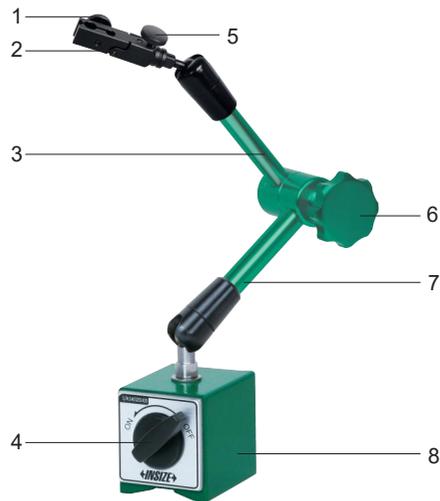




OPERATION INSTRUCTION

Universal Magnetic Stand

Code	Magnetic force	Applicable holding stem	Remark
6229-60	60kgf	Ø8mm	with fine adjustment and dovetail groove
6229-80	80kgf	Ø8mm	
6229-100	100kgf	Ø8mm	
6229-101	100kgf	Ø8mm	



- 1-Holding locking screw
- 2-Holding device
- 3-Upper arm
- 4-Magnetic switch
- 5-Fine adjustment screw
- 6-Locking wrench
- 7-Lower arm
- 8-Magnetic base

1. This magnetic stand is for digital/dial indicators and dial test indicators.
Holding as follows:



holding stem Φ8mm in metric



holding dovetail groove

2. Usage:

---Let the magnetic base be in contact with the machine tool, then turn on the magnetic switch to make sure that the universal magnetic stand can contact with the machine tool steadily.

Caution: Please make sure that the magnetic base and machine tool are cleaning, otherwise, the universal magnetic stand may slide slightly during measurement, which will affect the measuring results.

---Loosen the holding locking screw and locking wrench to adjust the arms and indicator to the appropriate position. Rotate fine adjustment screw is convenient to operate when the indicator is close to the workpiece. After adjustment, please make sure each part is locked steadily.

---After measurement, turn off the magnetic switch, universal magnetic stand can be removed from the machine tool.

3. To get accurate measurement, please try to avoid using the universal magnetic stand in vibration environment.

4. When the locking wrench is closer to the end face (fig 1), the position adjustment needs to be performed to avoid the subsequent situation that the locking wrench is screwed to the end but not locked.

Adjust the locking wrench to the middle position of the thread, use the hex wrench to adjust the internal hex wrench hole of the tail clockwise, and stop when there is a large resistance, turn the lock wrench at the same time to check the position of the lock wrench when locking, and complete the adjustment if the position is appropriate(fig 2, fig 3).



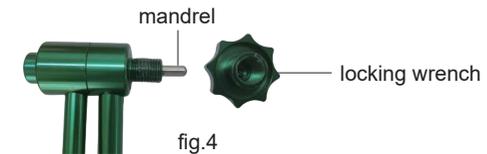
5. If the pressure is insufficient, the anti-wear hydraulic oil can be added appropriately.

Methods as below:

---Unscrew the locking wrench (fig 4) and remove the mandrel

---Add the right amount of anti-wear hydraulic oil

---Install the mandrel and tighten the lock wrench



Note: When not in use, loosen the lock wrench to avoid hydraulic oil consumption.

MN-6229-E

V1