



OPERATION INSTRUCTION

Micrometer Grinding Machine



Please scan QR code to watch the operation video of products.

Attention: 1. Please check the voltage input rang before using the machine.
2. The machine must install reliable grounding line.

Power supply: 220V, 50HZ



- 1-Grinding claw locking screw
- 2-Grinding claw
- 3-Locking screw
- 4-Fixed fixture
- 5-Indicator light
- 6-Power switch
- 7-Time control start switch
- 8-Manual control/Time control switch
- 9-Fixture locking screw
- 10-Speed adjustment knob (third gear)
- 11-Time adjustment knob
- 12-Grinding blocks(optional)

1. Used for grinding micrometer measuring surfaces. Suitable for 0~100mm range micrometer.

2. Panel function:

Manual control/Time control switch---Manual control the grinding time/set up grinding time

Manual control mode---Turn on the power switch and the grinding machine starts working;

Turn off the power switch and the grinding machine stops working

Time control mode---Turn on the power switch and press the time control start switch, the

grinding machine starts working;

When the set time is reached, the grinding machine stops working. If you

want to start again, press the time control start switch

Speed adjustment knob---Grinding speed can be adjusted in manual /time control mode

Time adjustment knob---Grinding time can be adjusted in time control mode

3. How to use:

--- Place the grinding machine on the table

--- Install the grinding blocks: Select a group suitable grinding blocks according to the micrometer.

Apply the grinding paste evenly to the grinding block that mark 1. Remove the grinding claw locking screw, open the grinding claw, then place the grinding block into the grinding claw and adjust its center position on the inner wall of the grinding claw. Then drop the upper grinding claw, and lock the grinding claw locking screw (Fig. 1).

---Install the micrometer: Remove the micrometer guard, and loosen the locking screw. Then place the micrometer horizontally on the fixing fixture, ensure the axis of the measuring surface and the plane of the grinding claw hole is perpendicular, lock locking screw. Loosen the fixture locking screw, and adjust the position of the fixture so that the micrometer measuring surface grinding path is within the radius of the grinding block, then lock fixture locking screw and turn off the grinding machine (Fig. 2).



Fig. 1



Fig. 2

---Rotate the micrometer ratchet stop to make the two measuring surfaces of the micrometer contact the grinding surface of the grinding block. After applying pressure appropriately, select the grinding time to grind according to the micrometer. During the grinding process, the ratchet stop should be rotated frequently to make the micrometer measuring surface is in good contact with the grinding surface of the grinding block (after loosen the micrometer locking screw and rotate the ratchet stop, to lock the micrometer locking screw first time).

---After a group grinding blocks are grinded in order, the micrometer can be removed for inspection.

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4. Note:

- Please check the voltage input range before using the machine, which in compliance with the requirements.
- The machine must install reliable grounding line.
- The operator must be trained and qualified before operating the machine.
- Check the micrometer before grinding to ensure that the every part and interactions are intact.
- The grinding block should be checked regularly to ensure its flatness and parallelism.
- If the grinding machine is unusual during use, it should be stopped to checked first time.
- When the grinding machine can not work, check the fuse (the fuse is located behind the grinding machine).
- The micrometer locking screw must be locked during the grinding process.

5. Maintenance:

- After use, cut off the power, clean the grinding machine, prevent rust.
- If long time not use, grinding machine should be oiled

6. Optional accessory: grinding block.