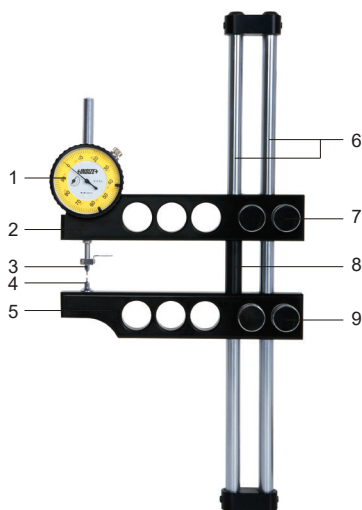


Code	Range(L)	Dial indicator stroke	Graduation	Accuracy
2230-10	0-10"/0-254mm	0.5"	0.001"	0.0015"
2230-45	1-4 1/2"/25.4-114.3mm	0.5"	0.001"	0.0015"
2230-16	8-16"/203.2-406.4mm	0.5"	0.001"	0.0015"
2230-20	8-20"/203.2-508mm	0.5"	0.001"	0.0015"



- 1-Dial indicator
- 2-Upper arm
- 3-Movable point
- 4-Fixed point
- 5-Lower arm
- 6-Sliding rods
- 7-Locking screws
- 8-Limit protection sleeve
- 9-Locking screws

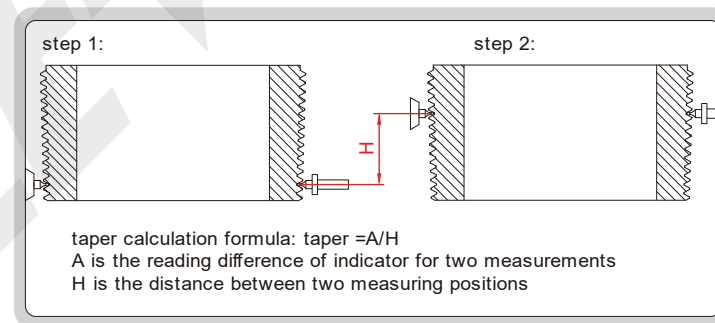
1. Measure the taper of external thread.

2. Measurement:

- Mark the measured thread and determine the measuring position.
- Select the appropriate thread points according to the type of thread to be tested and the number of threads per inch (refer to the table of thread ball points)
- Loosen the locking screws, adjust the upper/lower arm to the diameter position of the external thread, and then lock and fix it, place the fixed point in the groove of the first (or last) tooth of the complete thread, place the movable point in the alveolar opposite to the same tooth diameter, and dial indicator needs to reserve a certain amount of preload.
- Fixed point remains fixed, and the movable point swings in a small arc in the alveolar, after finding the maximum reading position, turn the dial indicator ring to coincide with the maximum reading position, lock the dial indicator ring and complete the measurement steps.

- Repeat the above measurement steps along the marked position on the measured thread and record the reading of the dial indicator.
 - The difference between the two measuring positions of the dial indicator is the taper value of the measured thread in this interval.
 - Compare the calculated taper value with the measured thread standard taper value to determine whether the thread taper is qualified.
- For example, the measured thread is 1:16 round thread, with 8 teeth per inch, two measuring marks are made on the measured thread, and the screw teeth at the two marked points are 4 teeth apart, the dial indicator difference between the two measuring positions is 0.032in (A), the distance between the two measuring points is 4/8in (H), the taper is $0.032/0.5=0.064$, it can be compared with the standard taper (0.0625) of 1:16 round thread tested.

principle of measurement



3. Matters needing attention:

- Pay attention to product protection after measurement. If it is not used for a long time, it should be stored.
- Oil shall be applied for protection during long-term storage to avoid rusting of products.

ball points

Code	Thread type	Threads per inch	Ball dia. (Ød)
6252-B8	round thread, line pipe	8	1.829mm
6252-B10	round threadline pipe	10	1.448mm
6252-B115	line pipe	11.5	1.27mm
6252-B14	line pipe	14	1.041mm
6252-B18	line pipe	18	0.813mm
6252-B27	line pipe	27	0.533mm
6252-B5	buttress thread	5	2.286mm
6252-B52	extreme line thread	5, 6	1.524mm