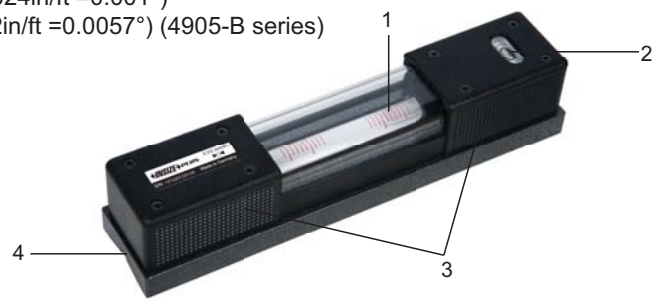
OPERATION INSTRUCTION

Block Level

No need to set zero before use

Sensitivity: 0.02mm/m(=.00024in/ft =0.001°)
0.1mm/m(=.0012in/ft =0.0057°) (4905-B series)



1-Main bubble
2-Vice bubble
3-Plastic hand grip
4-V-groove

1. Clean the measuring faces and workpiece with soft cloth before use, to avoid measurement error due to small particles and debris. The temperature of block level and workpiece should be equal to environment temperature. In case of changes in temperature, please wait for half an hour or more before use.
2. No need to set zero before use. Slide (not put) the level on the surface of measured workpiece. Read by bubble's postion.
   Take below fig. 1 for example, reading '+2 DIV. ' means right side is high (bubble moves to high side)
   For sensitivity of 0.02mm/m, inclination is 0.04mm/m(=.00048in/ft), tilt angle is 0.002°.
   For sensitivity of 0.1mm/m, inclination is 0.2mm/m(=.0024in/ft), tilt angle is 0.0114°.

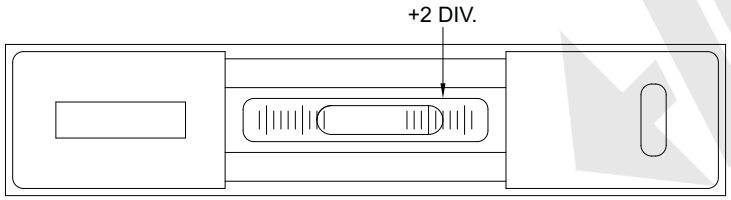


Fig.1

3. In order to get accurate result, suggest to turn level 180° to measure. Right side is positive scale, left side is negative scale (fig.2). After the bubble stops oscillating (about 40s), read A on the scale (Fig.3). Turn level 180°, slide it at the same position of the surface. Read B on the scale (fig. 4). The final reading is (A+B)/2.
   In the above example: A= +2, B= +1, (A+B)/2= +1.5DIV.
   For sensitivity of 0.02mm/m, the result is: +1.5x0.02mm/m=+0.03mm/m
   For sensitivity of 0.1mm/m, the result is: +1.5x0.1mm/m=+0.15mm/m

Notice: The line of sight should be perpendicular to the level to avoid parallax.

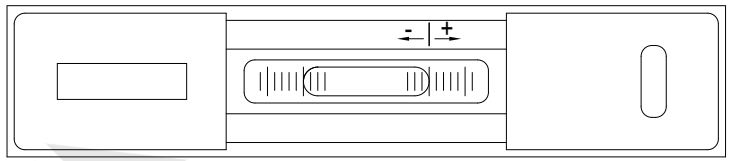


Fig.2

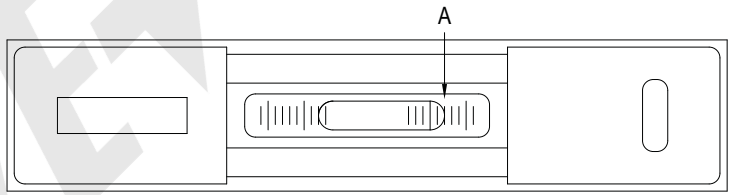


Fig.3

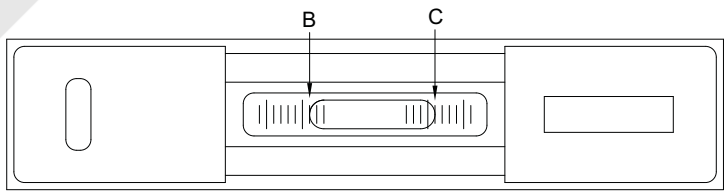


Fig.4

4. Plastic hand grip--reduce the impact of temperature on the measurement when holding. Please do not hold level for long in use, to avoid the impact of temperature on the measurement. Please also avoid direct sunlight, halitus, ect. during measurement.
5. Light up and down block level gently, please don't be shocked. After use, please oil the metal face (such as vaseline) to prevent rust and then put it into packing box.
6. V-groove 150° on bottom of block level is used for shafts (shafts dia. 19.3~115.9mm).
7. Storage temperature: -40°C ~ +70°C/40°F ~ 158°F.

Appended: In case of zero deviation (A-C, Fig.3 and Fig. 4) is more than 1 DIV. after hit or other external force, please return to INSIZE to adjust.

MN-4905-C/E
V2