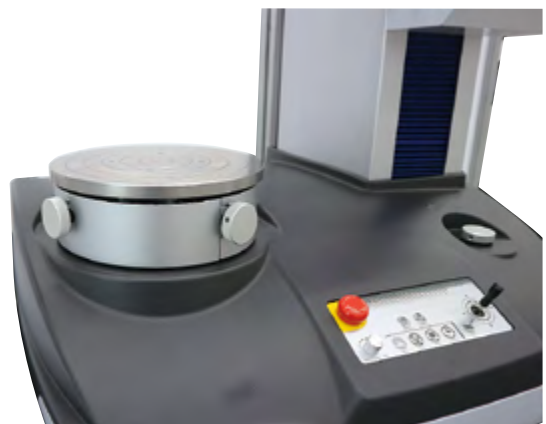|		100 SD2 (11/21)	100 SD2 (12/22)	100 SD2 (23)	100 DX2 (11/21)	100 DX2 (12/22)	200 SD2 (11/21)	200 SD2 (12/22)	200 SD2 (23)	200 DX2 (11/21)	200 DX2 (12/22)	300 SD2 (11/21)	300 SD2 (12/22)	300 SD2 (23)	300 DX2 (11/21)	300 DX2 (12/22)
Model		RONDCOM NEX (-11, -12) RONDCOM NEXα (-21,-22, -23) — RONDCOM NEX Rs (-11, -12) RONDCOM NEX Rsα (-21,-22, -23)														
Alignment		Handbook (100 & 200)										CNC (300)				
Change of detector position		Handbook (100)					Handbook (200)					CNC (300)				
Measuring range — Max. measuring diameter	(mm)	AD: φ300 (φ350)*4 / ID: φ360 (φ410)*4 (100 & 200)										AD: φ300 / ID: φ360 (300)				
Radial measuring range (R-axis)	(mm)	180					180					180				
Vertical measuring range (Z-axis)	(mm)	300	500	900	300	500	300	500	900	300	500	300	500	900	300	500
Max. loading diameter	(mm)	φ580					φ580					φ580				
Max. measuring height	(mm)	300	500	900	300	500	300	500	900	300	500	300	500	900	300	500
Accuracy — Rotational accuracy*3 — Radial direction	(µm)	(0.02+3.2H/10000) (all models)														
Rotational accuracy*3 — Axis direction	(µm)	(0.02+3.2R/10000) (all models)														
Straightness accuracy — Vertical direction (Z-axis)	(µm/mm)	0.10/100	0.10/100	0.20/100	0.10/100	0.10/100	0.10/100	0.10/100	0.20/100	0.10/100	0.10/100	0.10/100	0.10/100	0.20/100	0.10/100	0.10/100
		0.15/300	0.23/500	0.90/900	0.15/300	0.23/500	0.15/300	0.23/500	0.90/900	0.15/300	0.23/500	0.15/300	0.23/500	0.90/900	0.15/300	0.23/500
Straightness accuracy — Radial direction (R axis)	(µm/mm)	0.7/180 (all models)														
Parallelism accuracy — Z axis / T axis	(µm/mm)	0.7/300	1.0/500	2.0/900	0.7/300	1.0/500	0.7/300	1.0/500	2.0/900	0.7/300	1.0/500	0.7/300	1.0/500	2.0/900	0.7/300	1.0/500
Perpendicularity accuracy — R axis / T axis	(µm/mm)	1.0/150 (all models)														
Accuracy of the scale reading — R axis	(µm)	(0.5+L/180+2L ⊿T/100) L: Travel length (mm) ⊿T: Temperature difference between 20 °C and current temperature (°C)														

