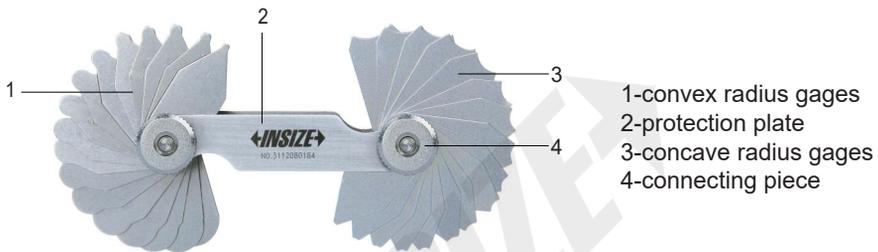




OPERATION INSTRUCTION

Radius Gages

Code	Range	Radius of leaves included (mm)	Quantity of leaves (internal + external)	Accuracy
4801-17	1-7mm	1, 1.25, 1.5, 1.75, 2, 2.25, 2.75, 3, 3.5, 4, 4.5, 5, 5.5, 6, 6.5, 7	17+17	±0.030mm
4801-16	7.5-15mm	7.5, 8, 8.5, 9, 9.5, 10, 10.5, 11, 11.5, 12, 12.5, 13, 13.5, 14, 14.5, 15	16+16	±0.035mm
4801-15	15.5-25mm	15.5, 16, 16.5, 17, 17.5, 18, 18.5, 19, 19.5, 20, 21, 22, 23, 24, 25	15+15	±0.042mm



- 1-convex radius gages
- 2-protection plate
- 3-concave radius gages
- 4-connecting piece

1. The radius gages are mainly used to check the concave-convex arc of various parts, tools, molds, etc. by comparison method. According to the size of the light gap to determine whether the arc radius of the workpiece is qualified.

2. Before use, clean the measuring surface of the radius gages with a clean soft cloth, and the surface of the radius gage shall be free of concave-convex bending.

3. Measurement:

There are two methods of using a radius gauge for inspection:

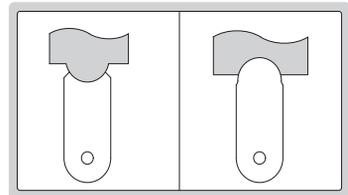
---Fixed value method: when the radius size of the arc part of workpiece to be tested is known, select the corresponding radius size template to test.

---Test method: when the radius size of the arc part of workpiece to be tested is unknown, the template with different radius size shall be sleeved with the arc to be tested in turn.

When the tightness is consistent (no light gap or the light gap is the minimum), the size of the radius template is the radius size of the arc to be tested.

4. Maintenance:

-- It should be used carefully, since the arc edges of the radius gages are easy to be damaged. After use, the radius gage should be coated with oil and put in the protection plate.



MN-4801-C/E

V0