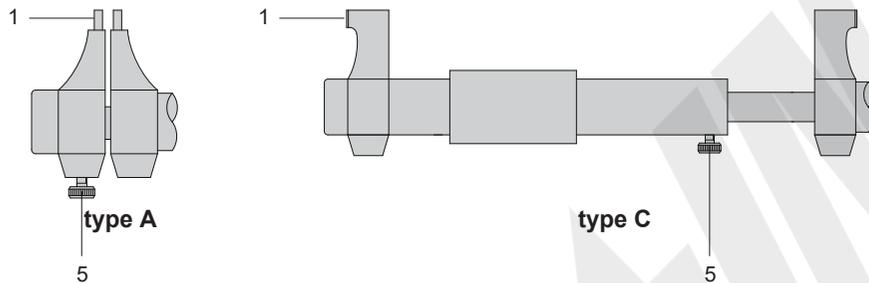
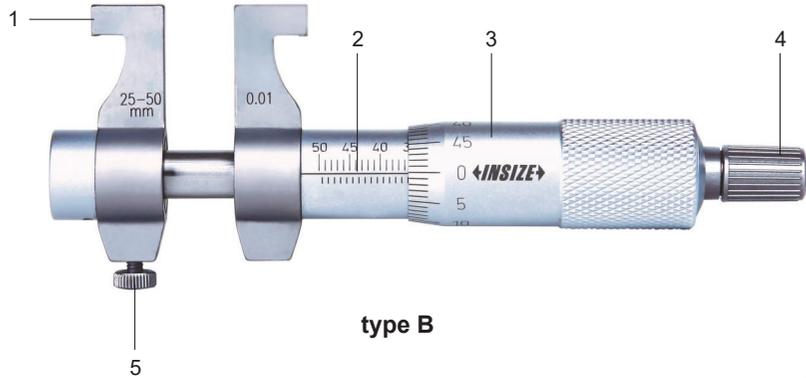


Graduation: 0.01mm  
 Accuracy: 7μm (range 5-30mm)  
 8μm (range 25-50mm)  
 9μm (range 50-75mm)  
 10μm (range 75-100mm)



- 1-Probe
- 2-Sleeve
- 3-Friction thimble
- 4-Ratchet stop
- 5-Locking screw
- 6-Spanner

1. The product is used to measure the internal dimension.

### 2. Calibration:

- Select the appropriate ring gage or the inner diameter dimension composed of gage block and gage block accessories.
- Turn the ratchet stop until the distance between the two probes is slightly less than the ring gage size.
- Put the micrometer into the ring gage, turn the ratchet stop to make the measuring probe fit with the measuring surface of the ring gage, and lock the locking screw.
- Use the spanner to adjust the reading of the micrometer to be consistent with the size of the ring gage.

### Zero adjustment method:

- Insert the spanner into the small hole of the sleeve(Fig.1), and turn the sleeve slightly until the reading of the micrometer to be consistent with the size of the ring gage.



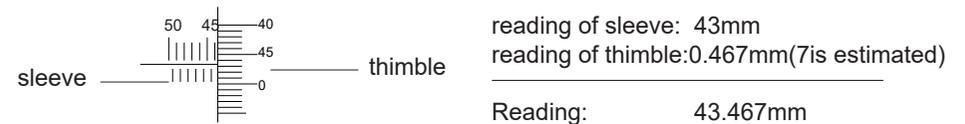
fig.1

### 3. Measurement:

- When measuring, ensure that the measuring surface of the micrometer and the measuring surface of the workpiece are clean. Do not allow burrs and other debris, which will lead to measurement error.
- Adjust the size of the micrometer to be slightly smaller than the measured workpiece, then put the micrometer into the measured workpiece, rotate the ratchet stop, gently swing the micrometer to make the measuring surface fully contact with the workpiece, and read the measurement result.

4. During reading, the line of sight should be perpendicular to the scale surface to avoid parallax. The reading is the sum of sleeve and thimble.

The reading method is as follows:



5. After use, the probe shall be protected with oil to prevent rust.

6. Optional accessory: setting ring (code 6312), micrometer stand and clamp (code 6301 and 6301-1)

MN-3220-E