Speed

		100	200 / 300
Measuring speed — Rotational speed (θ-axis)	(/min)	1 ~ 10	1 to 10 — 0.01 bis 1 (for roughness measurement, only with NEX Rs/NEX Rsα)
Measuring speed — Vertical speed (Z-axis)	(mm/s)	0.5 ~ 10	0.5 to 10 — 0.1 to 1.5 (for roughness measurement, only with NEX Rs/NEX Rsα)
Measuring speed — Radial speed (R-axis)	(mm/s)	0.5 ~ 10	0.5 to 10 — 0.1 to 1.5 (for roughness measurement, only with NEX Rs/NEX Rsα)
Traversing speed — Rotational speed (θ-axis)	(/min)	Max. 20	
Traversing speed — Vertical speed (Z-axis)	(mm/s)	5 to 60	
Traversing speed — Radial speed (R-axis)	(mm/s)	5 to 30	

Table

		Value
Table diameter	(mm)	φ235
Centring range	(mm)	±5
Tilting range	(°)	±1
Max. loading mass — NEX/NEX Rs	(kg)	30
Max. loading mass — NEXα/NEX Rsα	(kg)	60

Detector / probe

				Value
For roundness measurement (standard accessory)	Detector E-DT-R120B	Measurement force	(mN)	30 to 100
		Linear range	(µm)	±1000
		Function		AD/ID switching function, front/over travel setting, emergency stop
	Probe EM46000-S302	Pointed	(mm)	φ1.6
		Length	(mm)	53
		Pointed material		Hard metal
For roundness and roughness measurement (standard accessory for NEX Rs / NES Rsα)	Low measurement force detector E-DT-R168D	Measurement force	(mN)	4
		Linear range	(µm)	±400
	Probe (for 010 2505)	Pointed	(mm)	φ1.6
		Length	(mm)	26.5
		Pointed material		Ruby
	Probe (for 010 2501)	Pointed	(µm)	R-tip 5 µm (90° cone)
		Length	(mm)	26.5
		Pointed material		Diamond
For high-precision roughness measurement (optional for NEX Rs/NEX Rsα)	Detector E-DT-R290B	Measurement force	(mN)	0.75
		Linear range	(µm)	±500
	Probe DM43801	Pointed	(mm)	R-tip 2 µm (60° cone)
		Pointed material		Diamond

*1 NEX-11/NEX Rs-11 (max. loading mass 30 kg, 300 mm column), NEX-12/NEX Rs-12 (max. loading mass 30 kg, 500 mm column)
 NEXα-21/NEX Rsα-21 (max. loading mass 60 kg, 300 mm column), NEXα-22/NEX Rsα-22 (max. loading mass 60 kg, 500 mm column),
 NEXα-23/NEX Rsα-23 (max. loading mass 60 kg, 900 mm column)
*2 Please consult our sales team as there may be restrictions due to the measuring diameter and the combination of detector and probe.
*3 H is the height of the measuring point from the top of the table in mm, and R is the distance from the centre of rotation of the table in mm.
*4 When using the offset detector holder to extend the maximum measuring diameter E-DH-RB86A (optional)

Software

Model	RONDCOM NEX (-11, -12) RONDCOM NEXα (-21,-22, -23)											
	RONDCOM NEX Rs (-11, -12) RONDCOM NEX Rsα (-21,-22, -23)											
	100			200			300					
Position	SD2		DX2		SD2		DX2		SD2		DX2	
Model*1	11	12	11	12	11	12	11	12	11	12	11	12
	21	22	23	21	22	21	22	23	21	22	21	22	21	22	23	21	22
Number of measuring points (Point)	14400											
Filter type — Digital filter	Gauss/2RC/Spline/Robust (Spline)											

Cut-off value	Rotational direction (θ-axis)	Low-pass	15, 50, 150, 500, 1500 UPR, 15 to 1500 UPR (shaft movements per revolution)
		Band-pass	1 to 1500 UPR
	Linear direction (Z-axis)	Low-pass	0.025, 0.08, 0.25, 0.8, 2.5, 8 mm (each value in 0.0001 mm)

Roundness evaluation centring method	Least square reference circle (Gauss circle – LSCI), Minimum circle (MZCI), minimum circumscribed circle (MCCI) , minimum circumscribed circle (MICI), N.C

