OPERATION INSTRUCTION

Digital Thread Height Measuring Instrument

Caution: Prevent liquid from getting into indicator to damage electronics.

Code	Range (L)	Resolution	Accuracy
2242-35	0-3.5mm/0-0.135"	0.01mm/0.0005"	0.02mm

1-Digital indicator
2-Measuring base
3-Measuring tip

1. Measure the height of external thread and internal thread with nominal diameter larger than 5 1/2" (139.7mm)

2. Measurement proofreading and use:

---Select the appropriate thread height standard blocks on the measured thread taper and the number of teeth per inch (refer to the standard block table)

---Press the measuring seat of the thread height measuring instrument so that its measuring tip is placed in the U-shaped groove of the corresponding standard block (fig 1). The measuring seat should be tightly attached to the top surface of the adjacent standard block, and the digital indicator should be set to zero

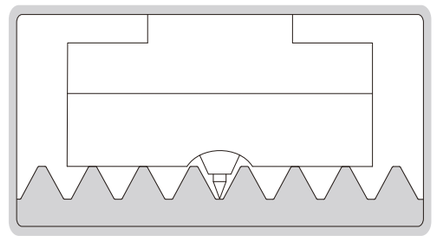
---Place the measuring tip of the thread height measuring instrument in the V-shaped groove of the standard block (fig 2), and the reading of the digital indicator should be the same as the value of the U-shaped groove. If the reading is different, the value change should not exceed 0.01mm. If it is greater than 0.01mm, it indicates that the gauge head is worn or damaged, and it needs to be replaced

---Place the tip of the calibrated thread height measuring instrument in the groove of the thread to be measured, and the measuring seat should be close to the adjacent thread crown. Then, the measuring instrument should swing in small arcs on both sides perpendicular to the cone. The maximum negative or minimum positive value of the digital indicator is the height error of the thread

fig 1(U-groove proofreading)

fig 2(V-groove proofreading)

measuring principle



3. Install and remove battery(CR1632), the negative side of battery should face out(fig.3).

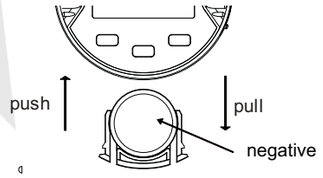


fig.3

4. Buttons:

'in/mm'--- short press for inch/metric conversion
long press to change measuring direction
'ABS' --- short press for absolute/incremental measurement
long press to preset data
'0/ON'--- short press to turn on when power is off
short press to set zero when power is on
long press to turn off

High and low frequency switching settings:
After shutting down, press and hold the in/mm key, and shortly press the 0/ON key to turn on, after displaying "----", release the in/mm key to enter the high and low frequency switching mode setting, short press the in/mm key to adjust the switching mode, display "Fr-on" means that the automatic frequency switching function is turned on. After 3 seconds without button operation and push rod operation, it will automatically switch to high frequency. Display "Fr-oF", which means that the automatic frequency switching function is turned off, and the sensor keeps the high frequency state unchanged. Short press the 0/ON button to confirm and save the high and low frequency switching mode settings, and exit to the working state.

Shutdown time setting:
After shutting down, press and hold the ABS button, short press the 0/ON button to turn on, after displaying "----", release the ABS button to enter the shutdown time mode setting, the default display is "6.0", which means it will automatically shut down after 6 hours of standing, short press ABS The key can switch the value, and it can switch between 0 and 6 hours every 0.5 hour. When the switch display is "0.0", it means that the gauge will not automatically shut down.

5. Matters needing attention：

---Pay attention to product protection after measurement. If it is not used for a long time, itshould be stored.

---Oil shall be applied for protection during long-term storage to avoid rusting of products.

thread height standard blocks

Code	Taper	Number of thread per inch
6250-4	1:4	4
6250-5	1:4	5
6250-8	1:16	8, 10
6250-51	1:16	5

MN-2242-C/E
V0