**Height Master**

**SERIES 515**

### Technical Data
- **Graduation:** 0.00001" or 0.001 mm
- **Counter resolution:** .001" or 0.01 mm
- **Character Height:** .16" / 4 mm
- **Micrometer Head Travel stroke:** 1" or 20 mm
- **Pitch:** .025° / rev or 0.5 mm / rev
- **Hysteresis:** .00004" or 1 µm

Provided with inspection certificate.

### Standard Accessories
- **Reference Block:** 11 mm for 515-322
- **Reference Block:** .3" for 515-310, 515-311

### Optional Accessories
- **515-112:** Auxiliary block kit for bore gage (mm)
- **515-119:** Auxiliary block kit for bore gage (for 515-310)
- **515-121:** Auxiliary block kit for bore gage (for 515-311)
- **——:** Riser block

### FEATURES
- Models with staggered arrangement of block stack have two measuring faces on the same level, one facing up and the other down (except for **515-310**).
- Each Height Master is supplied with a gage block for zero-setting.
- Supplied in fitted wooden case.

### SPECIFICATIONS

#### Metric

<table>
<thead>
<tr>
<th>Range (H)</th>
<th>Order No.</th>
<th>Block step</th>
<th>Graduation</th>
<th>Block Pitch Accuracy</th>
<th>Parallelism of Block</th>
<th>Micrometer Head Accuracy</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 &lt; H ≤ 310 mm</td>
<td>515-322</td>
<td>20 mm (staggered)</td>
<td>0.001 mm</td>
<td>±1.5 µm</td>
<td>1 µm</td>
<td>±1 µm</td>
<td>23</td>
</tr>
</tbody>
</table>

#### Inch

<table>
<thead>
<tr>
<th>Range (H)</th>
<th>Order No.</th>
<th>Block step</th>
<th>Graduation</th>
<th>Block Pitch Accuracy</th>
<th>Parallelism of Block</th>
<th>Micrometer Head Accuracy</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2&quot; &lt; H ≤ 12.2&quot;</td>
<td>515-310</td>
<td>.5&quot; (straight)</td>
<td>.0001&quot;</td>
<td>±.00005&quot;</td>
<td>.00004&quot;</td>
<td>±.00005&quot;</td>
<td>23</td>
</tr>
<tr>
<td>2&quot; &lt; H ≤ 12.2&quot;</td>
<td>515-311</td>
<td>1&quot; (staggered)</td>
<td>.00001&quot;</td>
<td>±.00005&quot;</td>
<td>.00004&quot;</td>
<td>±.00005&quot;</td>
<td>23</td>
</tr>
</tbody>
</table>

---

Reading:

1. Scale
2. Counter
3. Thimble

Height A:

1. Scale 280 mm
2. Counter 5.67 mm
3. Thimble 0.000 mm

285.670 mm
Digital Height Master
SERIES 515

FEATURES
• Standard model with a digital display, featuring all essential specifications required for versatile height standard.
• With SPC output.
• Each Height Master is supplied with a gage block for zero setting.