Measuring positions	Rotational direction	Roundness, flatness, overall flatness, parallelism, concentricity, coaxiality, cylindricity, diameter deviation, squareness, wall thickness uniformity, pitch circle
	Linear direction	Straightness (Z), straightness (R), cylindricity, perpendicularity, parallelism, diameter deviation, axis straightness

Roughness analysis position (only RONDCOM NEX Rs/NEX Rsα)	Standard	JIS-2013, JIS-2001, JIS-1994, JIS-1982, ISO-2009, ISO-1997 , ISO-1984, DIN-1990, ASME-2002, ASME-1995
	Parameter	Ra, Rq, Ry, Rp, Rv, Rc, Rz, Rmax, Rt, Rz.J, R3z, Sm, S, R Δ a, R Δ q, R λ a, R λ q, TILT A, Ir, Pt, Pc, Rsk, Rku, Rk, Rpk, Rvk, Mr1, Mr2, VO, K, tp, Rmr, tp2, Rmr2, R δ c, AVH, Hmax, Hmin, AREA, NCRX, R, Rx, AR, NR, CPM, SR, SAR
	Evaluation curve	Profile curve, roughness curve, filtered waviness curve, pitch circle waviness curve, pitch circle centreline waviness curve, ISO13565-1 profile curve, ISO13565-1 roughness curve, roughness motif curve, waviness motif curve, envelope curve with waviness
	Characteristic curve	Load-carrying curve, graph of amplitude distribution, power spectrum
	Inclination correction methods	Least squares straight line, n-dimensional polynomial, both ends, least squares circle, least squares ellipse, spline, robust (spline), spline curve

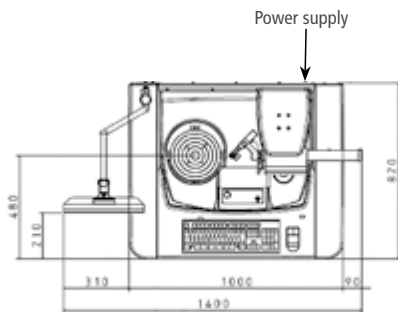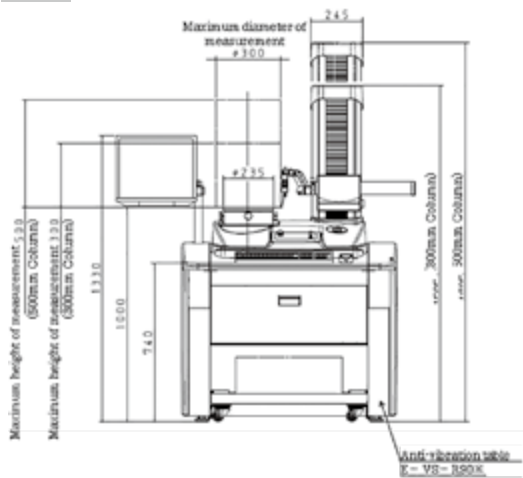| Analysis processing functions	Notch function (plane, angle, cursor), combination of methods for roundness evaluation, setpoint adjustment, cylinder 3D display (line drawing, shading, contour line), real-time display, graphical display of profile characteristics (load-carrying curve, graph of amplitude distribution, power spectrum), function for automatic CNC measurement	Notch function (plane, angle, cursor), combination of methods for roundness evaluation, setpoint adjustment, cylinder 3D display (line drawing, shading, contour line), real-time display, graphic display of profile characteristics (load-carrying curve, graph of amplitude distribution, power spectrum), function for automatic CNC measurement, automatic centring/tilt adjustment
The following are displayed	Measurement conditions, measurement parameters, comments, output conditions for the printer, profile graphics (layout plan, 3D plan), error messages, etc.	

