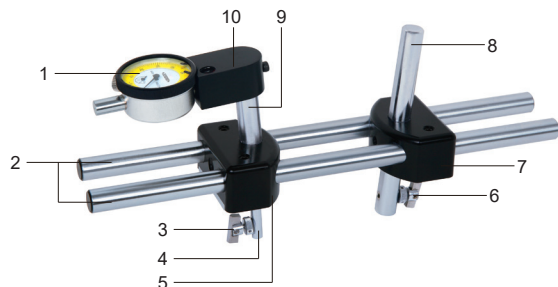


Internal Thread Crest Diameter Measuring Instruments

Code	Range	Dial indicator stroke	Dial indicator graduation	Accuracy
2237-5	23/8-5 1/2"/60.325-139.7mm	5mm	0.01mm	0.02mm
2237-5E	23/8-5 1/2"/60.325-139.7mm	0.25"	0.0005"	0.0008"
2237-20	41/2-20"/114.3-508mm	0.50"	0.0005"	0.002"



- 1-Dial indicator
- 2-Guide arm
- 3-Movable point
- 4-Swinging rod
- 5-Guide block
- 6-Fixed point
- 7-Guide block
- 8-Lower measuring arm
- 9-Upper measuring arm
- 10-Installing holder

1. Measure the crest diameter of internal thread with nominal larger than 2 3/8"(60.325mm) and less than 20"(508mm).

2. Measurement:

- Check the sliding performance of the guide block and guide arm, as well as the locking degree of the locking screws between the guide block and the upper and lower arms. The sliding performance can be adjusted through screws. Check whether the dial indicator is flexible when pushing the measuring rod again, and whether the dial indicator swings flexibly.
- Loosen the locking screw on the side of the guide block, place the height standard between the guide block base plate and the point. By adjusting the height of the point and sliding the lower measuring arm, make the end face of the height standard tightly fit with the guide block base plate and the side face of the point. Tighten the screw and remove the height standard (Fig 1)
- Complete the height setting of the upper measuring arm and point in the same way, and then place the height standard back into the packaging box (Fig 2)



Fig.1



Fig.2

- Complete the height setting of the upper measuring arm and point in the same way, and then place the height standard back into the packaging box (Fig 2)
- Loosen the locking screw above the guide block, place the zero standard block between the two points, adjust the guide block to leave an appropriate amount of preload on the dial indicator, lock the screw, rotate the zero position of the dial on the dial indicator to coincide with the pointer, and lock the bezel; After calibration, remove the zero standard block and place it back in the packaging box (Fig 3)
- Place the two points of the set internal thread crest diameter measuring instrument in close contact with the top of the measured internal thread, place the bottom plate of the guide block tightly against the end face of the threaded pipe, and use the point on the lower measuring arm as the fulcrum. Rotate the measuring instrument on both sides of the horizontal position, and record the deviation value at this time when the pointer rotates in the opposite direction after a certain graduation line (Fig 4); Rotate the measuring instrument 90 degrees to measure again, and record the deviation value when the pointer rotates in the opposite direction after a certain reticle is turned;

Take the average of the two deviation values as the top diameter deviation, and multiple positions can be selected for measurement to make the measurement results more accurate.



Fig. 3

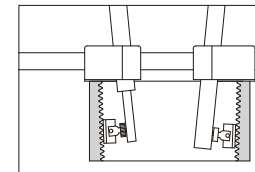
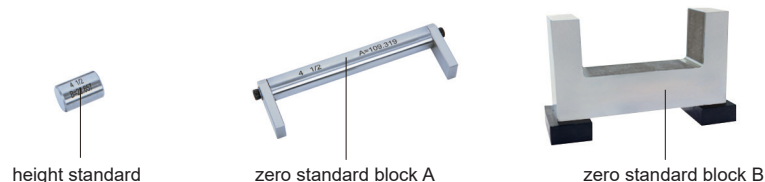


Fig. 4

3. Height standard and zero standard block(optional)



Code	Remark
2237-G□□□*	including height standard and zero standard block A (without taper)
2237-K□□□*	including height standard and zero standard block B (with taper)

* Can be customized according to workpieces

4. 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.