OPERATION INSTRUCTION

Comparison Gauges

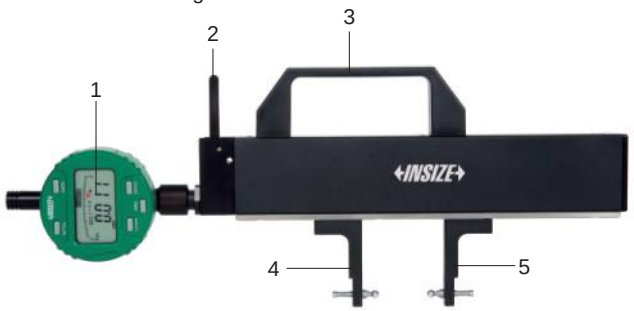
Measure external diameter

Code	Range of external diameter (L1)	Accuracy*	Repeatability
2252-101	25-90mm/1-3.54"	±5μm	1μm
2252-102	25-140mm/1-5.51"	±5μm	1μm
2252-110	25-90mm/1-3.54"	±5μm	2μm
2252-120	25-140mm/1-5.51"	±5μm	2μm

Measure internal diameter

Code	Range of external diameter (L2)	Accuracy*	Repeatability
2252-201	42-105mm/1.65-4.13"	±5μm	1μm
2252-202	42-160mm/1.65-6.30"	±5μm	1μm
2252-210	42-105mm/1.65-4.13"	±5μm	2μm
2252-220	42-160mm/1.65-6.30"	±5μm	2μm

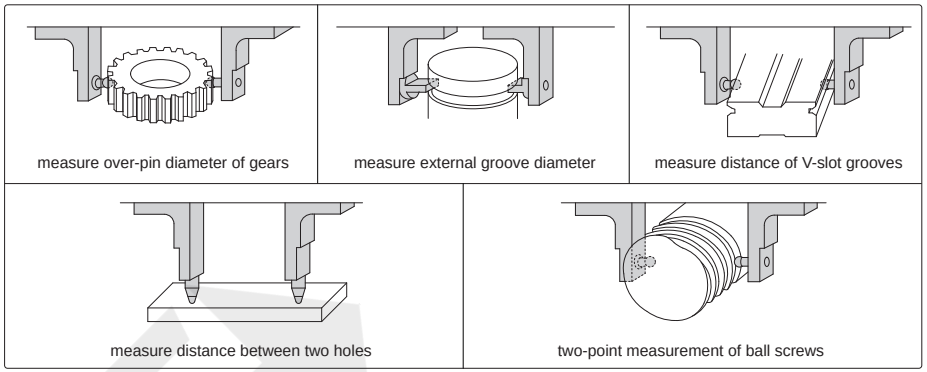
*Within ±2mm effective range



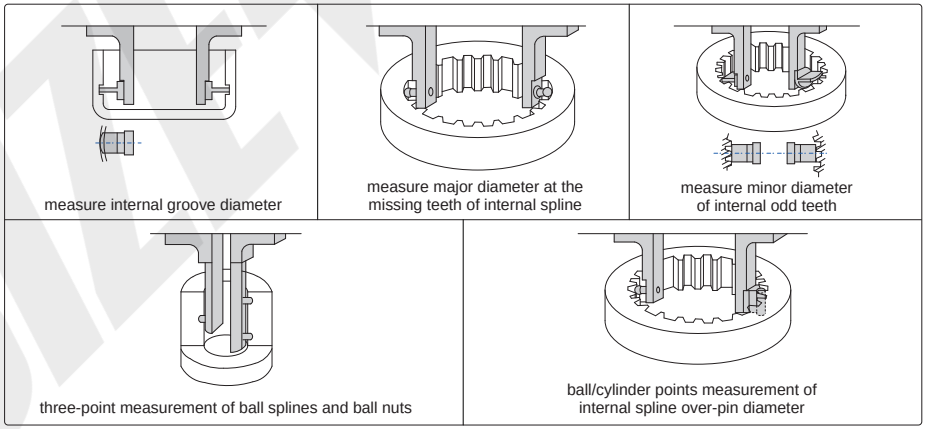
1-Dial indicator
2-Fork
3-Handle
4-Movable measuring jaw and point
5-Fixed measuring jaw and point (adjustable position)

1. Measure external diameter, internal diameter and over-pin diameter of gears.
   total range of movable point: 8mm, effective range of movable point: ±2mm
2. Measurement use：
   --- Before measurement, wipe the gauge point and adjust it to the desired measurement state.
   --- Adjustable movement of the fixed measuring jaw by means of an Allen key.
   --- Calibration of the gauge using a standard gauge that approximates the size being measured.
   --- Measurement of the workpiece, the dial indicator reads the difference between the measured size and the standard gauge size.
3. Measuring jaws and points can be customized：
   ---Measuring jaws and points can be customized according to measurement requirements
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.

external diameter measurement application



internal diameter measurement application



5. Adjustment of Probe Coaxiality:
   ---Loosen the probe and the adjusting nut.fig 1
   ---Adjust the two probes until they are visually aligned in a straight line.fig 2
   ---Tighten the adjusting nut to lock the probe in place.fig 3

fig 1

fig 2

fig 3

MN-2252-E

V1