Dimensions and other positions

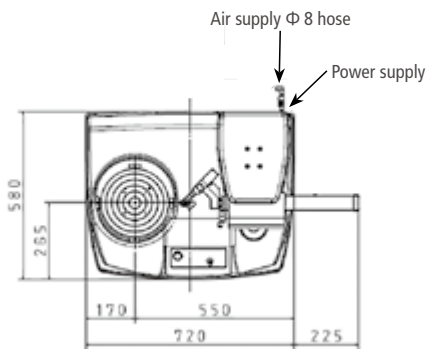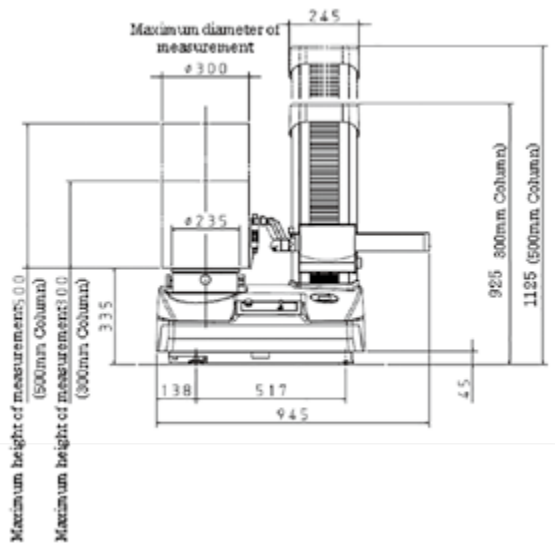|			(unit)	100 SD2		100 DX2		200 SD2		200 DX2		300 SD2		300 DX2	
Installation dimensions*5	Width		(mm)	720	1074	1400		720	1074	1400		720	1074	1400	
	Depth		(mm)	580	824	820		580	824	820		580	824	820	
	Height	NEX	(mm)	925	1125	1595	1795	925	1125	1595	1795	925	1125	1595	1795
		NEX Rs	(mm)					925	1125	1595	1795	925	1125	1595	1795
		NEX α	(mm)	925	1125	2125	1595	1795	925	1125	2125	1595	1795	925	1125	2125	1595	1795
		NEX Rsα	(mm)					925	1125	2125	1595	1795	925	1125	2125	1595	1795
Weight*5	NEX/NEX Rs	Measurement unit	(kg)	Approx. 170	Approx. 180	Approx. 330	Approx. 340	Approx. 170	Approx. 180	Approx. 330	Approx. 340	Approx. 170	Approx. 180	Approx. 330	Approx. 340
		Data processing unit	(kg)	Approx. 10				Approx. 10				Approx. 10			
	NEXα/NEX Rsα	Measurement unit	(kg)	Approx. 190	Approx. 200	Approx. 560	Approx. 350	Approx. 360	Approx. 190	Approx. 200	Approx. 560	Approx. 350	Approx. 360	Approx. 190	Approx. 200	Approx. 560	Approx. 350	Approx. 360
		Data processing unit	(kg)	Approx. 10				Approx. 10				Approx. 10			
Power supply	Voltage, frequency		(V, Hz)	AC100 to 240, 50/60 (earthing required)											
	Power consumption		(VA)	Approx. 630											
Air supply	Supply air pressure	NEX	(MPa)	0.35 ~ 0.7		0.35 ~ 0.7		0.35 ~ 0.7		0.35 ~ 0.7			0.35 ~ 0.7		
		NEXα/ NEX Rs/NEX Rsα	(MPa)	0.45 ~ 0.7											
	Compressed air pressure	NEX	(MPa)	0.3		0.3		0.3		0.3			0.3		
		NEXα/ NEX Rs/NEX Rsα	(MPa)	0.4											
	Air consumption rate	NEX	(NL/min)	30		30		30		30			30		
		NEX Rs/NEX Rsα	(NL/min)	40											
	Connection for the air supply (main unit)			One-touch hose connector for outer diameter Φ 8 mm hose											
Operating environment	Operating temperature		(°C)	10 to 30											
	Guaranteed accuracy Temperature range		(°C)	20±2											