SPECIFICATIONS

<table>
<thead>
<tr>
<th>Metric</th>
<th>Order No.</th>
<th>Block step</th>
<th>Resolution</th>
<th>Block Pitch Accuracy</th>
<th>Parallelism</th>
<th>Micrometer Head Accuracy</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>10 &lt; H ≤ 310mm</td>
<td>515-374</td>
<td>20mm (staggered)</td>
<td>0.001mm</td>
<td>±1.5µm</td>
<td>2µm</td>
<td>±2µm</td>
<td>9.5</td>
</tr>
<tr>
<td>10 &lt; H ≤ 460mm</td>
<td>515-376</td>
<td>20mm (staggered)</td>
<td>0.001mm</td>
<td>±2.5µm</td>
<td>2.5µm</td>
<td>±2µm</td>
<td>13.6</td>
</tr>
<tr>
<td>10 &lt; H ≤ 610mm</td>
<td>515-378</td>
<td>20mm (staggered)</td>
<td>0.001mm</td>
<td>±3.5µm</td>
<td>2.5µm</td>
<td>±2.5µm</td>
<td>16.0</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Inch/Metric</th>
<th>Order No.</th>
<th>Block step</th>
<th>Resolution</th>
<th>Block Pitch Accuracy</th>
<th>Parallelism</th>
<th>Micrometer Head Accuracy</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.5” &lt; H ≤ 12”</td>
<td>515-375</td>
<td>1” (staggered)</td>
<td>.0001” / .0001mm</td>
<td>±.0001”</td>
<td>±.0001”</td>
<td>±.0001”</td>
<td>9.5</td>
</tr>
<tr>
<td>.5” &lt; H ≤ 18”</td>
<td>515-377</td>
<td>1” (staggered)</td>
<td>.0001” / .0001mm</td>
<td>±.0001”</td>
<td>.0001”</td>
<td>±.0001”</td>
<td>13.6</td>
</tr>
<tr>
<td>.5” &lt; H ≤ 24”</td>
<td>515-379</td>
<td>1” (staggered)</td>
<td>.0001” / .0001mm</td>
<td>±.0001”</td>
<td>.0001”</td>
<td>±.0001”</td>
<td>16.0</td>
</tr>
</tbody>
</table>

Technical Data
Resolution (LCD): .0001” or 0.001mm
Graduation: .0001” or 0.002mm
Character Height: .21” / 5.4mm
Micrometer Head
Travel Stroke: 1” or 20mm
Pitch: .025”/rev or 0.5mm/rev
Hysteresis: .0001” for all inch models
0.002mm for 300mm models
0.0025mm for 450 & 600mm models
Battery: SR44 (2 pcs.), 938882
Battery life: Approx. 1.8 years under normal use

Function
Zero-setting, Presetting, ABS/INC switching, Data hold, Data output, inch/mm conversion (on inch/metric models only)
Alarm: Low voltage, Counting value composition error

Standard Accessories
Reference Block: 11mm for Metric Height Master 611621-031
Reference Block: 6” for Inch Height Master 611196-531
Provided with inspection certificate.

Optional Accessories
515-111: Auxiliary block kit for bore gage (mm)
515-120: Auxiliary block kit for bore gage (inch)
959149: Riser block (see page E-27.)
959150: SPC cable (40” / 1m)
050019: Fitted Mahogany case for 12” / 300mm model
050059: Fitted Mahogany case for 18” / 450mm model
24” / 600mm model

Technical Data
Resolution (LCD): .0001” or 0.001mm
Graduation: .0001” or 0.002mm
Character Height: .21” / 5.4mm
Micrometer Head
Travel Stroke: 1” or 20mm
Pitch: .025”/rev or 0.5mm/rev
Hysteresis: .0001” for all inch models
0.002mm for 300mm models
0.0025mm for 450 & 600mm models
Battery: SR44 (2 pcs.), 938882
Battery life: Approx. 1.8 years under normal use

Function
Zero-setting, Presetting, ABS/INC switching, Data hold, Data output, inch/mm conversion (on inch/metric models only)
Alarm: Low voltage, Counting value composition error

Standard Accessories
Reference Block: 11mm for Metric Height Master 611621-031
Reference Block: 6” for Inch Height Master 611196-531
Provided with inspection certificate.

