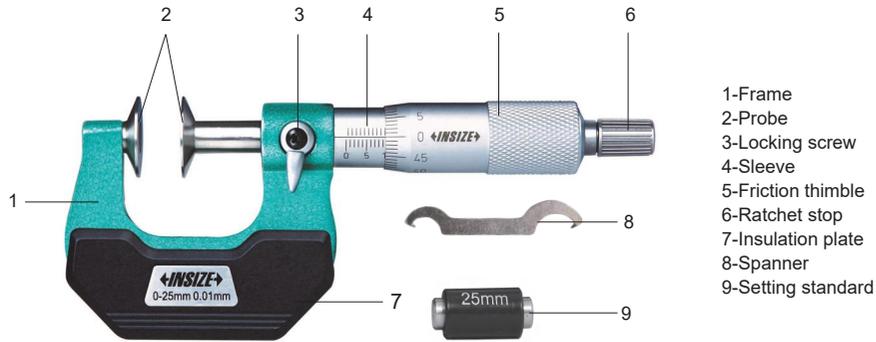


Graduation: 0.01mm



- 1-Frame
- 2-Probe
- 3-Locking screw
- 4-Sleeve
- 5-Friction thimble
- 6-Ratchet stop
- 7-Insulation plate
- 8-Spanner
- 9-Setting standard

1. The product is used to measure root tangent length of gear. Rotate ratchet stop one circle, probe moves 0.5mm.
2. Calibration before measurement:
 - Clean the measuring surface of probe and measuring surface of setting standard with a clean soft cloth;
 - 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.

Caution:

For 0-25mm disc micrometer, it is recommended to use 25mm setting standard for zero adjustment. The measuring point of the disk probe shall be consistent with the zero point as far as possible (the parallelism error of the disk micrometer is greater than that of the ordinary micrometer, and the inconsistency between the zero point and the measuring position will lead to the cumulative parallelism error of the measurement results)

Zero adjustment method:

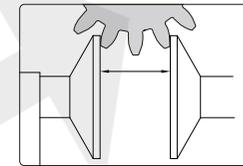
- Insert the spanner into the small hole of the sleeve, and turn the sleeve slightly until the zero mark of the friction thimble is aligned with the mark of the sleeve (Fig.1) to complete the calibration.



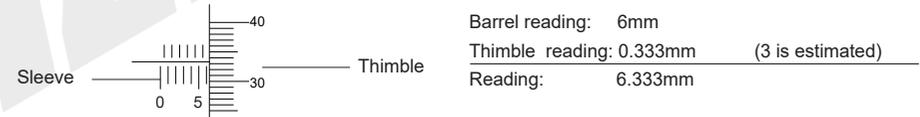
fig.1

3.Measurement:

- During measurement, ensure that the measuring surface of the micrometer and the measuring surface of the workpiece are clean, and burr or other sundries are not allowed, which will lead to measurement error.
- Adjust the size of the micrometer to be slightly larger than the measured workpiece, then put the measured workpiece into the micrometer, rotate ratchet stop, and read after hearing the squeak.



4. During reading, the line of sight is perpendicular to the scale, in order to avoid parallax. The reading is the sum of barrel, thimble, results are as follows:



5. Notice:

- During storage, there should be a gap of 0.1mm to 1mm between the measuring surfaces. Do not store the micrometer in a clamped state.
- The micrometer has been stored for a long time, and there is a protective oil film on the spindle. When using it, wipe the oil film on the spindle with a dust-free cloth.