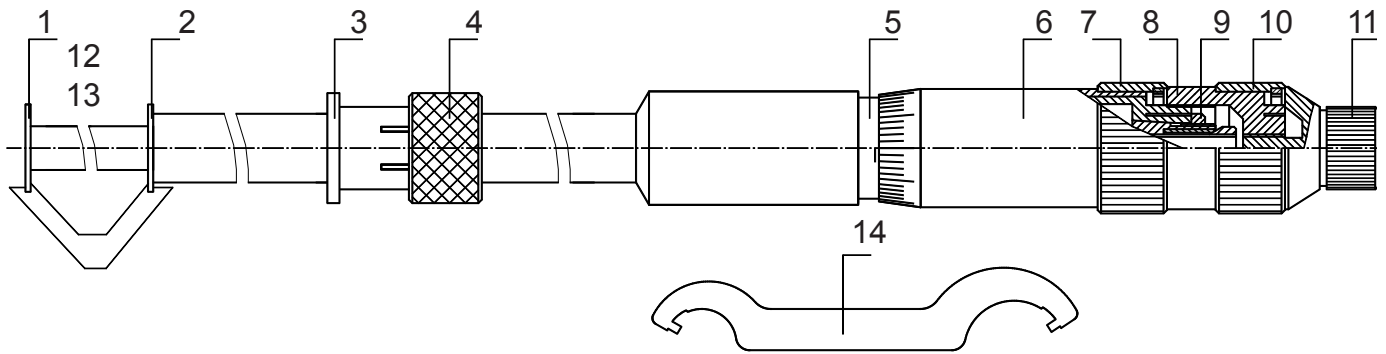


MeasumaX^{MX}

GROOVE MICROMETER

11-490, 11-491



Type B

- | | | | | |
|------------------|-----------------------------|----------------------------|------------------|----------------------------|
| 1. Movable anvil | 2. Fixed anvil | 3. Movable washer | 4. Adjusting nut | 5. Sleeve |
| 6. Thimble | 7. Outside measuring force | 8. Connecting ring | 9. Locking nut | 10. Inside measuring force |
| 11. Quick drive | 12. Outside measuring faces | 13. Inside measuring faces | 14. Spanner | |

1. Use

For measuring width and depth of grooves inside bores.

2. Zero Setting

Before using, clean the measuring faces of the movable anvil, the fixed anvil and the setting tool with soft cloth or soft paper. Bring the anvils together carefully by rotating the thimble. If the line marked "0" on the thimble does not coincide with the reference line on the sleeve, adjust zero position in the following manner:

1) Deviation within $\pm 0.01\text{mm}$

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

2) Deviation over $\pm 0.01\text{mm}$

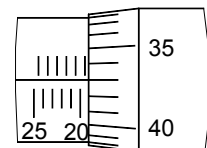
Type B: Loosen the connecting ring of the inside measuring force by hand. Unlock the locking nut with the spanner and take out the thimble. Adjust the thimble until the reference line comes exactly in line with "0" line on the sleeve. Screw down the locking nut and fasten the connecting ring of the inside measuring force.

If necessary, in the former way.

3. Reading

Min reading of the micrometer is 0.01mm.

Reading is 19.37mm. (see fig.). (Estimations can be made by 0.001mm~0.002mm).



4. Measuring method

The incremental measuring can be achieved by adjusting the adjusting nut until the movable washer is in required position.

5. Precautions

Do not disassemble or drop the instrument.

Keep the instrument clean and dry.

Return into the box supplied after apply antirust oil on the measuring jaws if the micrometer is not to be used for a long of time.