

Reading show movement value of probe,
for example,if probe moves 0.01mm, reading changes 0.01mm (2 graduations)

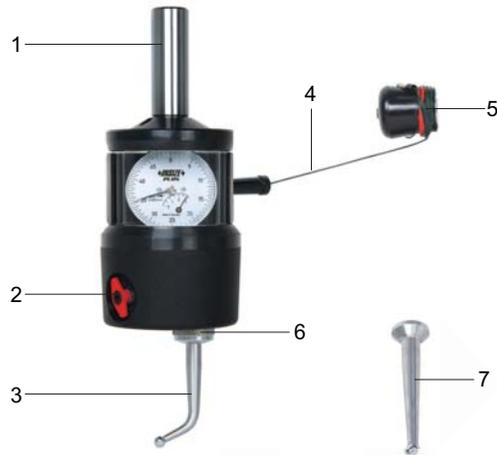
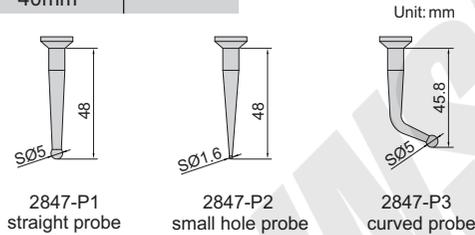
Code	Graduation	Travel
2847-3	0.005mm	2.5mm

Specification of probe

Description	Measurement type	Diameter measurement	Depth measurement	Accuracy
straight probe (included)	hole center	Ø6-125mm	55mm	0.005mm
	squareness	Ø120-160mm	40mm	
small hole probe (optional)	small hole center	Ø2-125mm	55mm	0.005mm
	squareness	Ø120-160mm	40mm	
curved probe (included)	shaft center	Ø0-125mm	55mm	0.005mm
	squareness	Ø120-160mm	40mm	

Probe (optional)

Code	Description
2847-P1	straight probe
2847-P2	small hole probe
2847-P3	curved probe



- 1-spindle
- 2-adjust knob (switch shaft/hole measurement)
- 3-curved probe (included)
- 4-rope (fix dial direction)
- 5-magnetic base (can attach on metal surfaces)
- 6-locknut
- 7-straight probe(included)
- 8-hexagon wrench



- Provides quick and accurate shaft/hole centering in boring and milling set-up, can also measure squareness between workpiece and spindle.
- Installation of probe:
Place the stylus in the locknut (Figure 1), install it on the gauge, and tighten the locknut.

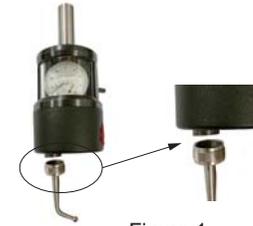


Figure 1

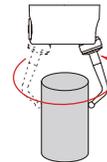


Figure 2

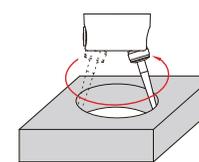
- Before measurement, wipe the probe and the measured workpiece with a clean soft cloth to avoid affecting the measurement results.
- Measurement:
 - Clamping the gauge: The gauge is clamped on the machine by the spindle.
 - Clamping magnetic base: Connect the gauge to magnetic base with rope. the magnetic base can be adsorbed on the metal surface, which is used to fix the gauge in measurement, so that the dial face of the gauge is always in one direction to easy to read.
 - Change shaft/hole measurement by adjusting the knob.
 - Estimate the center of the workpiece, move the table so that the center of the workpiece is vertically aligned with the spindle of the machine.
 - Loosening the locking screw (Figure 2) allows the probe position to be adjusted to suit the diameter of the workpiece, so that the probe is in contact with the wall of the workpiece being measured and the gauge has a certain amount of preload.
 - Rotate the machine spindle, observe the rotation of the gauge pointer, adjust the table position so that the rotation of the gauge pointer becomes smaller and smaller, and when the pointer basically coincides with the "0" scale, the center of the workpiece is coaxial with the spindle.

Attention:

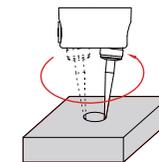
Make sure the magnetic is fixed firmly during the measurement.
Control the spindle speed (50-100rpm, not more than 150rpm), too high speed will accelerate the wear of the probe and may damage the internal components of the gauge.



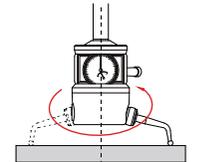
Finding the center of a shaft



Finding the center of a hole



Finding the center of a small hole



Measure the perpendicularity between workpiece and spindle

- Avoid impacts and knocks during use, and do not operate with excessive force. After use, remove the stylus and protect it with oil.

MN-2847-C/E

V1