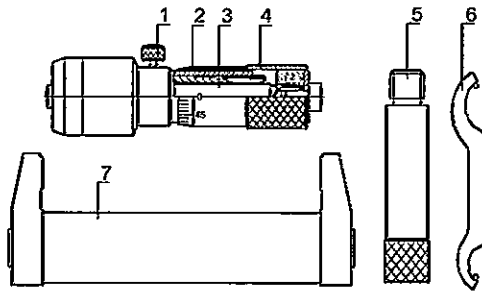


# Instruction for Inside Micrometer

Measuring Range: 2-12"



1. Lock screw
2. Barrel
3. Thread spindle
4. Thimble
5. Extension rod
6. Spanner
7. Calibration gauge

## 1. Use

It is mainly used for measuring inside dimensions.

## 2. Zero-Setting

Wipe the measuring face with soft cloth or soft paper before zero setting.

The calibration gauge is of 2". First put the micrometer head in the calibration gauge. If the zero position is correct, then the reading on the micrometer head should be zero when the two ends of the micrometer head are just against the calibration gauge.

If the zero line on the sleeve is not lined up with the zero line on the Thimble, it means the zero position is not correct, then it need to be set as follows:

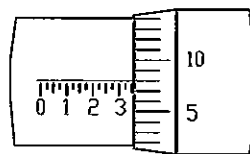
Use the lock screw to lock the thread spindle, then use the spanner to turn the sleeve until the two zero lines are lined up.

## 3. Reading

The inside size should be the sum of 2" + the length of the extension rod + the reading on the micrometer head.

The micrometer head's reading is a sum of the sleeve' reading + the thimble's reading.

The sleeve' reading is taken from the last graduation showing on the sleeve directly to the left of the revolving thimble. Note each full graduation is 0.1". The reading on the thimble is taken directly from the thimble opposite the main scale. The reading on the picture is 0.358".



Sleeve	0.35"
+ Thimble	<u>0.008"</u>
Reading	0.358"

## 4. Warning

- 1) Don't disassemble the micrometer casually.
- 2) Keep the micrometer clean and dry.
- 3) When don't use it for long time, please clean it and put it in packing case with antirust oil.

5. The extensions may be disassembled for the purpose of checking the calibration of the extension rod. An extension spanner is provided to remove the retaining nut.