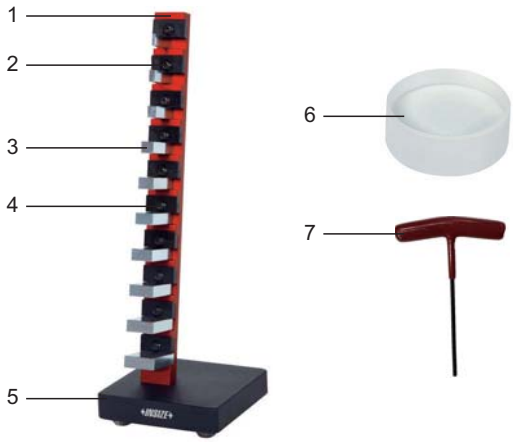
OPERATION INSTRUCTION
Micrometer Inspection Gage Block Set

Code	Material	Gage blocks included in set	Applicable micrometer
4160-10	alloy steel	2.5mm, 5.1mm, 7.7mm, 10.3mm, 12.9mm, 15mm, 17.6mm, 20.2mm, 22.8mm, 25mm	0-25mm



1-Column
2-Press block
3-Gage blocks
4-Locking screw
5-Base
6-Optical flat
7-T-wrench

1. Mainly used for measuring accuracy and flatness of 0-25mm micrometer.
2. Installation:
   --- Align the screw hole of the column with the screw hole of the base (Fig. 1), and tighten the screw to fix the column on the base.
   --- Loosen the locking screw, put the gage block into the installation groove (Fig. 2), and slightly apply the locking force to fix the gage block.

Fig. 1

Fig. 2

3. Operation:
   --- As shown in Fig. 3, check the indication error of each measuring point of micrometer in turn.
   --- Put the optical flat on the measuring surface of micrometer and observe the number of interference fringes. The calculation formula of flatness is as follows:

$$\Delta = 0.5N\lambda$$

In the formula: Δ is the measured value of flatness, unit: μm
N is the number of interference bands
λ is the wavelength of monochromatic light wave, unit: μm

The wavelength of monochromatic sodium light is λ = 0.6μm. For one light band, Δ is calculated to be 0.3μm, that is, the flatness is 0.3μm.

Fig. 3