Optional Accessories
515-111: Auxiliary block kit for bore gage (mm)
515-120: Auxiliary block kit for bore gage (inch)
959149: Riser block (see page E-27.)
959150: SPC cable (40” / 1m)
050019: Fitted Mahogany case for 12” / 300mm model
050059: Fitted Mahogany case for 18” / 450mm model
24” / 600mm model

Technical Data
Resolution (LCD): .0001” or 0.001mm
Graduation: .0001” or 0.002mm
Character Height: .21” / 5.4mm
Micrometer Head
Travel Stroke: 1” or 20mm
Pitch: .025”/rev or 0.5mm/rev
Hysteresis: .0001” for all inch models
0.002mm for 300mm models
0.0025mm for 450 & 600mm models
Battery: SR44 (2 pcs.), 938882
Battery life: Approx. 1.8 years under normal use

Function
Zero-setting, Presetting, ABS/INC switching, Data hold, Data output, inch/mm conversion (on inch/metric models only)
Alarm: Low voltage, Counting value composition error

Standard Accessories
Reference Block: 11mm for Metric Height Master 611621-031
Reference Block: 6” for Inch Height Master 611196-531
Provided with inspection certificate.

Optional Accessories
515-111: Auxiliary block kit for bore gage (mm)
515-120: Auxiliary block kit for bore gage (inch)
959149: Riser block (see page E-27.)
959150: SPC cable (40” / 1m)
050019: Fitted Mahogany case for 12” / 300mm model
050059: Fitted Mahogany case for 18” / 450mm model
24” / 600mm model
Riser Blocks
SERIES 515

FEATURES
• These riser blocks are specially designed for standard/Digimatic height masters.

SPECIFICATIONS

<table>
<thead>
<tr>
<th>Metric</th>
<th>Height</th>
<th>Order No.</th>
<th>Accuracy of height</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>150mm</td>
<td>515-113</td>
<td>±0.6µm</td>
<td>5.7</td>
</tr>
<tr>
<td></td>
<td>300mm</td>
<td>515-114</td>
<td>±1.0µm</td>
<td>11.3</td>
</tr>
<tr>
<td></td>
<td>600mm</td>
<td>515-115</td>
<td>±2.0µm</td>
<td>31</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Inch</th>
<th>Height</th>
<th>Order No.</th>
<th>Accuracy of height</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>6&quot;</td>
<td>515-116</td>
<td>±20µin</td>
<td>5.7</td>
</tr>
<tr>
<td></td>
<td>12&quot;</td>
<td>515-117</td>
<td>±40µin</td>
<td>11.3</td>
</tr>
<tr>
<td></td>
<td>24&quot;</td>
<td>515-118</td>
<td>±80µin</td>
<td>31</td>
</tr>
</tbody>
</table>

Auxiliary Block Kit
SERIES 515 — for Bore Gage

FEATURES
• Used for efficient zero-setting of dial bore gages and tubular inside micrometers (18 - 150mm) on a Height Master.

SPECIFICATIONS

<table>
<thead>
<tr>
<th>Metric</th>
<th>Order No.</th>
<th>Applicable height master</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>515-110</td>
<td>Universal Height Master</td>
</tr>
<tr>
<td></td>
<td>515-111</td>
<td>Digimatic Height Master</td>
</tr>
<tr>
<td></td>
<td>515-112</td>
<td>Height Master</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Inch</th>
<th>Order No.</th>
<th>Applicable height master</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>515-119</td>
<td>Universal Height Master, Height Master (515-310)</td>
</tr>
<tr>
<td></td>
<td>515-120</td>
<td>Digimatic Height Master</td>
</tr>
<tr>
<td></td>
<td>515-121</td>
<td>Height Master (515-311)</td>
</tr>
</tbody>
</table>
Universal Height Master
SERIES 515 — Usable in Vertical and Horizontal Orientations

FEATURES
- The Universal Height Master is designed for both vertical and horizontal orientations, providing a wide range of applications such as accuracy checking of machine tool table movements.
- Fitted wooden case supplied.

Technical Data
Graduation: 0.001mm or .00001"
Counter Resolution: .001" or 0.01mm
Character Height: .16" / 4mm
Block arrangement: Straight arrangement

Micrometer Head
Travel stroke: 1" or 20mm
Pitch: .025"/rev or 0.5mm/rev
Hysteresis: .00004" / 1.2µm up to 24.2" / 610mm
.00006" / 1.5µm for 40.2" / 1010mm
Block pitch accuracy: ±1.5µm (0 < R ≤ 310mm)
±3.5µm (310 < R ≤ 610mm)
±3.5µm (610 < R ≤ 1010mm)
Parallelism of blocks: 1.0µm (0 < R ≤ 310mm)
2.5µm (310 < R ≤ 1010mm)
Provided with inspection certificate.

