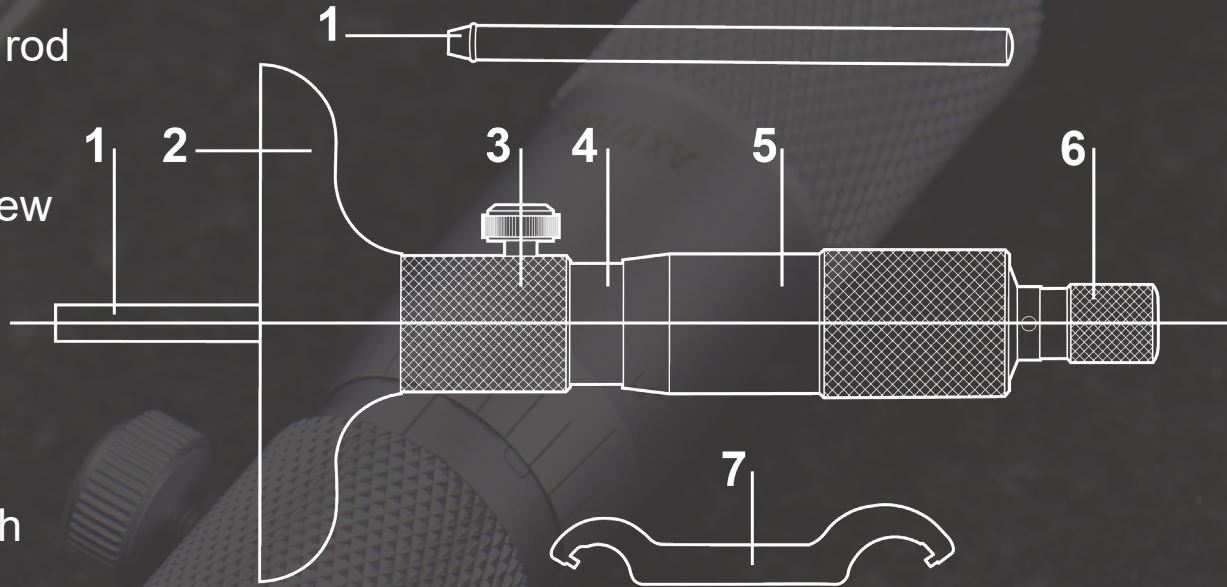


Operation Manual

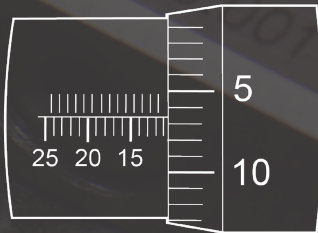
Depth Micrometer

1. Interchangeable rod
2. Base
3. Locking set screw
4. Sleeve
5. Thimble
6. Ratchet stop
7. Spanner wrench



Reading the Tool

Metric



Sleeve	11mm	
+	Thimble	0.065mm
Reading		11.065mm

Inch



Sleeve	0.625"	
+	Thimble	0.0067"
Reading		0.6317"

Zero Setting

Before using, clean measuring face of interchangeable rod and face of base with soft cloth or soft paper. The zero position is set on an accurate flat surface with 25mm/1" interchangeable rod.

- 1 Insert the interchangeable rod with taper end into the depth base.
(figures 1 & 2)



figure 1



figure 2

- 2 Loosen the set screw (figure 3) and rotate the thimble (figure 4) to retract the interchangeable rod. (figure 5)



figure 3



figure 4



figure 5

- 3 Holding down the base of the micrometer firmly to the base surface, rotate the thimble until the interchangeable rod is flush with the base surface. (figure 6 & 7)

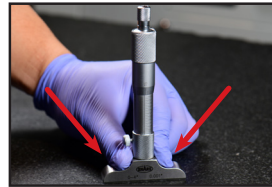


figure 6



figure 7

- 4 When the rod is flushed with the base surface, the micrometer should read 0. (figure 8)

Not necessary to reset when changing rod.

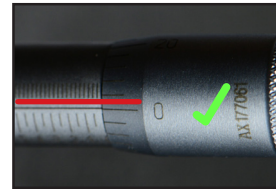


figure 8

- 5 If the line marked "0" on the thimble does not coincide with the reference line on the sleeve (figure 9), adjust the zero position using steps a and b. (figure 10 & 11)

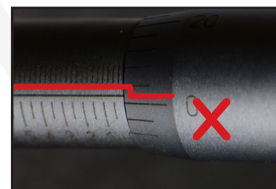


figure 9

a) Deviation **within** ± 0.001 " (or ± 0.01 mm)
Lock the spindle by the locking set screw then adjust the sleeve with a wrench until the reference line comes exactly in line with "0" line on the thimble.



figure 10



figure 11

b) Deviation **over** ± 0.001 " (or ± 0.01 mm)
Lock the spindle by the locking set screw and loosen the ratchet stop by a spanner. Pressing the thimble to the ratchet stop bring it so that "0" line coincides with the reference line on the sleeve. Fasten the ratchet stop and make the final adjustment.

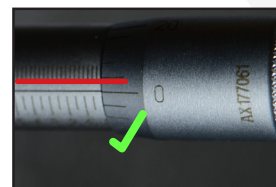


figure 12

Do not disassemble and drop the instrument. Keep the instrument clean and dry. Use ratchet stop to keep precision measuring.