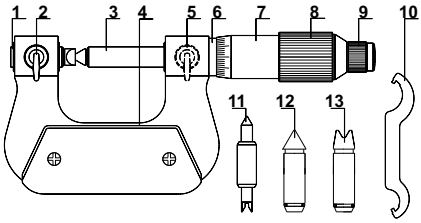
OPERATION MANUAL

SCREW THREAD MICROMETERS



1. Anvil sleeve **2. Locking device for anvil**
3. Spindle **4. Frame**
5. Locking device for spindle
(No in non-rotating micrometers)
6. Inside sleeve **7. Thimble**
8. Ratchet drive **9. Quick drive**
10. Spanner **11. Calibration standard**
12. Interchangeable knife-edged(Cone) anvil
13. Interchangeable V-shaped anvil

1. Use

Mainly for measuring the diameters of screw thread.

2. Zero Setting

Before using, wipe off measuring faces of anvils, spindles and calibration standard with soft cloth or soft paper. Install the anvils in the micrometer and rotate thimble to the “0” position. Push the anvil sleeve to make the two anvils contact or make the anvils contact the faces of the calibration standard. Make the line marked “0” on the thimble coincides with the “0” line on the inside sleeve. If the line marked “0” on the thimble does not coincide with the reference line on the sleeve, adjust zero position in the following manners:

1) Deviation within ±0.02mm (±0.001”)

Adjust the sleeve with a spanner until the reference line comes exactly in line with “0” line on the thimble.

2) Deviation over ±0.02mm (±0.001”)

Loosen the quick drive, press the thimble to make “0” line coincides with the reference line on the sleeve.

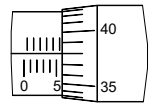
If necessary, in the former way.

3. Anvils

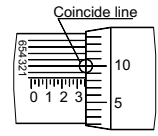
Interchangeable knife-edged (cone) anvil and V-shaped anvil are optional according to the pitch of the measured screw thread. The pitch of inch screw thread is the turn number per inch. The pitch is marked on the anvil.

4. Reading

Metric: Min reading is 0.01mm
Reading is 5.88mm
Inch: Min reading is 0.0001”
Reading is 0.3582”



（Metric）



（Inch）

5. Precautions

Do not disassemble and drop the instrument.

Keep the instrument clean and dry.

Regularly inspect the indication to keep precision measuring.

Return into the packaging box after apply antirust oil on the measuring faces if the micrometer not used for a long time.