OPERATION INSTRUCTION
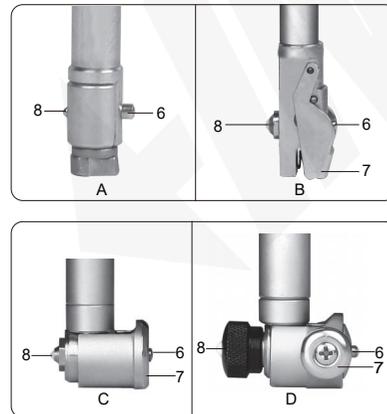## Precision Bore Gauges

Caution: Prevent liquid from getting into digital indicator to damage electronics.
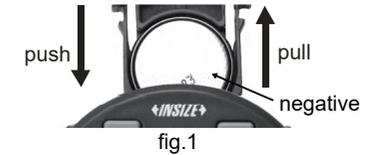
Code	Range	Indictor
2153-10	6-10mm	
2153-18	10-18.5mm	
2126-35	18-35mm	
2126-60	35-60mm	digital indicator with data transmission indication range12.7mm/0.5" adjustable resolution 0.001mm/0.00005" (code2108-101F)
2126-100	50-100mm	
2126-160	50-160mm	
2126-161	100-160mm	
2126-250	160-250mm	
2126-450	250-450mm	
2527-800G	400-800mm	

1-Battery cover
2-LCD display
3-Output
4-Buttons
5-Main pole
6-Contact point
7-Protect bridge
8-Anvil
9-Extension rod
10-Washer
11-Data transmission indication

Contact points

A   B   C   D

1. Install and remove battery(CR2032), the negative side of battery should face out(fig.1).

2. Display can be rotated by 320°.

push   pull

negative

fig.1

3. Buttons: Long press: long press than 2 seconds; short press: less than 2 seconds.

ZERO/CAL--- For calibration in tracking mode.
   --- Short press to set zero in absolute measuring mode
DATA --- Short press to data transmission.
START --- Short press(after calibration) to enter into measuring mode.
   --- Long press for metric and inch conversion.
MIN/SET --- Short press to enter into minimum reading tracking mode, "MIN" blinks. Short press again to exit and "MIN" disappears.
   --- Long press to enter into initial reading set mode, "SET" appears and the last digit blinks.
   Short press "ON/OFF" button to positon the digit and the digit blinks when it is positioned. Short press "START" button to change the digit from 0 to 9. After finishing setting, long press "ABS" button to exit set mode and saving the setting, long press "ON/OFF" button can exit set mode without saving the setting.
ON/OFF --- When display is on: short press to turn off display.
   --- When display is off: short press to turn on display

Shutdown time setting:
After shutting down, press and hold the MIN/SET button, short press the ON/OFF button to turn on, enter the shutdown time mode setting, the default display is "06", which means it will automatically shut down after 6 hours of standing, short press MIN/SET The key can switch the value, long press MIN/SET button to switch bits, and it can switch between 0 and 99 hours every 1 hour, Short press ON/OFF to confirm and exit.
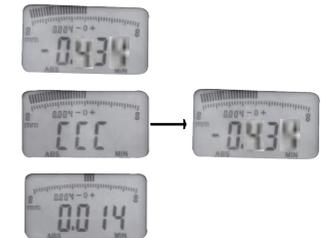When the switch display is "00", it means that the gauge will not automatically shut down.

4. Measurement(take 2126-60, Ø35mm setting ring as example):
(1) Relative measurement
---Short press "ON/OFF" button to turn on display.

---Insert the bore gauge into setting ring, short press "MIN/SET" button, "MIN" blinks and enter into minimum reading tracking mode and sway the bore gauge for several times, the bore gauge will find the minimum reading automatically, and "MIN" stop blinking.

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--- Take out the bore gauge and then long press "ZERO/CAL" button, "CCC" appears then disappears, calibration is finished.

--- Insert the bore gauge into workpiece, short press "START" button, "MIN" blinks and enter into measuring mode and sway the bore gauge, the bore gauge will find the minimum reading automatically.

--- The reading is the difference between the measured diameter and setting ring. If the reading is minus, the diameter is smaller than the setting ring. Otherwise, the diameter is larger than setting ring. The diameter of above figure should be 35.014mm.

--- Take out bore gauge and insert the bore gauge into workpiece, then short press "START" button, "MIN" blinks and start next measurement.

--- To exit measuring mode, please short press "MIN/SET" button. It is necessary to do calibration before new measurement.

(2) Absolute measurement
--- Set the initial reading same as the diameter of setting ring, please refer to the instruction of "MIN/SET" button.

--- Insert the bore gauge into setting ring, short press "MIN/SET" , "MIN" blinks and the bore gauge enter into minimum reading tracking mode and sway the bore gauge, the bore gauge will find the minimum reading automatically, and "MIN" stop blinking.

--- Take out the bore gauge and then long press "ZERO/CAL", "CCC" appears, then disappears, calibration is finished.

--- Insert the bore gauge into workpiece, short press "START" button, "MIN" blinks and the bore gauge enter into measuring mode and sway the bore gauge, the bore gauge will find the minimum reading automatically.
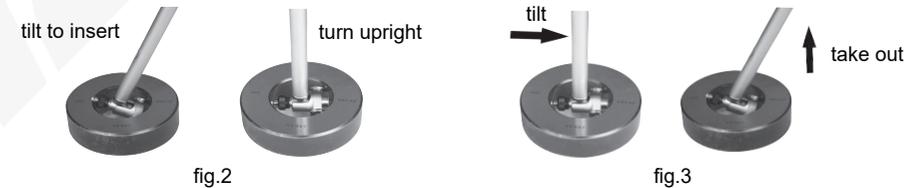
--- The reading is the diameter of the measured workpiece. The diameter of above figure should be 35.014mm.

--- Take out bore gauge and insert the bore gauge into workpiece, then press "START" button, "MIN" blinks and start next measurement.

--- To exit measuring mode, please short press "MIN/SET" button. It is necessary to do calibration before new measurement.

Caution: The contact point should be protected from being pressed improperly, please follow figure 2 and 3 about how to insert and take out bore gauge. Let the bore gauge tilt to insert into the workpiece or setting ring(fig.2), the protect bridge contact with the inwall first and then turn the bore gauge upright slowly(let the anvil contact with the inwall firstly, then let the contact point contact with the inwall). Let the bore gauge tilt to take out of the workpiece or setting ring(fig.3), do not press the contact point.

tilt to insert   turn upright   tilt   take out

fig.2   fig.3

5. Automatic power off in about 2 hours, press "ON/OFF" button to turn on display, not need to calibrate again turn on display.

6. Optional accessories: SPC cable, setting ring(6312).

7. The battery life is about 6 months. If there is nothing on display or digits blurr, battery is too low, please replace battery. If digits do not change when buttons are pressed or contact point is moved, please take out battery and put it back after 1 minute. If the bore gauge is not used for a long time, please remove the battery. Otherwise, liquid may leak from the battery and damage the digital indicator.

8. Working temperature is 0-40°C, relative humidity should not exceed 80%.

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