

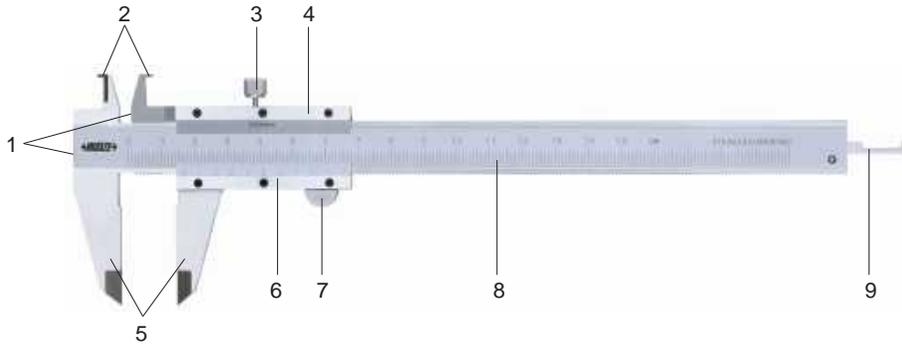


OPERATION INSTRUCTION

Inside Groove Vernier Caliper

Caution: Do not measure the workpiece if it is rotating, this is dangerous and measuring faces will be worn out.

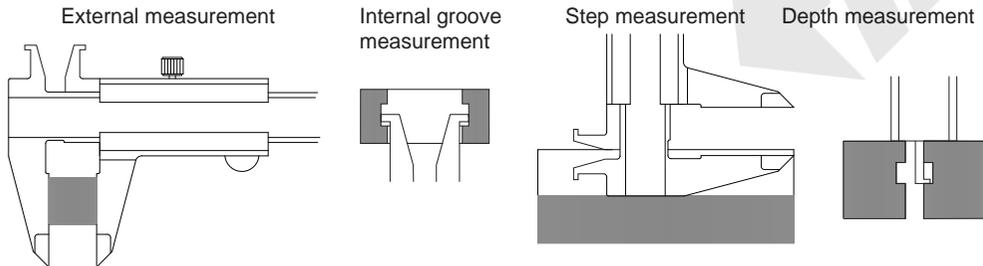
Code	Graduation	Range of upper jaw	Range of lower jaw	Accuracy
1291-150	0.02mm	8-150mm	0-150mm	±0.03mm



- 1-Step measuring faces
- 2-Internal groove measuring jaws
- 3-Locking screw
- 4-Slider
- 5-External measuring jaws

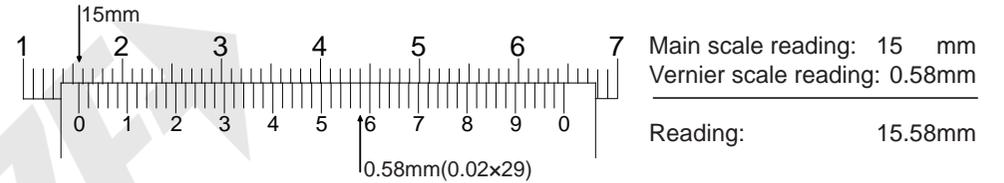
- 6-Vernier with vernier scale
- 7-Thumb clamp
- 8-Beam
- 9-Depth measuring bar

1. Measurement



- 2. Please clean the measuring faces and beam with soft cloth, then close the external jaws, make sure that the zero lines of the vernier and main scales coincide and there is no slit observed between the jaws against the light.

- 3. To get accurate measurement, it is necessary to control the force. During measurement, please always apply constant and proper force on the thumb clamp. The measuring jaws should "hold" the workpiece and can still "slide" on the workpiece.
- 4. The reading is obtained by adding the reading of the vernier scale to that of the main scale. Take the vernier scale reading at the graduation which coincides with the one on the main scale. Details please refer to following figures.



5. Notice:

- When reading, the line of sight should be perpendicular to the scale line.
- When measuring, make sure to use the entire measuring surface of the measuring claw. Regardless of measuring the external and internal dimensions, do not use only partial measurement surfaces of the measuring claw for measurement. Using only partial measuring surface of the measuring claw to measure not only accelerates the wear of the measuring claw, but also generates significant measurement errors. When measuring the external dimensions, swing the caliper to find the minimum size; When measuring the internal dimensions, swing the caliper to find the maximum size.
- Do not use the tip of the measuring claw as a scribe, compass, or screwdriver.
- Avoid placing the product in the air with moisture to prevent rustiness, oil it after use.

MN-1291-C/E

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