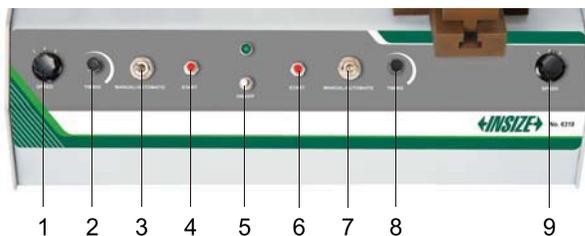


Please scan QR code to watch the operation video of products.



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- Caliper grinding speed adjustment(3 steps)
- 2- Caliper grinding time adjustment
- 3- Caliper grinding manual control/time control switch
- 4- Caliper grinding start
- 5- Power switch
- 6- Micrometer grinding start
- 7- Micrometer grinding manual control/time control switch
- 8- Micrometer grinding time adjustment



- 9- Micrometer grinding speed adjustment (3 steps)
- 10-Caliper grinding block
- 11-Micrometer grinding blocks (optional)

1. Used for grinding measuring surfaces of caliper lower jaws and outside micrometer, suitable for 0-300mm range calipers and 0-100mm range outside micrometers
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:
 - A. Grinding measuring surfaces of outside micrometer:
 - Place the grinding machine on the table
 - Install the grinding blocks: Select a group suitable micrometer grinding blocks according to the micrometer. Apply the grinding paste evenly to the grinding block . 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.
 - 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. 1).



Fig. 1

--- 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.

B. Grinding measuring surfaces of caliper lower jaws:

--- Clamp the caliper on the workbench and adjust the clamping position. Evenly apply the grinding paste to the caliper grinding block, put it into the grinding card slot, and press the spring pressure plate against the caliper (Fig. 2).



Fig. 2

--- The position of the caliper clamping on the workbench should be careful not to tilt forward and backward. The working surface of the external measuring jaw should be located in the middle of the grinding block. If the gap at the front of the caliper is large, the caliper installation should

be moved forward properly, and the pressure plate should be pressed back a bit. And vice versa. After the gap between the front and back is eliminated, the caliper should still be installed in the middle of the grinding block for grinding.

--- After grinding, the caliper can be removed for inspection.

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 caliper before grinding to ensure that all parts and interactions are intact.

--- Before grinding, wipe the caliper measurement surface clean and set zero.

--- Check whether the caliper is fixed and reliable before grinding.

--- The grinding wheel should be checked regularly to ensure that the grinding wheel is intact.

--- If the machine is not working properly or makes unusual noise, stop in time to check.

--- When the grinding machine can not turn on, check the fuse (the fuse is on the back of the grinding machine).

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.

Code	For micrometer	Remark
6307-1	0~25mm	includes 4 grinding blocks
6307-2	25~50mm	includes 4 grinding blocks
6307-3	50~75mm	includes 4 grinding blocks
6307-4	75~100mm	includes 4 grinding blocks