*5 Installation dimensions and weight of a NEXα-23/NEX Rsα (max. loading mass 60 kg, 900 mm column) are the values when using an anti-vibration table E-VS-R86B (optional).
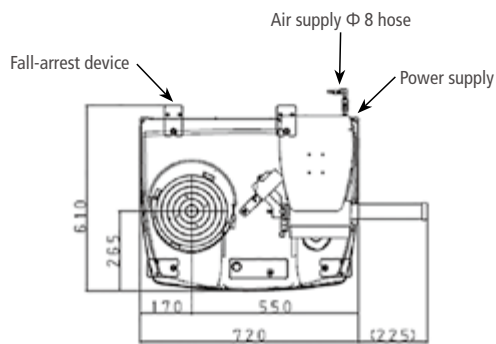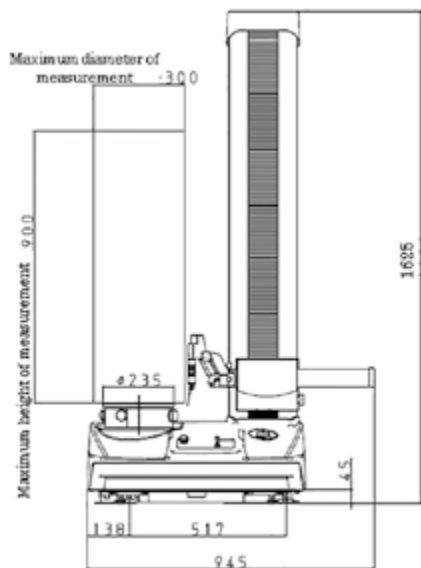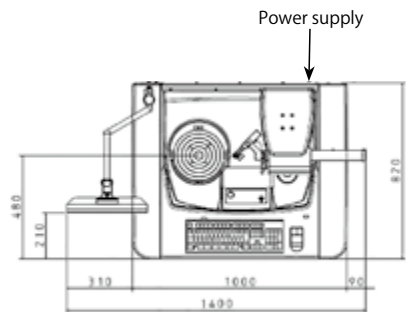
Exterior view – RONDCOM NEX / NEXα

DX2

Power supply

Maximum diameter of measurement ø300

ø235

Maximum height of measurement 520 (500mm Column)
Maximum height of measurement 320 (300mm Column)

245

300mm Column
500mm Column

1330
1000
940

Anti-vibration table
F – VS – 380K

480
210
870

310   1000   90
1400

SD2 Z = 300 / 500

Maximum diameter of measurement ø300

ø235

245

800mm Column
500mm Column

925
1125

Maximum height of measurement 500 (500mm Column)
Maximum height of measurement 300 (300mm Column)

335

138   517   45
945

Air supply Φ 8 hose
Power supply

580
265

170   550
720   225

SD2 Z = 900

Maximum diameter of measurement 300

ø235

Maximum height of measurement 900

1685

138   517   45
945

Air supply Φ 8 hose
Fall-arrest device
Power supply

610
265

170   550
720   (225)
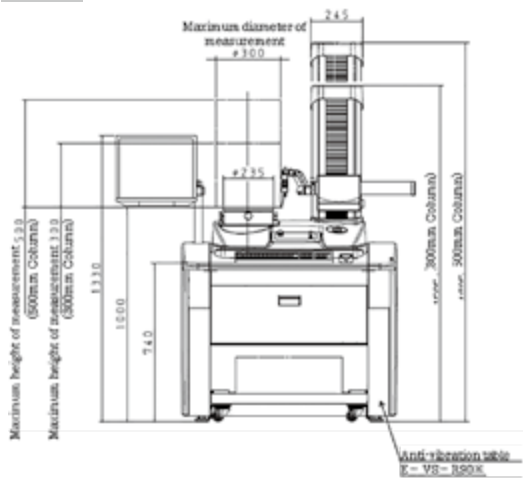
Exterior view – RONDCOM NEX Rs / NEX Rsα