Optional Accessories
900574*: Supporting base for vertical operation
Mass: 3kg
(*supplied as a standard for 515-523 and 515-513)
515-112: Auxiliary block kit for bore gage (mm)
515-119: Auxiliary block kit for bore gage (inch)

SPECIFICATIONS

<table>
<thead>
<tr>
<th>Metric</th>
<th>Range (R)</th>
<th>Order No.</th>
<th>Block step</th>
<th>Graduation</th>
<th>Block Pitch Accuracy</th>
<th>Parallellism of Block</th>
<th>Micrometer Head Accuracy</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>5 &lt; R ≤ 610mm</td>
<td>515-520</td>
<td>10mm (straight)</td>
<td>0.001mm</td>
<td>±1.5µm</td>
<td>1.0µm</td>
<td>±1.2µm</td>
<td>42</td>
</tr>
<tr>
<td></td>
<td>5 &lt; R ≤ 1010mm</td>
<td>515-523</td>
<td>10mm (straight)</td>
<td>0.001mm</td>
<td>±3.5µm</td>
<td>2.5µm</td>
<td>±1.5µm</td>
<td>63.5</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Inch</th>
<th>Range (R)</th>
<th>Order No.</th>
<th>Block step</th>
<th>Graduation</th>
<th>Block Pitch Accuracy</th>
<th>Parallellism of Block</th>
<th>Micrometer Head Accuracy</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>2&quot; &lt; R ≤ 18.2&quot;</td>
<td>515-512</td>
<td>5&quot; (straight)</td>
<td>.00001&quot;</td>
<td>±.00005&quot;</td>
<td>.00006&quot;</td>
<td>±.00004&quot;</td>
<td>42</td>
</tr>
<tr>
<td></td>
<td>2&quot; &lt; R ≤ 24.2&quot;</td>
<td>515-510</td>
<td>5&quot; (straight)</td>
<td>.00001&quot;</td>
<td>±.0001&quot;</td>
<td>.00006&quot;</td>
<td>±.00004&quot;</td>
<td>50</td>
</tr>
<tr>
<td></td>
<td>2&quot; &lt; R ≤ 40.2&quot;</td>
<td>515-513</td>
<td>5&quot; (straight)</td>
<td>.00001&quot;</td>
<td>±.00015&quot;</td>
<td>.00008&quot;</td>
<td>±.00006&quot;</td>
<td>63.5</td>
</tr>
</tbody>
</table>
High Accuracy Check Master HMC-H
SERIES 515

FEATURES

• Designed to check the accuracy of table movements of machine tools and calibrate
  CMMs. Permanently wrung stack of gage blocks is housed in a rigid frame.
• Can be used in either vertical and horizontal orientation.
• Fitted wooden case supplied.

Specifications for Ceramic Check Master:
• Each measuring block is made of zirconia-based ceramic that requires no anti-corrosion
  treatment for measuring faces.
• Free from deterioration and dimensional changes over time.

Technical Data
Measuring range (R): Refer to the list of specifications.
Block pitch accuracy:
- ±1.2µm (0 < R ≤ 310mm)
- ±1.8µm (310 < R ≤ 610mm)
- ±2.5µm (610 < R ≤ 1010mm)
- ±4.0µm (1010 < R ≤ 1510mm)
Parallelism of blocks:
- 1.0µm (0 < R ≤ 450mm)
- 1.5µm (450 < R ≤ 1010mm)
- 2.0µm (1010 < R ≤ 1510mm)
Provided with inspection certificate.

