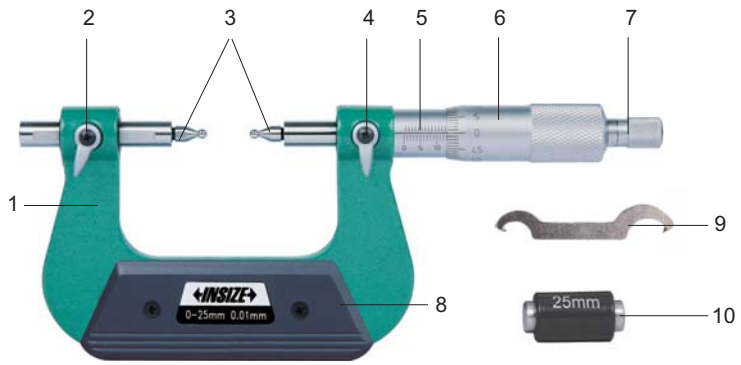
OPERATION INSTRUCTION
Gear tooth micrometers

Graduation: 0.01mm



1-Frame
2-Locking wrench for fixing probe
3-Probe (optional)
4-Locking screw
5-Sleeve
6-Friction thimble
7-Ratchet stop
8-Insulation plate
9-Spanner
10-Setting standard (except 0-25mm)

1. The product is used to measure over-pin diameter of gears.
2. Select the appropriate probe according to the gear module and install it.
3. 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 turn the friction thimble to make the zero line on the friction thimble coincide with the longitudinal engraved line on the sleeve, and make the edge of the friction thimble and the zero line on the sleeve tangent;
   --- Loosen the locking wrench of fixing probe, push the measuring rod to make the two probes contact, and tighten the locking wrench of fixing probe. Loosen the locking wrench, turn the ratchet stop and check the zero position adjustment. If there is any deviation, use the spanner to adjust.
   --- For gear tooth micrometers with a lower limit more than 25mm, setting standard shall be used for zero adjustment. The operation is the same as above.

   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

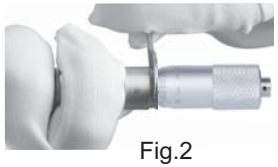
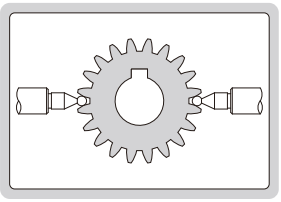
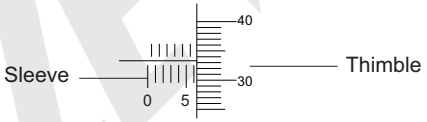


Fig.2

4. 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.



5. 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:



Barrel reading: 6mm
Thimble reading: 0.333mm(3 is estimated)
Reading: 6.333mm

6. 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.

7. Optional accessary: ball tips (code: 7391)

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