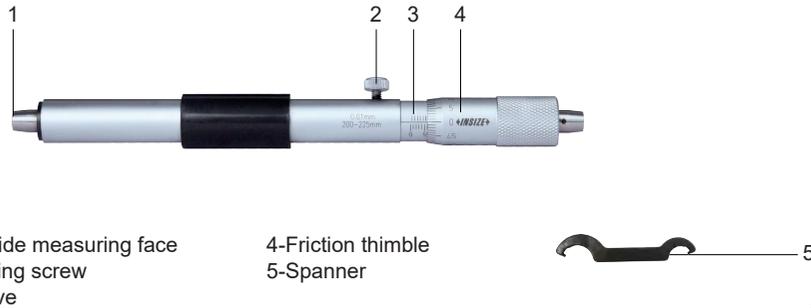


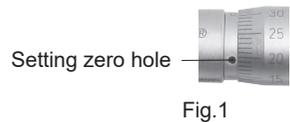
Graduation: 0.01mm
Travel of micrometer head: 25mm

Graduation: .001"
Travel of micrometer head: 1"



1. Micrometer is used to measure inside size

2. It is necessary to calibrate micrometer with cylindrical gage block or setting standard before measuring. Clean the measuring faces and internal blocks of gage block with soft cloth. Then use micrometer to measure gage block: rotate friction thimble to adjust the size to be less than gage block. Put fixed measuring face to contact gage block, rotate friction thimble slowly, meanwhile shake micrometer to find the minimum value when moving measuring face contacts gage block. If result is equal to the normal value of gage block, micrometer is ready to measure, otherwise, mark down the position of the zero scale points, take out micrometer, rotate friction thimble until zero scale points the mark as before. Tighten the locking screw, fasten the zero adjustment hole(Fig.1) with zero spanner, slightly rotate sleeve(Fig.2) until the zero scale on sleeve coincides with the scale on friction thimble. Loosen the locking screw, calibrate again to make sure the result is equal to the normal value of setting standard.



3. During measurement, make sure there are no cutting chips or other debris on both measuring faces and workpiece surface which will affect the result. Rotate friction thimble to set its size less than the hole's diameter, and then put micrometer into the hole. Put fixed measuring face to contact the measured hole, rotate friction thimble slowly, shake micrometer gently along hole's axial and radial to find the minimum value in axial direction(Fig.3) and the maximum value in radial direction(Fig.4), tighten the locking screw, take out micrometer to get the result.

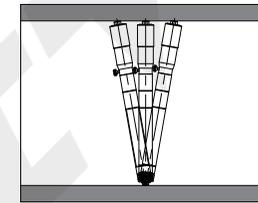


Fig.3

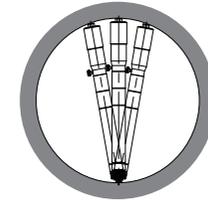
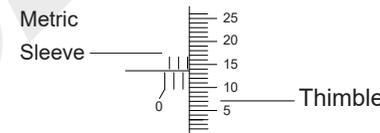
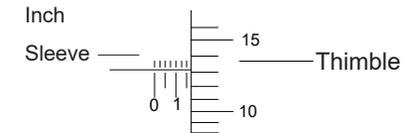


Fig.4

4. During reading, the sight is perpendicular to the scale to avoid parallax reading. The reading is the sum of a initial reading, sleeve, thimble. For example:



Initial reading: 200mm
Sleeve reading: 2.5mm
Thimble reading: 0.137mm(7 is estimated)
Reading: 202.637mm



Initial reading: 40"
Sleeve reading: 0.15"
Thimble reading: 0.0131"(1 is estimated)
Reading: 40.1631"

5. After use, please apply oil for protection

6. Optional accessory: gage block accessory(code 6881),cylinder gage block(code 4001), caliper/height gage checker(code 6884).