<table>
<thead>
<tr>
<th>Metric</th>
<th>Range (R)</th>
<th>Order No.</th>
<th>Pitch</th>
<th>Accuracy of block pitch for the range shown below as measured from the bottom block</th>
<th>Length</th>
<th>Parallelism</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>Ceramic</td>
<td>P P</td>
<td></td>
<td>up to 300mm 300-600mm 600-1000mm 1000-1500mm</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>300mm</td>
<td>515-740</td>
<td>515-760</td>
<td>20mm</td>
<td>10mm ±1.2µm — — —</td>
<td>311mm</td>
<td>1µm</td>
<td>3.6</td>
</tr>
<tr>
<td>450mm</td>
<td>515-741</td>
<td>515-761</td>
<td>20mm</td>
<td>10mm ±1.2µm ±1.8µm —</td>
<td>482mm</td>
<td>1µm</td>
<td>5.4</td>
</tr>
<tr>
<td>600mm</td>
<td>515-742</td>
<td>515-762</td>
<td>20mm</td>
<td>10mm ±1.2µm ±1.8µm —</td>
<td>631mm</td>
<td>1.5µm</td>
<td>7.2</td>
</tr>
<tr>
<td>1000mm</td>
<td>515-743</td>
<td>515-763</td>
<td>20mm</td>
<td>10mm ±1.2µm ±1.8µm ±2.5µm</td>
<td>1037mm</td>
<td>1.5µm</td>
<td>12.0</td>
</tr>
<tr>
<td>1500mm</td>
<td>515-744</td>
<td>515-764</td>
<td>20mm</td>
<td>10mm ±1.2µm ±1.8µm ±2.5µm ±4.0µm</td>
<td>1546mm</td>
<td>2µm</td>
<td>18.0</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Inch</th>
<th>Range (R)</th>
<th>Order No.</th>
<th>Pitch</th>
<th>Accuracy of block pitch for the range shown below as measured from the bottom block</th>
<th>Length</th>
<th>Parallelism</th>
<th>Mass (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>Ceramic</td>
<td>P P</td>
<td></td>
<td>up to 360mm 24-40&quot; 40-60&quot;</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>12&quot;</td>
<td>515-730</td>
<td>515-750</td>
<td>1&quot;</td>
<td>5&quot; ±50µin — —</td>
<td>13.0&quot;</td>
<td>40µin</td>
<td>3.4</td>
</tr>
<tr>
<td>18&quot;</td>
<td>515-731</td>
<td>515-751</td>
<td>1&quot;</td>
<td>5&quot; ±50µin ±70µin —</td>
<td>19.0&quot;</td>
<td>40µin</td>
<td>5.2</td>
</tr>
<tr>
<td>24&quot;</td>
<td>515-732</td>
<td>515-752</td>
<td>1&quot;</td>
<td>5&quot; ±50µin ±70µin —</td>
<td>25.0&quot;</td>
<td>60µin</td>
<td>6.9</td>
</tr>
<tr>
<td>40&quot;</td>
<td>515-733</td>
<td>515-753</td>
<td>1&quot;</td>
<td>5&quot; ±50µin ±70µin ±100µin —</td>
<td>41.0&quot;</td>
<td>60µin</td>
<td>11.5</td>
</tr>
<tr>
<td>60&quot;</td>
<td>515-734</td>
<td>515-754</td>
<td>1&quot;</td>
<td>5&quot; ±50µin ±70µin ±100µin ±158µin</td>
<td>61.5&quot;</td>
<td>80µin</td>
<td>17.3</td>
</tr>
</tbody>
</table>

Specifications for Ceramic Check Master:
• Each measuring block is made of zirconia-based ceramic that requires no anti-corrosion
  treatment for measuring faces.
• Free from deterioration and dimensional changes over time.

