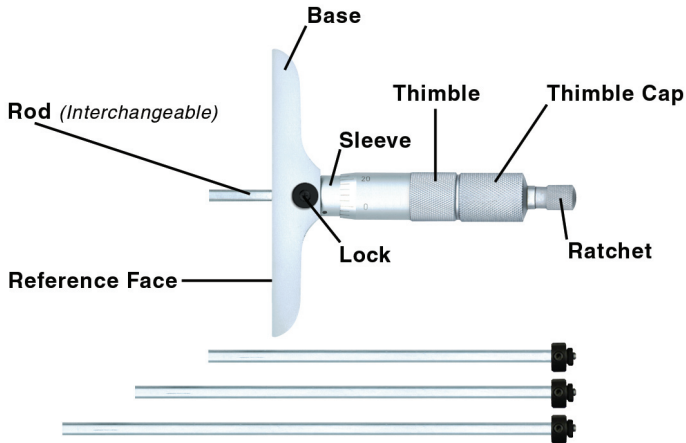




DEPTH MICROMETER

1. CONSTRUCTION OF DEPTH MICROMETER



2. REPLACING THE RODS

The rod is secured with a screw-on cap. Turn the cap by holding the thimble. The rod can be easily detached from the micrometer by hand.

Select the rod that matches the intended measurement and insert it into the lead screw. Wipe away all dust and other foreign matter adhering to the contact faces of the lead screw and rod nut.

3. CHECKING THE REFERENCE POINT

Check the reference point error of the rod in the manner described below. Before checking, wipe away all oil, dust and other foreign matter adhering to the reference face of the base and the measuring face of the rod.

Rods for measurements 0 to 1" (0 to 25 mm): Position the reference face so that it directly contacts the surface plate. Press the base by hand so that the micrometer does not rise. Then turn the ratchet stop and read the scale when the measuring face of the rod closely contacts the surface plate.

Rods for measurements more than 1" (25 mm): Place two block gauges whose identical height corresponds to the minimum measuring length of the rod on the surface plate. Then arrange them parallel to each other. Set the reference face of the base on the blocks and read the scale when the measuring face of the rod contacts the surface plate.

4. ADJUSTING THE REFERENCE POINT

The reference point can be adjusted by the two methods described below.

A) General adjustment

If a scale reading provides a reference point error of less than 0.001" (0.02 mm), use an accessory spanner to turn the outer sleeve for adjustment of the reference point.

B) Adjusting the rod dimension

Measurements normally require no dimensional adjustments since the dimensions of all provided rods are factory-adjusted together with the micrometer. Should for some reason a dimensional adjustment be required, secure the rod in a vise, taking care not to damage the rod. Loosen the locking collar using a 2 mm allen key, then use an adjustable angle wrench to turn the rod nut for adjustment of the reference point. Once the reference point is corrected tighten the locking collar.

5. PRECAUTIONS

In no case should external force be applied to the micrometer during operation. Care must be taken so as not to bend the rod.