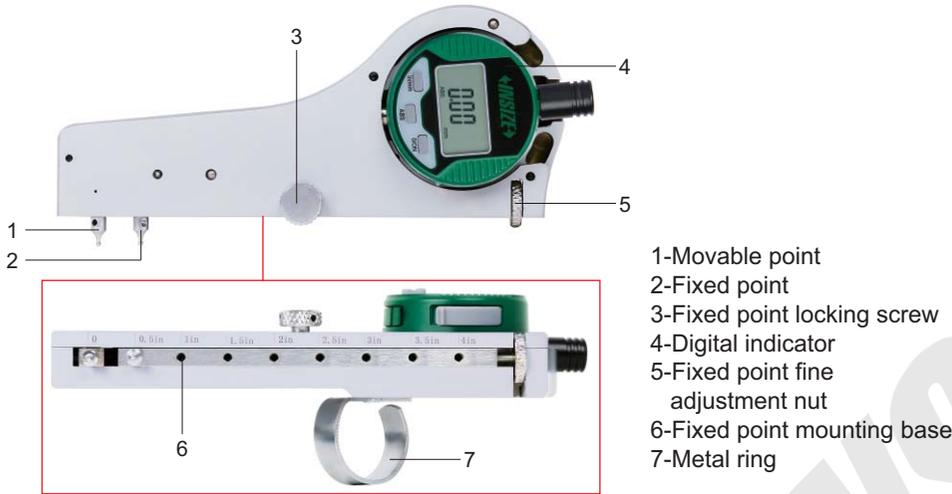# OPERATION INSTRUCTION
Internal Thread Crest Diameter Measuring Instruments

Code	Range (L)	Digital indicator stroke	Resolution	Accuracy
2245-4	0.5-4"/12.7-101.6mm	0.2"/5mm	0.0005"/0.01mm	0.02mm

1-Movable point
2-Fixed point
3-Fixed point locking screw
4-Digital indicator
5-Fixed point fine
   adjustment nut
6-Fixed point mounting base
7-Metal ring

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

2. Install and remove battery(CR1632), the negative side of battery should face out(fig.1).

push   pull

negative

fig.1
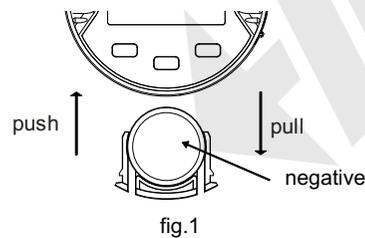
3. Buttons:
   'in/mm'--- short press for inch/metric conversion
              long press to change measuring direction
   'ABS' --- short press for absolute/incremental measurement
              long press to preset data
   '0/ON'--- short press to turn on when power is off
              short press to set zero when power is on
              long press to turn off

4. Measurement:
   ---Select a suitable thread point based on the type of thread being tested and the number of threads per inch (refer to the thread ball points table).
   ---Loosen the fixed point locking screw, rotate the fixed point fine adjustment nut at the tail, and adjust the position of the fixed point
      Place the two measuring points into the slots corresponding to the pitch standard block, so that the spherical outer circles of the two measuring points are tightly attached to the protective plate. After adjustment, tighten the fixed point locking screw
   ---Keep the fixed point fixed, and make a small swing of the movable point in the standard block groove to find the smallest point. Set the digital indicator to zero and complete the calibration
   ---Place the two end measuring points of the calibrated pitch measuring instrument in the tested thread groove to keep the fixed point fixed. The movable point swings in a small arc in the thread groove, and the minimum positive reading or maximum negative reading on the digital indicator is the pitch error of the tested thread

application

step 1: set zero on standard block   step 2: measurement
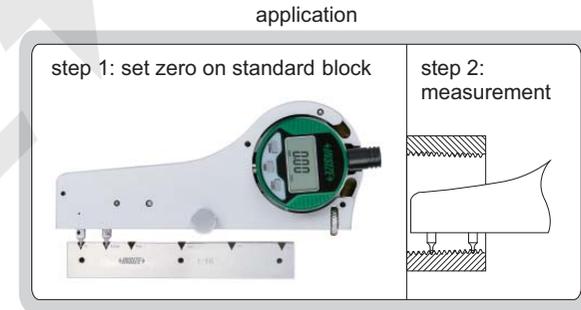
4. Matters needing attention:
   ---Pay attention to product protection after measurement. If it is not used for a long time, it should be stored.
   ---Oil shall be applied for protection during long-term storage to avoid rusting of products.

Ball points

Code	Thread type	Threads per inch	Ball dia. (Ød)
6252-B8	round thread, line pipe	8	1.829mm
6252-B10	round thread, line 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-B51	buttress thread	5	1.575mm
6252-B53	extreme line thread	5	2.667mm *
6252-B6	extreme line thread	6	2.210mm *

*0. 58mm off the top of ball

MN-2245-C/E

V0