

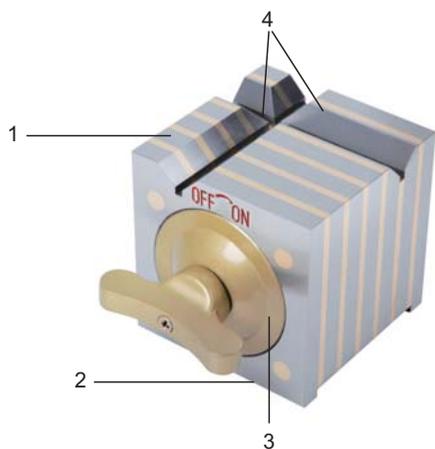


# OPERATION INSTRUCTION

## Magnetic Square With V Groove

Code	Size (LxWxH)	Magnetic force on V grooves		Magnetic force on top, left and right sides		Range of shafts (Ød)
		Granite surface plate	Cast iron plate	Granite surface plate	Cast iron plate	
6539-100	100x100x100mm	30kgf	25kgf	50kgf	30kgf	5-30mm

Parallelism and squareness of top, bottom, left, right and back: 10µm  
 Parallelism and squareness of V grooves to top, bottom, left, right and back: 10µm



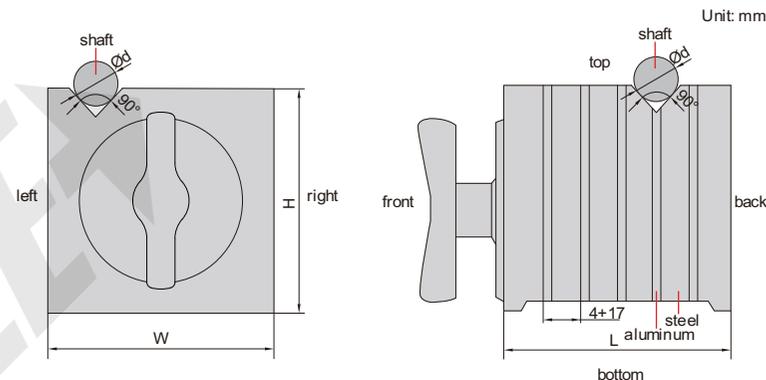
- 1-Top
- 2-Bottom
- 3-Magnetic switch
- 4-V grooves

1. It has magnetic force on top, left, right and V grooves. It is used for measuring the parallelism, squareness and marking of workpieces.

2. Operation:

- Before use, clean all working surfaces of the magnetic square, and clean the working surface of the platform on which the square will be placed.
- Each working surface of the magnetic square is precision processed and can be used to position the workpiece. It provides auxiliary reference perpendicular to the reference plane (such as flat working surface, machine tool guide rail) for the measured workpiece. By flipping, the measured size is perpendicular to the working surface of the platform, and parallelism or squareness can be measured.

- Put the workpiece to be marked into the V groove of the magnetic square, turn the magnetic switch clockwise to ON until it can not be turned, and then mark with the height gage or tosecan. After marking, turn the magnetic switch to OFF anticlockwise until it can not be turned, and then remove the workpiece.



3. Notice:

- The working surface of magnetic square is not hardened and has no hardness. When using, try to put the workpiece vertically up and down
- To avoid wear, do not rotate the workpiece on the working surface of the magnetic square
- When it is not used for a long time, antirust oil shall be applied on the working surface to prevent rusting

MN-6539-C/E

V1