DX2

Power supply

SD2 Z = 300 / 500

Air supply Φ 8 hose
Power supply

SD2 Z = 900

Fall-arrest device
Air supply Φ 8 hose
Power supply
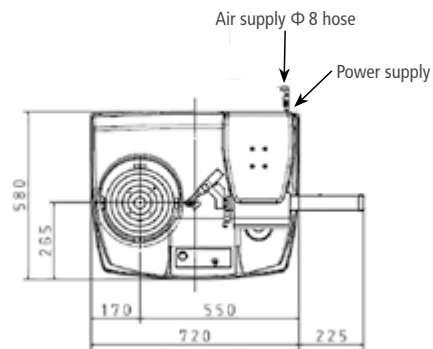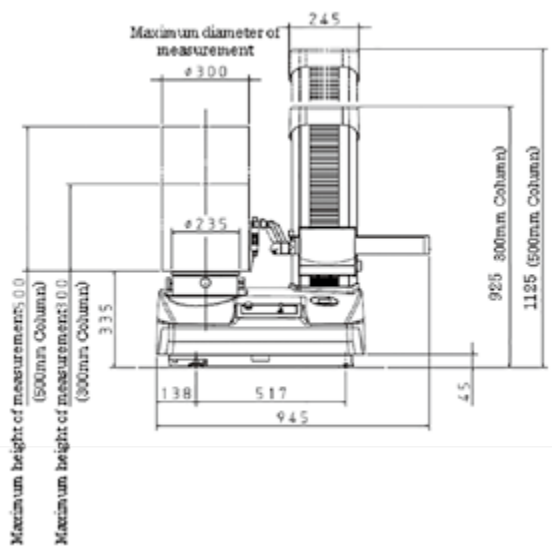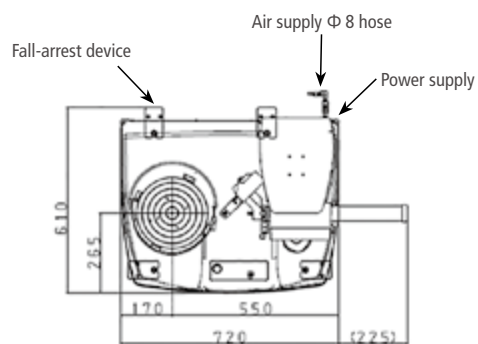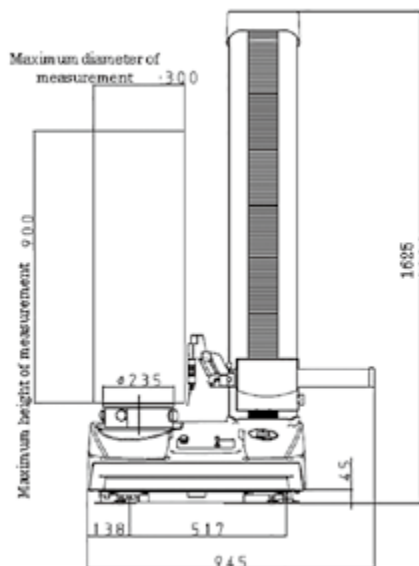
Model designation based on system configuration and selection

Product name

RONDCOM NEX / NEX Rs
RONDCOM NEXα / NEX Rsα

| ☐ ☐ ☐ | | — | ■ ■ |
| 1 Version | 2 Type | | 3 Column |

1 Selection of workpiece alignment and detector holder, manual or CNC-controlled

Position	Manual / CNC	100*	200	300
Workpiece alignment	Manual	●		
	CNC		●	●
Detector holder	Manual	●	●	
	CNC			●

*Only RONDCOM NEX / NEXα

2 Type selection

Type	DX2	SD2
Exterior view		

3 Column selection

RONDCOM NEX / NEX Rs

Column	11	12
Z measuring range	300 mm	500 mm

RONDCOM NEXα / NEX Rsα

Column	21	22	23
Z measuring range	300 mm	500 mm	900 mm (SD only)

On-site retrofitting to CNC unit after delivery*

The manual model RONDCOM NEX 100 can be retrofitted to a CNC model RONDCOM NEX 200 or 300 after delivery. Customers who have introduced a manual model can retrofit this to a CNC model on site via our service team if required.