Optional Accessories

601167: Supporting base for vertical operation
(*supplied as a standard for 515-523 and 515-513)
Dimensions: 14.2"(W) x 8.7"(D) x 8.3"(H)
360mm(W) x 220mm(D) x 210mm(H)
Mass: 3kg

Supporting base
CERA Straight Master SM-C
SERIES 311 — Straightness Measuring Instrument

FEATURES
CERA Straight master is a master gage used for the straightness inspection of each axis movement such as a CMM, machine tool, semiconductor related equipment and form measuring machine.
- Made from Alumina ceramic
- 50mm/2” pitch gradation scales
- Precision lapped measuring surface
- Double faced type is lapping the double face which can be used for straightness in horizontal and vertical as a reference square.
- Lightweight
- Supplied with fitted wooden case.

SPECIFICATIONS

<table>
<thead>
<tr>
<th>Metric</th>
<th>Inch</th>
<th>High accuracy model</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nominal length</td>
<td>Order No.*</td>
<td>Straightness</td>
</tr>
<tr>
<td>400mm</td>
<td>311-302-33</td>
<td>0.3µm</td>
</tr>
<tr>
<td>700mm</td>
<td>311-305-33</td>
<td>0.5µm</td>
</tr>
<tr>
<td>1000mm</td>
<td>311-307-33</td>
<td>1.0µm</td>
</tr>
<tr>
<td>1300mm</td>
<td>311-309-33</td>
<td>1.5µm</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Metric</th>
<th>Inch</th>
<th>Ultra high accuracy model</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nominal length</td>
<td>Order No.*</td>
<td>Straightness</td>
</tr>
<tr>
<td>16&quot;</td>
<td>311-332-33</td>
<td>0.2µm</td>
</tr>
<tr>
<td>28&quot;</td>
<td>311-335-33</td>
<td>0.4µm</td>
</tr>
<tr>
<td>40&quot;</td>
<td>311-337-33</td>
<td>0.5µm</td>
</tr>
<tr>
<td>52&quot;</td>
<td>311-339-33</td>
<td>0.7µm</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Metric</th>
<th>Inch</th>
<th>Double faced model</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nominal length</td>
<td>Order No.*</td>
<td>Straightness</td>
</tr>
<tr>
<td>16&quot;</td>
<td>311-352-33</td>
<td>0.3µm</td>
</tr>
<tr>
<td>28&quot;</td>
<td>311-355-33</td>
<td>0.5µm</td>
</tr>
<tr>
<td>40&quot;</td>
<td>311-357-33</td>
<td>1.0µm</td>
</tr>
<tr>
<td>52&quot;</td>
<td>311-359-33</td>
<td>1.5µm</td>
</tr>
</tbody>
</table>

Technical Data
Provided with inspection certificate.

Cross section
Double faced type
Lapped surface
W
H
Lapped surface
Gradiation
W
22.5
Square Master
SERIES 311 — Squareness / Straightness Measuring Instrument

FEATURES
- Squareness (perpendicularity) and straightness measurements can be performed accurately and efficiently by moving a lever.
- With a dial test indicator for reading displacements.
- Its own squareness is adjustable for high accuracy measurement.

Optional Accessory
- Riser blocks (see page E-27.)*
- 517-665: Granite square, 45 (W) x 140 (D) x 280 (H) mm
- 900571: Adjustable holder
- 900551: Extension holder
- 900565: Feeler**
*Not available for 450mm model.
**Adapter (902803) is required for metric model.

Adjustable holder
No.900571

Extension holder
No.900551

Feeler
No.900565

SPECIFICATIONS

<table>
<thead>
<tr>
<th>Vertical travel</th>
<th>Order No.</th>
<th>Squareness</th>
<th>Straightness</th>
<th>Mass (kg)</th>
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<tbody>
<tr>
<td>150mm</td>
<td>311-215</td>
<td>3µm</td>
<td>2µm</td>
<td>13.7</td>
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<tr>
<td>250mm</td>
<td>311-225</td>
<td>6µm</td>
<td>2.5µm</td>
<td>16.2</td>
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<tr>
<td>450mm</td>
<td>311-245</td>
<td>9µm</td>
<td>3.5µm</td>
<td>24</td>
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