



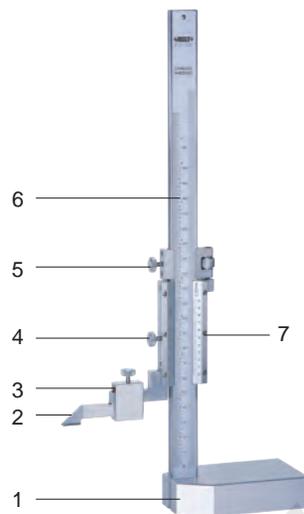
OPERATION INSTRUCTION

Vernier Height Gauges

Graduation: 0.02mm/0.001"

| Code | Range | Accuracy |
|----------|--------------|----------|
| 1253-150 | 0-150mm/0-6" | ±0.03mm |
| 1253-200 | 0-200mm/0-8" | ±0.03mm |

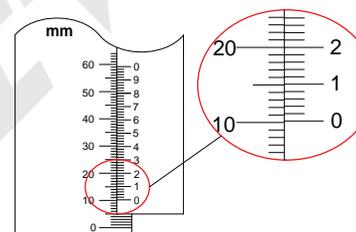
- 1-Base
- 2-Scriber
- 3-Clamp
- 4-Locking screw
- 5-Fine adjustment frame
- 6-Beam
- 7-Vernier



1. This product is used for measuring height dimensions and scribing.
2. Clean the bottom of the base and scriber, install the scriber, and put the height gauge on an inspection plate.
3. The height gauge should be check zero before measuring :
 - Make sure the bottom of the base and the inspection plate is clean, without burrs and scratches and other effects.
 - Lower the scriber, make the measuring surface and the bottom of the base at the same level, check whether the reading is zero.
4. Measurement:
 - Check the bottom of the base and the inspection plate is clean, without burrs and scratches and other effects.
 - When measuring the height, raise the measuring surface of the scriber slightly higher than the measured height of the workpiece, and then use the fine adjustment frame to make the measuring surface of the scriber contact with the measured surface of the workpiece and then get the reading. Be careful of the measuring force to avoid the measurement error.

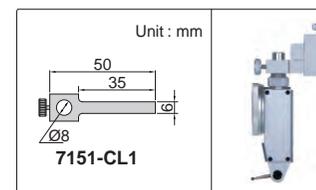
- Use dial test indicator (or precision dial test indicator) instead of scriber to position to improve measurement accuracy. Install dial test indicator into the holder. First make the dial test indicator touch with the inspection plate and set zero, get the reading a1 from the height gage, and then move the beam to make the contact point contact with the upper surface of the workpiece and set zero, get the reading a2, the height of the workpiece $h = a2 - a1$.
- The scriber is made of carbide and can be used for scribing. When scribing, use the fine adjustment frame to accurately align the required size with the height of the scribe line, then tighten the locking screw and scribe. When scribing, the base should fit the inspection.

5. During reading, the sight is perpendicular to the scale to avoid parallax reading. The reading is the sum of beam and vernier. The reading results are as follows:



| | |
|------------------------|---------|
| Beam reading: | 10mm |
| Vernier scale reading: | 0.20mm |
| <hr/> | |
| Reading: | 10.20mm |

6. Optional accessory: dial test indicator holder, for holding dial test indicator.



7. Notice :
 - When move the gauge, you should hold the base with one hand and hold the beam with the other hand.
 - After use, clean and put the gauge back to the packing box and store it in a dry place.
 - The gauge without the box is not allowed to be placed horizontally, nor can it be leaning against other goods. Move the beam to the lowest position after use. The gauge should be calibrated regularly.

MN-1253-C/E

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