Conventional measuring instruments

Manual machine → New order → **CNC machine**

RONDCOM NEX 100 and RONDCOM NEX 200/300 Series

RONDCOM NEX 100 → Upgrade on site → **RONDCOM NEX 200/300** (CNC)

*RONDCOM NEXα excluded

Detector for automatic force adjustment

Position		Detector for automatic force adjustment
Linear measuring range	(µm)	±1000
Measurement force*	(mN)	4~30 (controlled by ACCTee software)
Function		AD/ID switching function (controlled by ACCTee software), movement range setting function (controlled by ACCTee software), emergency stop function
Remark		Optional for the 200/300 system

*Measurement force range is limited by the mass and angle of the probe.
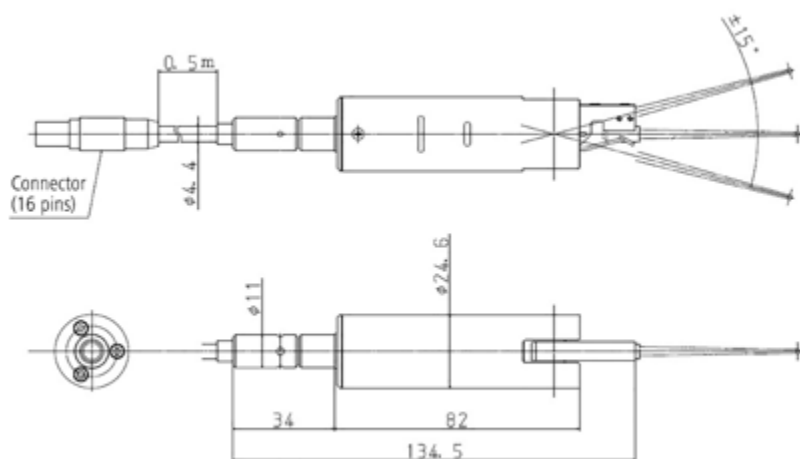
Automatic XY-axis positioning table

Position			Specifications for the RONDCOM NEX series with automatic XY-axis positioning table
Traverse path	Cx-axis	(mm)	200(±100)
	Cy-axis	(mm)	100(±50)
Workpiece	Loadable area	(mm)	Φ 300 from the centre of the XY-axis positioning table
	Max. loading mass	(kg)	5
Traversing speed		(mm/s)	Max. 20
Rotational accuracy*	Radial direction	(µm)	(0.08 + 6H / 10000)
	Axis direction	(µm)	(0.08 + 6R / 10000)
Guaranteed accuracy range*		(mm)	120≦H≦300
Z-axis parallelism		(µm/mm)	0.5 / 150
Installation dimensions and weight	Width x depth x height	(mm)	540 x 356 x 132
	Height from the top of the unit table to the top of the XY positioning table (mm)	(mm)	120
	Weight	(kg)	Approx. 20 (not including counterweights)
Correct model			RONDCOM NEX / NEX α 200 • 300 RONDCOM NEX Rs / NEX Rs α 200 • 300
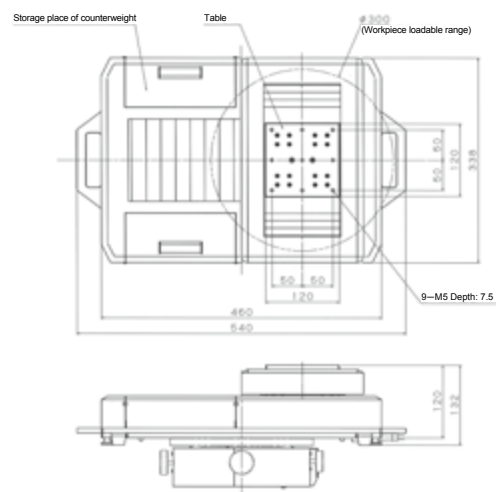
* Complies with standard JIS B 7451-1997. H is the height of the measuring point from the top of the unit table in mm, and R is the distance from the centre of rotation of the unit table in mm.
  The other specification items correspond to the specifications for the RONDCOM NEX series

Together with our partners, we are able to offer you a Europe-wide sales and service network. Through the regional proximity, a service technician can reach your premises without any prolonged wait and travel times. If you have any questions, please contact us directly from all European countries through our centralized metrology phone number or email address:

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