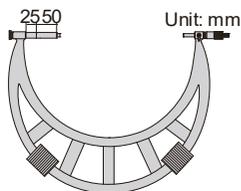
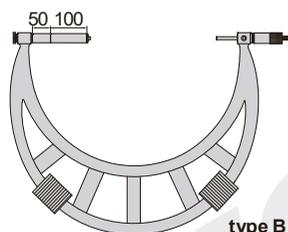


Graduation: 0.01mm

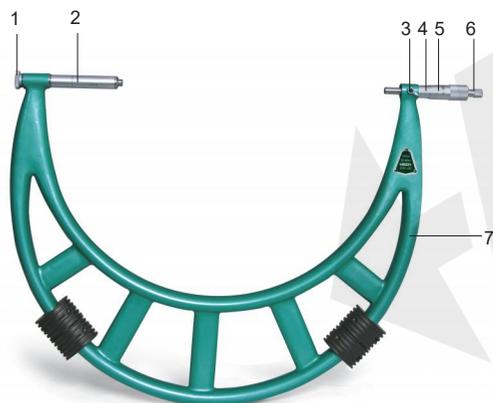
Code	Range	Type	Accuracy	Setting standard (included)
3205-400	300-400mm	A	11 μ m	325, 375
3205-500	400-500mm	A	13 μ m	425, 475
3205-600	500-600mm	A	14 μ m	525, 575
3205-700	600-700mm	A	16 μ m	625, 675
3205-800	700-800mm	A	18 μ m	725, 775
3205-900	800-900mm	A	20 μ m	825, 875
3205-1000	900-1000mm	A	22 μ m	925, 975
3205-1200	1000-1200mm	B	22 μ m	1050, 1150
3205-1400	1200-1400mm	B	24 μ m	1250, 1350
3205-1600	1400-1600mm	B	28 μ m	1450, 1550
3205-1800	1600-1800mm	B	31 μ m	1650, 1750
3205-2000	1800-2000mm	B	34 μ m	1850, 1950



type A



type B



- 1-Locking nut
- 2-Adjust collar
- 3-Locking screw
- 4-Sleeve
- 5-Friction thimble
- 6-Ratchet stop
- 7-Frame
- 8-Spanner
- 9-Guide sleeve
- 10-Setting standard

1. Calibration

- Choose suitable adjust collar and setting standard according to measuring range.
- Install adjust collar into micrometer, tighten locking nut.
- Loosen the locking screw and adjust the distance between the two probes to be slightly larger than the setting standard, put the setting standard into the micrometer. Turn the thimble to make the measuring surface of the micrometer close to the measuring surface of the setting standard. When it is about to contact, turn the ratchet force, and read after hearing the squeak. If the zero position has deviation, use the spanner to set zero.
- Micrometer should be checked regularly to ensure that the zero position is correct.

Zero adjustment method:

- Insert the spanner into the small hole of the sleeve (Fig.1), and turn the sleeve slightly until the zero mark of the friction thimble is aligned with the mark of the sleeve (Fig.2) to complete the calibration.

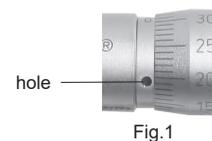


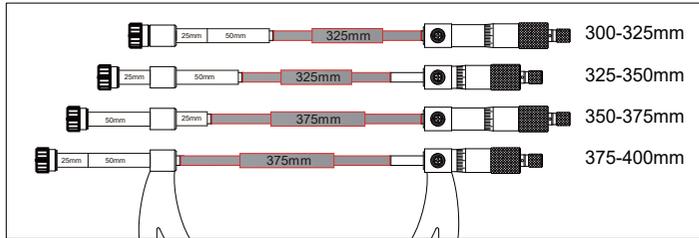
Fig.1



Fig.2

Note:

Micrometer is supplied with two setting standards, which can be shared in calibration. Take 3205-400 for example, it is supplied with setting standards 325mm and 375mm. 325mm is for range 300~325mm and 325~350mm. 375mm is for range 350~375mm and 375~400mm. Range 300~325mm/350~375mm is calibrated at micrometer end while range 325mm~350mm/375~400mm is calibrated at micrometer start.



5. After use, please apply oil for protection.

6. The support mode of the micrometer for zero setting shall be consistent with the actual measurement to avoid measurement errors caused by different influences of the self weight deformation of the frame.

2. Measurement:

When the measuring face is close to, but not in contact with the workpiece, rotate the ratchet stop until you hear click, but can not rotate friction thimble, which will damage the internal precision threads.

Caution:

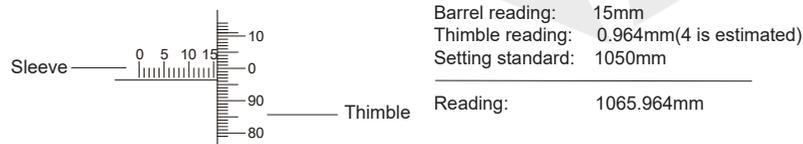
When the measuring faces is close to, but not in contact with the workpiece, do not apply excessive force to rotate the ratchet stop, as it will lead to inaccurate results and may damage the internal precision threads.

3. During reading, the line of sight is perpendicular to the scale, in order to avoid parallax . The reading is the sum of barrel, thimble, and setting standard. Results are as follows:



Reading: 331.333mm

type A



Reading: 1065.964mm

type B

Note:

If it is calibrated at micrometer end, the reading needs to be reduced by the stroke of micrometer.