

Resolution: 0.5mm
Accuracy: $\pm 0.25\text{mm}$



- 1-GO thread
- 2-Scale sleeve
- 3-Handle
- 4-Adjusting screw
- 5-NOGO thread

1. Thread Depth Gauges consist of a GO thread and a NOGO thread, and are used to check the depth of a threaded hole and to measure the depth of the hole at the same time.

2. Measuring thread depth:

Scale Sleeve in the free state, this time the length of the GO thread out of the reference surface is 0.5P (P for the pitch) (Figure 1). Put the GO thread of the thread depth gauge into the workpiece to be measured, turn the handle, the GO thread into the workpiece to be measured until the end of the bottom, read out the scale readings



Figure 1

3. When the GO and NOGO threads of the depth gauge are worn, it is necessary to replace the threads:

- Select a suitable long sleeve and place it into the GO thread, screw the nut into the GO thread until the long sleeve is flush with the handle (Figure 2).
- Remove the GO thread by turning the nut with a spanner.
- Put in a new thread and tap it lightly with a plastic hammer (Figure 3).
- Replacement completed

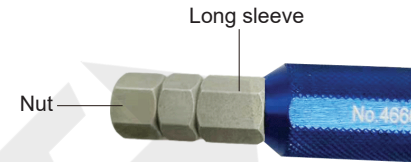


Figure 2



Figure 3

4. After replacing the threads, it is necessary to check the zero position as follows:

- Select the zeroing block and adjust the mark on the zeroing block to the nominal size of the calibrated thread depth gauge.
- Place the GO thread into the zeroing block until it is pressed to the bottom (Figure 4).
- Observe if the scale reads 8 (standard value) - 0.5P
- If inconsistent, use a hexagonal spanner to loosen the three adjusting screws (Figure 5), keep the handle immobile, turn the NOGO thread to adjust the scale read 8 (standard value)-0.5P
- Tighten the adjusting screw to complete the calibration.

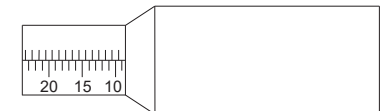


Figure 4



Figure 5

5. The reading is the value at the tangent position of the handle ramp and the scale, as shown in the figure below, which reads 8.50mm.



6. Optional accessories: zero block (code 4668-SETTER), removal tool (code 4668-TOOLXXX).