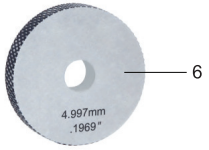
OPERATION INSTRUCTION

Digital Internal Chamfer Gages

Code	Range	Resolution
2942-20	0.5-20.1mm	0.01mm/0.0005"
2942-40	20-40mm	0.01mm/0.0005"
2942-203	0.5-20.1mm	0.01mm/0.0005"
2942-403	20-40mm	0.01mm/0.0005"



1-Indicator
2-Locking device
3-Zero initial value
4-Probe
5-Base
6-Setting gage(2942-20 and 2942-203are supplied)

1. Gage is used to measure end diameter of chamfer or taper holes.
2. Buttons:
Long press: longer than 2 seconds; short press: less than 2 seconds.
M/TOL
---Long press until "TOL" appears to enter tolerance measuring mode. Under this mode," ▶ " at the upper right corner blinks if the reading is larger than the upperlimit; " ◀ " at the top left corner blinks if the reading is less than the lower limit. Shortpress "M/TOL" button to exit tolerance measuring mode.
---Long press until "TOL" and " ▼ " appears to enter tolerance set mode. And thelast digit blinks. Short press "ZERO" button to position the digit, the digit blinkswhen it is positioned. Short press "in/mm" button to change the digit from 0 to 9.After setting the lower limit, short press "M/TOL" button, " ▲ " appears and the lastdigit blinks. Set the upper limit as setting the lower limit way. Short press "M/TOL"button to finish set and enter into tolerance measuring mode.If the lower limit is larger than the upper limit, "EEE" will appear and the digitalindicator enter into tolerance set mode again automatically.
---Short press, "MAX" appears and enter maximum reading tracking mode. Shortpress again, "MIN" appears and enter minimun reading tracking mode. Short pressfor the third time, "TIR" appears and to get the difference between the maximumand minimum reading of one measurement.
in/mm
---Short press for inch and metric reading conversion" appears, the value increases if
---Long press to change measuring direction." ▲ " appears, the value decreases if the spindle moves up." ▼ " appears, the value decreases if the spindle moves up.

ABS
---Short press for absolute and relative measuring mode conversion. The normal mode is absolute measuring mode("ABS" is on display). Short press the button to enter relative measuring mode at any point(this point is called "relative zero point"), "ABS" disappears and the reading is zero. In this mode, the reading is the distance to the "relative zero point". Press the button again to return back to absolute measuring mode.
---Long press to enter initial reading set mode. "SET" appears and the last digit blinks. Short press "ZERO" button to position the digit, the digit blinks when it is positioned. Short press "in/mm" button to change the digit from 0 to 9. Long press "ABS" button to exit set mode.

ZERO
---When display is powered on: short press to get initial reading on absolute measuring mode("ABS" is on display); long press to turn off display.
---When display is powered off: short press to turn on display.

DATA
---Short press for data port output current display value, When the transmission is successful, the LED light will be on once, but if the transmission is failed, the LED light will not be on.
---Long press for switch analog resolution.

3. Set zero:
Measuring range :0.5-20.1mm
---Zeroing with setting gage to prevent probe wear.Set the initial value of indicator consistent as the value of setting gage (see ABS buttonfunction), then put the gage into setting gage, the base and setting gage fit completely,press the "ZERO", the indicator value is the value of the setting gage.Measuring range :20-40mm
---Set the initial value of the indicator consistent as zero initial value(see ABS buttonfunction), then put the gage on the plate, the base and the plate fit completely (Fig.1),press the "ZERO", the indicator value is zero initial value(for example 0.19mm).

4. Measurement:
When the base of gage and workpiece fit completely, probe and hole contact completely(Fig.2), read reading(Pay attention to the measurement direction).

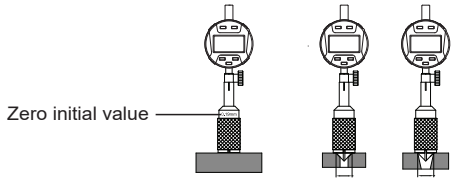


fig.1 fig.2

Note: Clean the measurement surface and the surface of the workpiece before set zero andmeasurement;Please do not crash probe and measure rotating tool.

5. Please oil probe and base to prevent rust after use.

6. Optional accessory:data output cable (code 7315-, 7302-, 7305-)

MN-2942-E
V4