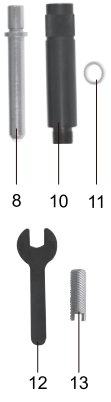
OPERATION INSTRUCTION

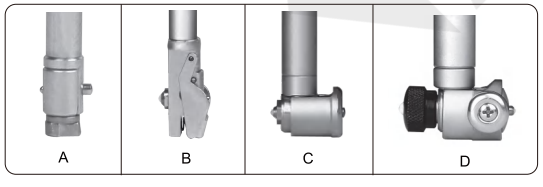
Bore Gauge

Range	Indicator	Accuracy	Repeatability	Type
6-10mm	dial indicator, range 1mm, graduation 0.001mm (code 2313-1FA)	±0.007mm	0.0015mm	A
10-18.5mm		±0.007mm	0.0015mm	B
18-35mm		±0.007mm	0.0015mm	C
35-60mm		±0.007mm	0.0015mm	D
50-100mm		±0.007mm	0.0015mm	D
50-160mm		±0.007mm	0.0015mm	D
100-160mm		±0.007mm	0.0015mm	D
160-250mm		±0.007mm	0.0015mm	D
250-450mm		±0.007mm	0.0015mm	D
400-800mm		±0.007mm	0.0015mm	D

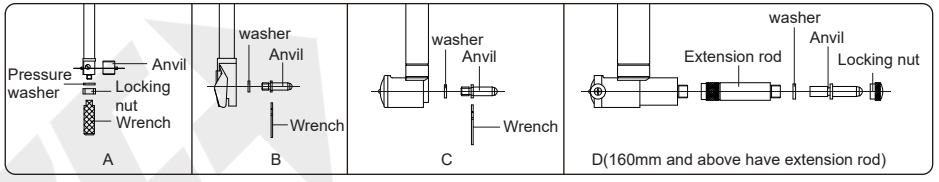


1-Dial indicator
2-Stem
3-Main pole
4-Contact point
5-Protect bridge
6-Locking device
7-Handle
8-Anvil
9-Locking nut
10-Extension rod
11-Washer
12-Wrench(2853-18,2825-35)
13-Wrench(2853-10)

Contact point



1. The bore gage used to compare measurement. It is mainly used for measuring internal diameter size.
2. Usage:
   (1)Set size: Choose anvil, extension rod and washer according to the size of workpiece, then install them as follow figures, please make each part be installed steadily. Use wrench to tighten the anvil when range is less than 35mm. Press contact point several times after installation, the pointer of indicator move smoothly, flexibly.



   (2)Set calibration size: Select setting ring, outside micrometer, or standard hole with known diameter and accuracy, clean measuring faces with soft cloth.

   (3)Set zero(as setting ring gage for a example): Insert the bore gage into seting ring and sway the bore gage wiggly(fig.1), to find the "turning point" of the pointer. Loosen bezel locking screw and rotate bezel to make "zero line" coincide with "turning point",then tighten bezel locking screw. Sway the bore gage wiggly several times to make sure the "zero line" coincide with the"turning point".

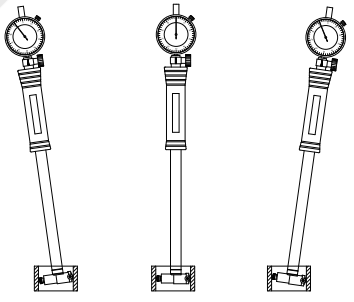


Fig.1

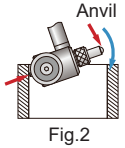


Fig.2

   (4)Measuring: Insert the bore gage into workpiece and sway it wiggly several times to find the "turning point" of the pointer. Get the result, the reading is deviation from the normal value.
3. Optional accessories: setting ring(series 6312)
4. Notes:
   ---Please do not insert the bore gage into workpiece or setting ring from the anvil side. It is necessary to press the contact point and protect bridge into setting ring or workpiece firstly, then make the anvil contact with the inwall and turn the bore gage upright slightly.
   --- Do not strike the gage or allow it to be struck.
   ---The gage, setting ring and workpiece should be temperature balanced before calibration.

MN-2825-E
V2