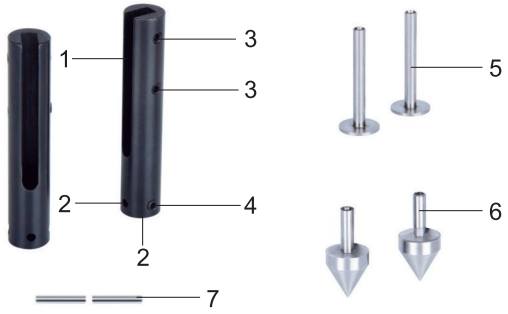
OPERATION INSTRUCTION

Accessory Set For Digital Caliper



1-Mounting groove
2-Mounting holes
3-Locking screw
4-Point locking screw
5-Disk points
6-Conical points
7-Spherical/flat points

1.Suitable for 0-150mm/0-6" and 0-200mm/0-8" digital calipers (thickness of lower jaws <3.7mm).
2. Install accessory set for digital caliper:
--- Install the accessory on the caliper fixed claw (fig.1) and tighten the locking screw with spanner
--- Install the spherical/flat point on the inside of the accessory (fig.2) and tighten the point locking screw with spanner
--- Align the mounting hole of the other accessory with the spherical/flat point (fig.3).
--- Pull the caliper so that the active jaw fits into the accessory and tighten the locking screw (fig.4)
--- Remove the point and complete installation of the accessory


fig.1

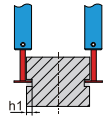

fig.2


fig.3

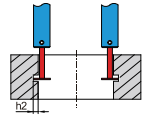

fig.4

3. Disk points:
Be used for measuring external groove diameter and internal groove diameter.
Installation
---Install the disk points on the bottom of accessory, adjust the points at the same heightand tighten the point locking screw(fig.5)
Calibration
---Fit the measuring surface of disk points and set zero, complete the calibration
Measuring external groove diameter.
---Pull the caliper until the internal measuring surface is larger than the measured sizeand make the measuring surface contact with measured workpiece completely (fig.6)
---Direct reading
Measuring internal groove diameter
---Pull the caliper until the external measuring surface is less than the measured size, andmake the measuring surface contact with measured workpiece completely (fig.7)
---The internal groove diameter is reading plus diameter of two points (Ø 10mm)

fig.5



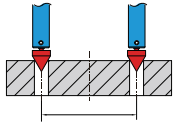
measuring extemal groove diameter(h1≤3.5mm)
fig.6



measuring intemal groove diameter(h2≤ 3.5mm)
fig.7

4. Conical points: Be used for measuring center distance.
Installation
---Install the conical points on the bottom of accessory and adjust the points at the same height, tighten the point locking screw(fig.8)
Calibration
---Fit the measuring surface of conical points and set zero, complete the calibration
Measuring center distance
---Pull the caliper until the conical points contact with measured workpiece completely (fig.9)
---Center distance is reading plus diameter of point (Ø10mm)


fig.8


measuring center distance
fig.9

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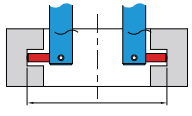
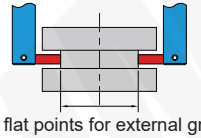
5. Spherical/flat points:
Be used for measuring groove diameter (inside hole) and external groove diameter.
Installation
---spherical points for groove diameter (inside hole) measurement (fig.10)
---flat points for external groove diameter measurement (fig.11)
Calibration
---When measuring groove diameter (inside hole) ,and choose the suitable micrometer to calibrate. Make spherical points contact with the measuring surface of micrometer completely, find minimum value and set zero, complete the calibration.
---When measuring external groove diameter, fit the measuring surface of flat points and set zero,complete the calibration.
Measuring groove diameter (inside hole)
---Method as above, refer to fig.12
---Diameter is reading of caliper plus reading of micrometer
Measuring external groove diameter
---Method as above,refer to fig.13
---Direct reading

fig.10

fig.11


spherical points for groove diameter(inside hole) measurement
fig.12


flat points for external groove diameter measurement
fig.13