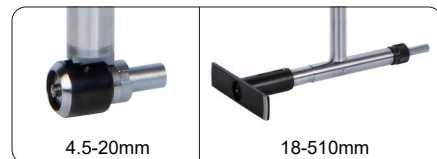


**Caution: Measuring head and main pole are not separable**

Code	Range	Accuracy	Repeatability
2425-6	4.5-6mm	2μm	0.5μm
2425-8	6-8mm	2μm	0.5μm
2425-12	8-12mm	2μm	0.5μm
2425-20	12-20mm	2μm	0.5μm

Code	Range	Accuracy	Repeatability
2422-35	18-35mm	4μm	2μm
2422-60	35-60mm	4μm	2μm
2422-150	50-150mm	4μm	2μm
2422-300	150-300mm	4μm	2μm
2422-510	280-510mm	3μm	1.5μm
2422-800	400-800mm	3μm	1.5μm

#### 2435

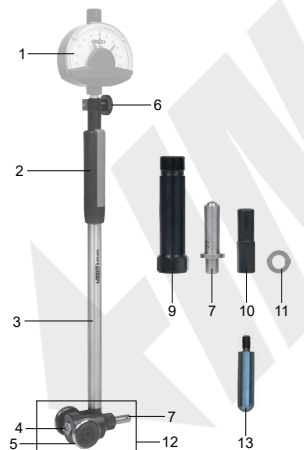
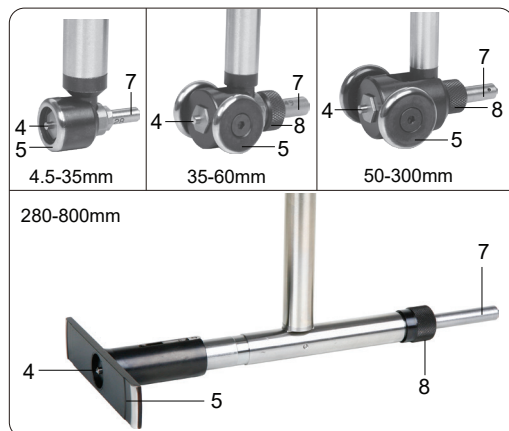


4.5-20mm

18-510mm

Code	Range
2435 Series	4.5-510mm

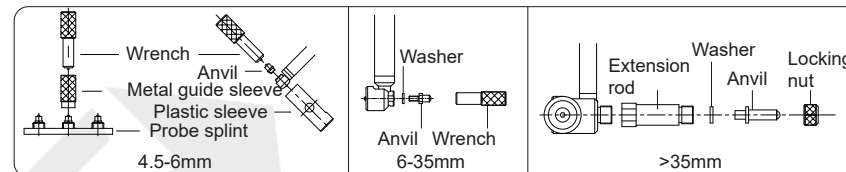
#### 2422 and 2425



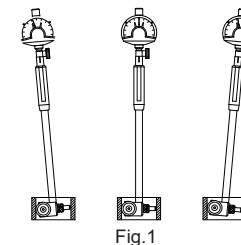
- 1-Dial indicator (not included)
- 2-Handle
- 3-Main pole
- 4-Contact point
- 5-Protect bridge
- 6-Locking device

- 7-Anvil
- 8-Locking nut
- 9-Extension rod (≥50mm)
- 10-Wrench (≤35mm)
- 11-Washer
- 12-Measuring head
- 13-Extended contact point for dial indicator

1. The bore gauge used to compare measurement. It is mainly for measuring internal diameter size.
2. Usage:
  - (1)Set size: Choose anvil, extension rod and washer according to the size of workpiece, then install them as follow figures, please make each part be installed steadily. Use wrench to tighten the anvil when range is less than 35mm. Press contact point several times after installation, the pointer of indicator move smoothly, flexibly.



- (2)Set calibration size: Select setting ring, outside micrometer, or standard hole with known diameter and accuracy, clean measuring faces with soft cloth.
- (3)Set zero (as setting ring gauge for a example): Insert the bore gauge into setting ring and sway the bore gauge wiggly (fig.1), to find the 'turning point' of the pointer. Adjust indicator to make 'zero line' coincide with 'turning point'. Sway the bore gauge wiggly several times to make sure the 'zero line' coincide with the 'turning point'.



- (4)Measuring: Insert the bore gauge into workpiece and sway it wiggly several times to find the 'turning point' of the pointer. Get the result, the reading is deviation from the normal value.
3. Optional accessories: setting ring, long handle, dial indicator or dial comparator.
4. Notes:

- Please do not insert the bore gauge into workpiece or setting ring from the anvil side. It is necessary to press the contact point and protect bridge into setting ring or workpiece firstly, then make the anvil contact with the inwall and turn the bore gauge upright slightly.
- Do not strike the gauge or allow it to be struck.
- The gauge, setting ring and workpiece should be temperature balanced before calibration.

