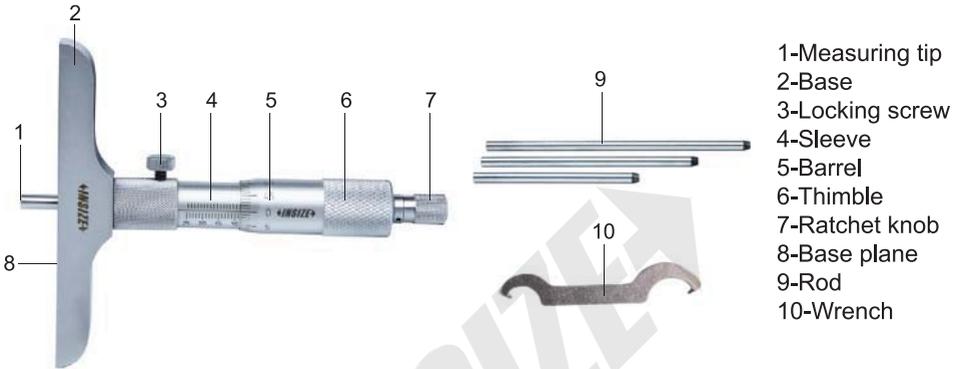


Graduation: 0.01mm
 Micrometer head accuracy: $\pm 3\mu\text{m}$
 Rod accuracy: $\pm(2+L/75)\mu\text{m}$ (L is the measuring range in mm)

Graduation: .001"
 Micrometer head accuracy: $\pm .00012$ "
 Rod accuracy: $\pm[.001+.0005(L/3)]$ " (L is the measuring range in inch)



1. First, select rod according to the measured size, install rod as following Fig. 1.

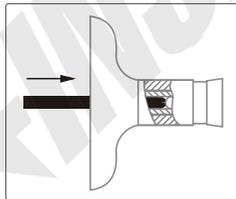
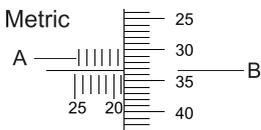


Fig.1

2. It is necessary to set zero on the inspection plate before measuring. Clean the measuring faces and inspection plate surface with soft cloth. It's directly to set zero when the range is 0-25mm: rotate barrel until zero scale is visible, then put the base plane on the inspection plate, keep pressing the base, rotate the ratchet knob of the micrometer until the tip of rod gets into the inspection plate. When cluck is heard, measuring faces contact completely, there is no deviation in zero, it's ready to measure. Micrometer's range is more than 25mm or scale is in inch, do calibration with calibrated tool (or gage block): put calibrated tool on inspection plate, put the base plane on the calibrated tool to set zero. Micrometer should be checked regularly to make sure that it is properly zero set.

Caution: When the measuring faces is close to, but not in contact with the inspection plate, do not apply excessive force to rotate the ratchet thimble, as it will lead to inaccurate results and may damage the internal precision threads.

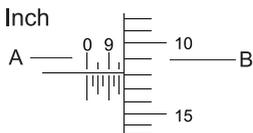
3. During measurement, make sure there are no cutting chips or other debris on the measuring faces and workpiece surface, or it will lead to inaccurate results and may damage base plane.
4. After measuring operation, loosen locking screw, take off micrometer to read the result. During reading, the sight is perpendicular to the scale to avoid parallax reading. The reading is the sum of sleeve, barrel. If range is more than 25mm or scale is in inch, the reading is needed a initial reading. For example, the rod's range is 25-50mm in metric or 1"-2" in inch, the reading is the sum of the initial, sleeve and barrel.



A: 18.5
 B: 0.334 (4 is estimated)
 C: 25.00

 D: 43.834mm

A is the reading from the sleeve
 B is the reading from the barrel
 C is the initial value
 D is the reading



A: 0.825"
 B: 0.0119" (9 is estimated)
 C: 1"

 D: 1.8369"

5. During zero setting, if there is a deviation, make adjustment according to following method: Tighten locking screw, use spanner the bigger half arc side to adjust sleeve (Fig. 2) till setting zero.



Fig.2

6. Measuring tip and base should be carefully prevented from being scratched or damaged. Tip and base should be oiled to prevent rust after measurement.

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