MICROTECH

BORE GAUGE WITH CARBIDE CONTACTS

USER MANUAL

Calibration ISO 17025:2017

ISO 9001 BUREAU VERITAS Certification

ISO 9001:2015

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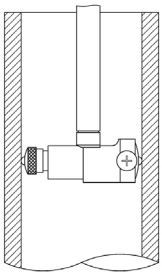
MODIFICATIONS

Item No*	Range	Depth	Rod travel	Carbide contacts	DIAL res.10 µm *X - 1	DIGITAL res. 1 µm *X - 8	COMPUTERIZED res.0.1 µm *X - 7
					Accuracy		
	mm	mm	mm		µm	µm	µm
132010X00	6-10	60		•	±8	±3	±3
132018X00	10-18	110		•	±8	±3	±3
132050X00	18-50	130	1,5	•	±12	±3	±3
132050X11		500		•	±12	±3	±3
132050X22		1000		•	±12	±3	±3
132050X44		2000		•	±12	±3	±3
132160X00	50-160	150	4	•	±15	±3	±3
132160X11		500		•	±15	±3	±3
132160X22		1000		•	±15	±3	±3
132160X44		2000		•	±15	±3	±3
132250X00	160-250	260	4	•	±15	±5	±5
132250X22		1000		•	±15	±5	±5
132250X44		2000		•	±15	±5	±5
132450X00	250-450	260	6	•	±22	±8	±8
132450X22		1000		•	±22	±8	±8
132450X44		2000		•	±22	±8	±8
132900X00	400-1000	440	8	•	±30	±12	±12
132200X22		1000		•	±30	±12	±12
132900X44		2000		•	±30	±12	±12
132951X00	130-1500	440		•	±25	±8	±8
BORE GAUGES SETS							
132160X00	18-160			•	±15	±3	±3
132450X00	18-450			•	±22	±8	±8
132990X00	6-1000			•	±30	±12	±12



INDICATORS

Analog 0,01mm

Digital 0,001mm

Compuiterized 0,0001mm

OPERATION INSTRUCTIONS

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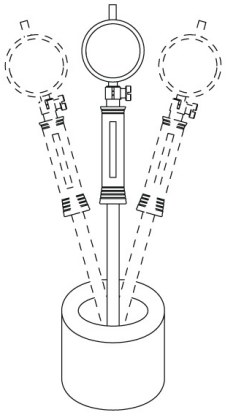
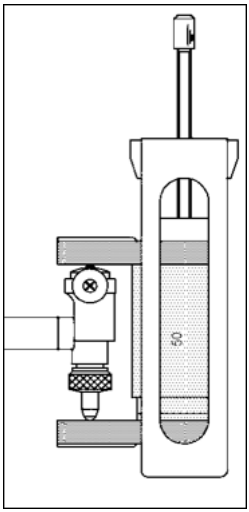


Clean oil from the measuring surfaces of bore gauge and indicator.

Attach bore gages body components to each other (if the body consists of two or more parts).

To avoid damaging the rods and threads DO NOT use excessive force when screwing body.

For the zero setting position make sure that the measurement line of bore gauge coincided with a diametrical cross-section of the setting ring. Slightly shaking bore gages in the axial plane, determine the largest reading of indicator, which is the size of ring gauge. Combine the zero mark of the scale with an arrow by turning ring. Use a clamp to fixate a ring.



In order to increase the accuracy of setting up the position of the bore gauge must be the same as in the measurement.

For the zero setting position:

- *by gauge blocks* - the appropriate size block fix in a clamp between two outsets and enter between them bore gauge. Slightly shaking bore gauge in two mutually perpendicular directions, to determine the lowest reading device, which corresponds to the block size.
- *by micrometer* - fix micrometer and enter between micrometer measuring surface bore gauge. Slightly shaking bore gauge in two mutually perpendicular directions, to determine the lowest reading device, which corresponds to micrometer indication.

IMPORTANT!

Do not make sudden shock to the measuring rod, not put more effort in the case of jamming.

Avoid contact with the indicator and oil emulsion.

Do not turn indicator when it is fixed in the tool holder by a sleeve.

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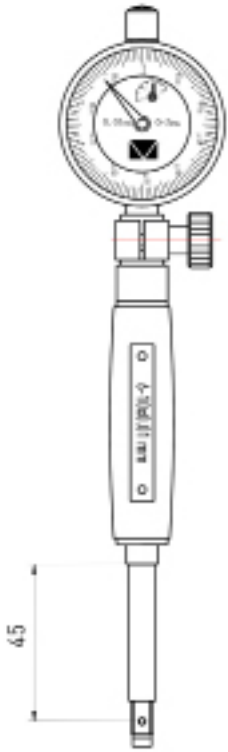
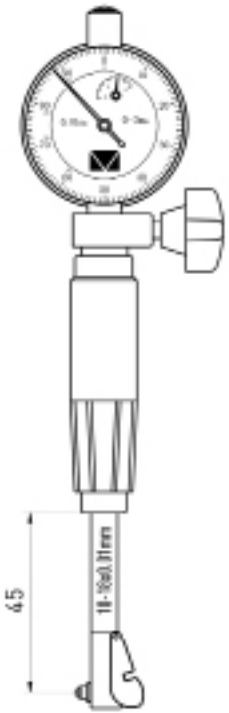
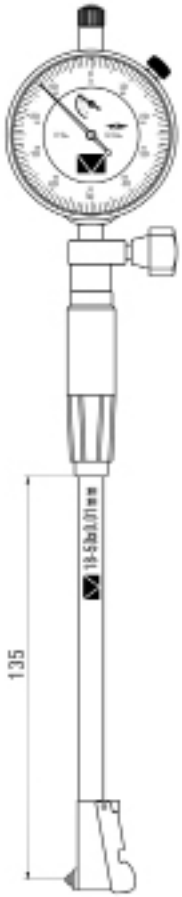


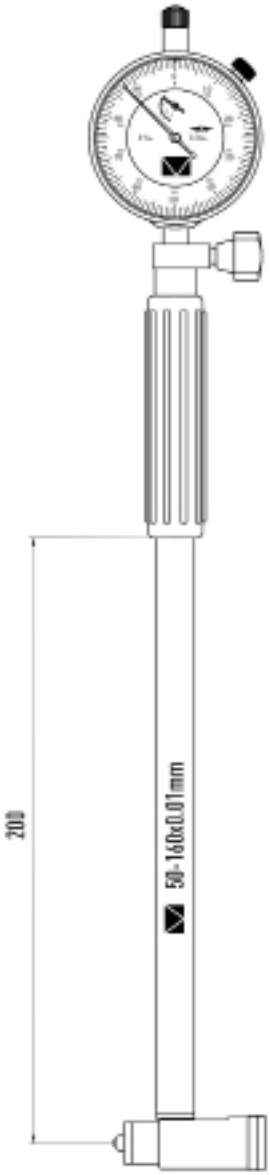
6-10mm



10-18mm



18-50mm



50-160mm
160-250mm
250-450mm

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