



OPERATION INSTRUCTION

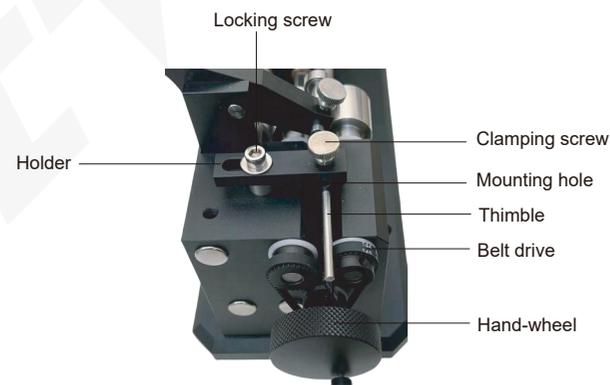
Quick positioning Concentricity Gauge

Code	Diameter Range	Accuracy
4737-26	3-25mm	2 μ m



Thimble: Put it at the right end of the workpiece to prevent workpiece from moving right. Select appropriate mounting hole based on the workpiece and thimble can be moved left and right, fix it by clamping screw. Holder can also be moved up and down, fix it with hex wrench tightening the locking screw.

Hand-wheel: Move the workpiece by rotating hand-wheel.



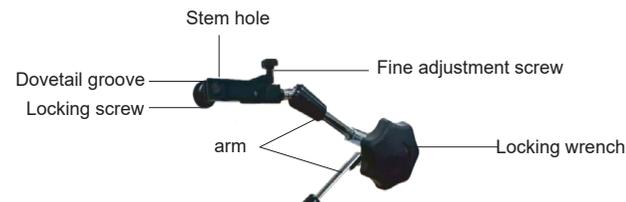
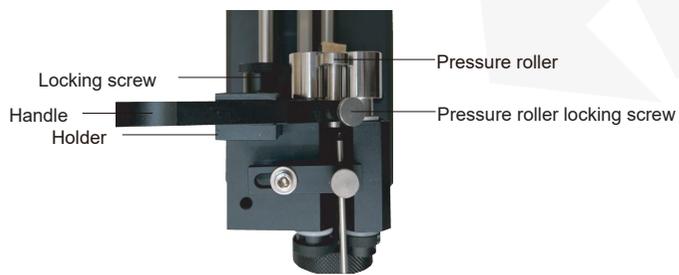
1. Concentricity gage is mainly used to measure cylindrical workpiece's roundness and concentricity.

2. Description of each part:

Press device: Fix the workpiece with the pressure roller. The holder can be moved up and down, fix it by the locking screw.

Pressure roller can be moved left and right, fix it by the pressure roller locking screws.

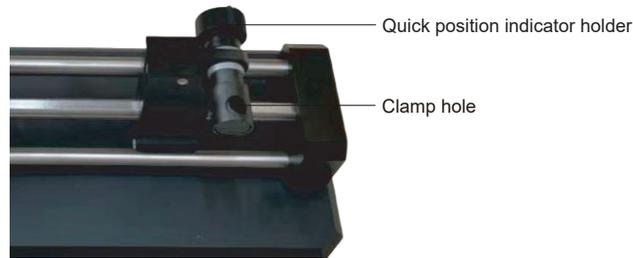
Indicator holder: Clamp the indicator to fix it. Clamp the indicator by dovetail groove or stem hole, the direction of fine adjusting movement is contrary to the direction of the measuring point by force, which avoids to affect the result. Loosen locking wrench, locking device can move freely, tighten it after setting its position.



MN-4737-E

V1

Quick position indicator holder: Clamp the indicator to fix it. The indicator can quickly position on the guide rail based on the length of the measured workpiece



3. Usage:

--- Holding probe as below ways.

Caution: To avoid the measurement error which caused by fine adjustment elasticity, the lever needle and the fine adjustment screw should be located at the opposite side(fig.1);
When working, adjust the fine adjustment screw so that component 1 is between the top of thread and the middle of thread, to increase the elasticity of head, do not let component 1 be at the bottom of thread(fig.2).

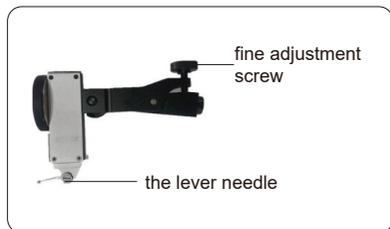


fig.1

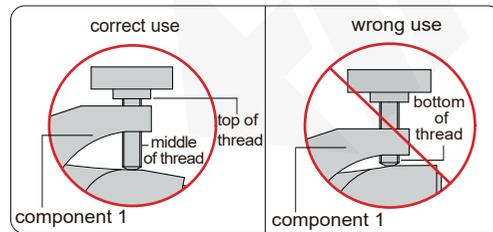
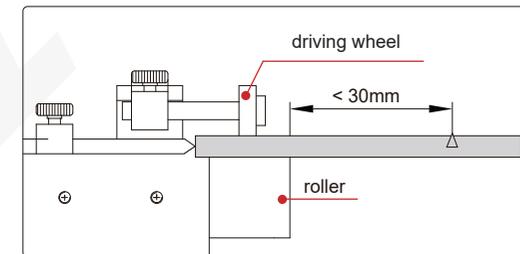


fig.2

4. Measurement:

- It is necessary to clean faces of cylinder, pressure roller, workpiece before measurement
- Measure standard pin gage, cylinder accuracy <math>< 2\mu\text{m}</math>, remove pin gage, and then measure workpiece
- Dial test indicator should be prepressing, the direction of the measuring point is close the workpiece's axes as far as possible, rotate hand-wheel, get the result till the pointer is steady

distance between measuring point and roller <math>< 30\text{mm}</math>



5. Notice:

- The moment that start to turn hand-wheel, the pointer of indicator is jumping. Get reading after the pointer is steady
- Measuring faces should be carefully protected from being scratched or damaged. It should be oiled to prevent rust after use

6. Optional accessory: Dial test indicator(code: 2880-02, 2880-02R).