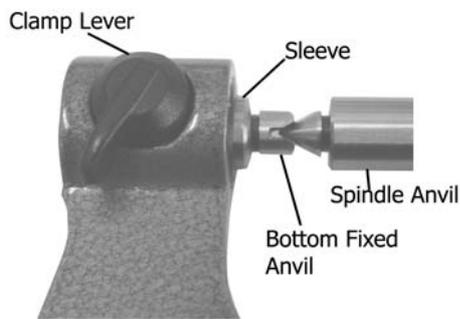


Thread Micrometers

Measumax screw thread micrometers are used to measure the pitch of a thread. The screw thread micrometer can have either 55deg, or 60deg anvils with a pointed anvil mounted in the spindle, and a V-shaped anvil mounted in the sleeve to become the bottom anvil.

Measumax screw thread micrometer is supplied with a series of anvils designed to cover most of the threads in that diameter range.

When the micrometer is set at zero, the pitch line of the spindle and bottom anvil coincide. When the micrometer is measuring the thread, it is measuring the pitch diameter of the thread.



Re-Setting the Micrometer

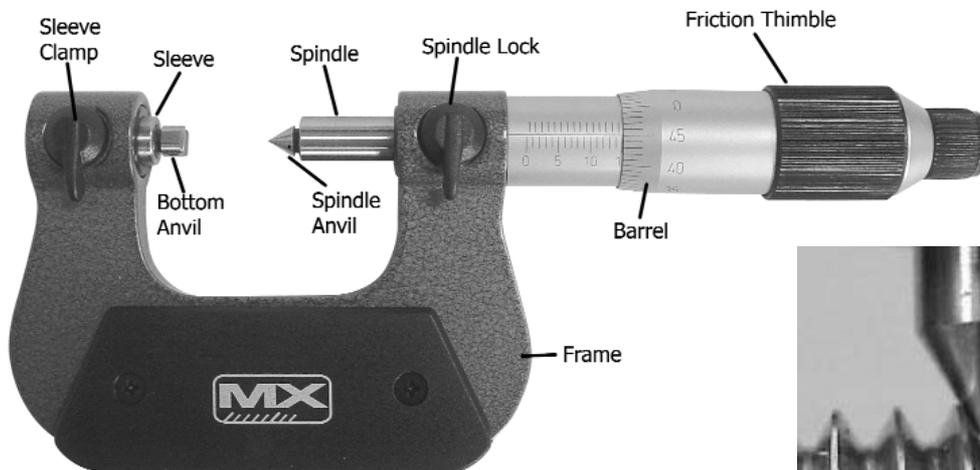
1. Select the anvils required to cover the thread pitch. The sizes are printed on the side of the anvils. (Fig.1) There will need to be a pointed anvil (Spindle anvil) and a V-shaped anvil (Bottom anvil). Make sure that both the anvils cover the thread pitch range that is to be measured.



Fig.1

The anvils are pushed in and held in place by the spring ring on the end of the anvils.

2. Loosen the sleeve lock and push the sleeve away from the spindle.
3. Set the spindle and barrel to read zero (0-1" and 0-25mm). For larger thread mics the lowest denominator should be used. (e.g. 25mm on a 25-50mm)
4. With both the anvils in place push the sleeve up gently to meet the spindle so that the anvils fit into each other, and secure the sleeve lock.
5. Withdraw the spindle slightly and bring the anvils back in contact with each other using the friction thimble. Repeat the process until the micrometer is set.

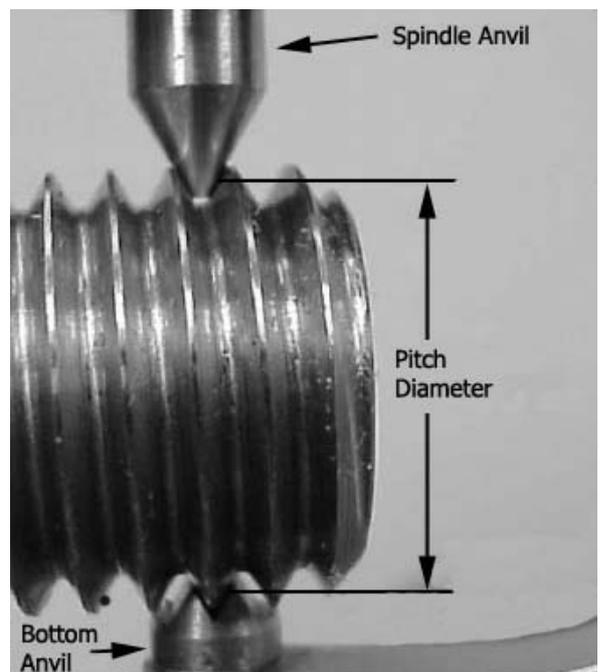


Maintenance

Before storing your Measumax micrometer, back the spindle away from the anvil, wipe all exterior surfaces with a clean, soft cloth, and coat the surfaces with a light oil.

Should the spindle become loose adjustment can be made by tightening the nut at the end of the barrel until the action is smooth and easy. (Fig 3)

"Measumax" micrometers are set and tested during production.



Measumax

Thread Micrometers

Anvils

With each micrometer a number of anvils are supplied to cover the sizes in that range. Listed below are the models and the anvils supplied with them.

Model	Size	Anvils
10-137	0-1"	F0203 - F0206
10-138	0-25mm	F0101 - F0105
10-139	25-50mm	F0102 - F0106
10-1391	50-75mm	F0102 - F0106
10-1392	75-100mm	F0102 - F0106

Code No.	SIZE	Code No.	SIZE
ANVILS IMPERIAL 55°		ANVILS METRIC 60°	
F0201	60 - 48TPI	F0101	0.4 - 0.5
F0202	48 - 40TPI	F0102	0.6 - 0.9
F0203	40 - 32TPI	F0103	1 - 1.75
F0204	32 - 24TPI	F0104	2 - 3
F0205	24 - 18TPI	F0105	3.5 - 5
F0206	18 - 14TPI	F0106	5.5 - 7
F0207	14 - 10TPI		
F0208	10 - 7TPI		

Diagram 1

1. Painted Frame
2. Barrel
3. Ratchet Thimble
4. Spindle Lock
5. Spindle
6. Anvils

Reading a 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 millimetre) are taken directly from the thimble opposite the main scale. *The reading is 3.46 mm.* (See Fig.5)

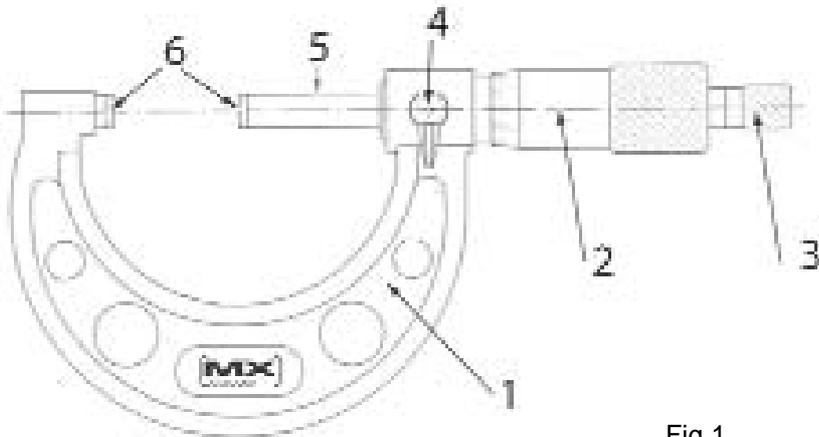


Fig 1



Fig 5

Fig 2



Fig 3



Fig 4

