

INSTRUCTION MANUAL

25-163 3-Point Internal Micrometers 50-100mm



Measumax

3 Point Internal Micrometers 25-160 - 25-163

Measumax Self-centering 3-point internal micrometers are designed for accurate measurement of internal diameters. Highly durable carbide-tipped contact points ensure reliable repeatability. Measurement can be taken close to the bottom of a blind bore, due to the unique design. Measurements can be taken into deep holes with the use of the extension rod that is supplied in the kits.

Zero-setting

- 1) Before using the Measumax 3 Point Micrometer, clean the measuring face and the hole of the setting ring with soft cloth or soft paper.
- 2) Put the setting ring on a flat worktable, insert the measuring face into the setting ring vertically. Rotate ratchet device until the measuring face contacts the bore of the setting ring fully.(Fig
- 3) Rotate ratchet device to make indication stable in the operation. The ratchet should "click" two or three times
- 4) If the indication value of is not identical with the value marked on the setting ring, set zero in the following ways:
 - a. Loosen locking screw with a screw driver. (Fig 3)
 - b. Rotate the sleeve until the indicator value is in line, then tighten the screw with the screw diver provided.

Diagram 1

- | | |
|-------------------|-------------------|
| 1. Measuring face | 2. Cover |
| 3. Locking screw | 4. Sleeve |
| 5. Thimble | 6. Ratchet device |
| 7. Test Ring | 8. Extension |
| 9. Spanner | |

Precautions

- 1) Do not distort the measuring face. Do not insert the measuring faces on an angle into the hole to be measured.
- 2) Do not subject the instrument to shock or strong knocks. This may cause the accuracy of the instrument to be compromised.
- 3) Do not disassemble or remove the cover. This could cause damage to the instrument.

Reading a 3 Point- Micrometer

The first figure is taken from the last graduation showing on the sleeve directly to the left of the revolving barrel. Note Each full graduations is 1mm. There is an additional half scale divisions are 0.5 mm. The remaining two figures (hundredths of a millimeter) are taken directly from the thimble opposite the main scale.(Fig 4.) The reading is 20.005mm

Fig 1

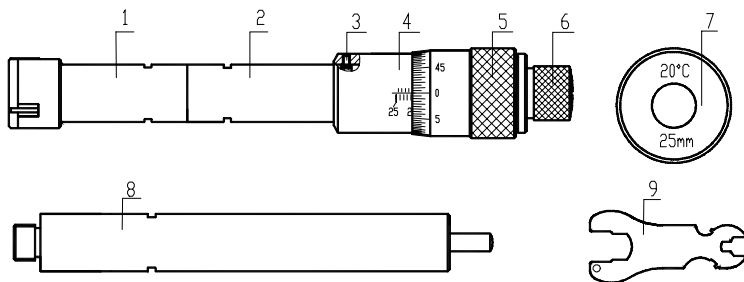


Fig 4



Fig 3



Fig 2