



OPERATION INSTRUCTION

Digital screw thread micrometers

Resolution: 0.001mm/0.00005"

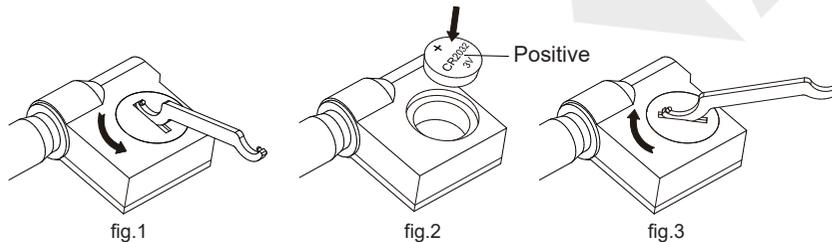


- 1-Frame
- 2-Zero adjustment device
- 3-Locking screw
- 4-Tip
- (optional, except 3581-SXX series)
- 5-Spindle
- 6-Locking screw
- 7-Sleeve
- 8-Friction thimble
- 9-Ratchet stop
- 10-Insulation plate
- 11-Data output signal light
- 12-Spanner
- 13-60° setting standard (except 0-25mm/0-1")
- 14-Data output interface

1. The product is used to measure pitch diameter of screw thread.

2. Install battery:

- Turn the battery counterclockwise with the spanner (fig.1), then remove it.
- Put CR2032 battery into battery house, positive side of battery(+) should face out (fig.2).
- Tilt the battery cover to align it with the snap position and press it down, then use a spanner to turn the battery cover clockwise to lock it. (fig.3)



- 3. Buttons:
 - on/off...set
 - short press(<2 sec.): power on/off
 - long press(>2 sec.): set the initial reading in absolute measuring mode. data...mm/in
 - short press(<2 sec.): for data transmit, send one data each time.
 - long press(>2 sec.): metric/inch conversion
 - Data output signal light
 - for short press data...mm/in, the red light flashes once

4. The micrometer should be zeroed before measuring:

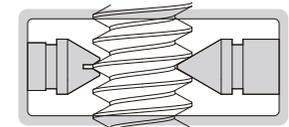
- Install the tip that is consistent with the thread pitch and tooth profile angle to be measured, and wipe the measuring surface of the probe with a clean soft cloth;
- Loosen the locking screw and turn the friction thimble to make the zero line on the friction thimble coincide with the longitudinal engraved line on the sleeve, and make the edge of the friction thimble and the zero line on the sleeve tangent;
- Push the zero adjustment device to make the V-shaped tip and the cone (knife-edge) tip come into contact with each other, and tighten the lock screw. Long press "on/off set" to setting zero. Turn the ratchet stop to check the zero adjustment, if there is any deviation, use the spanner to adjust.
- Thread micrometers with a lower limit more than 25mm/1" are required to be zeroed. Procedure is same with above.

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.4) to complete the calibration.



fig.4



5. Measurement:

- Measurement, should ensure that the micrometer measuring surface and workpiece surface clean, do not allow burrs and other debris, which will lead to measurement error.
- Adjust the size of the micrometer slightly, to make it larger than the measured workpiece. Put the workpiece into the micrometer, rotating friction thimble, when the probe and the workpiece are about to contact, turn the ratchet thimble. Reading after you hear the gigue sound.

6. Automatic power off in about 20 minutes. Press any button to turn on micrometer.

7. The battery can be used for half a year. If there is nothing on display or digits blurring, battery voltage is too low, please replace battery. If digits do not change when buttons are pressed or friction thimble is rotated, take out battery and put it back after 1 minute. Remove battery if micrometer is not be used for a long period of time, otherwise, liquid may leak from the battery and damage the micrometer.

MN-3581N-E