



DIAL BORE GAUGE

USER MANUAL



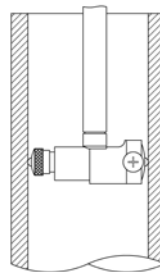
Calibration ISO 17025:2017

ISO 9001
BUREAU VERITAS
Certification



ISO 9001:2015

Item No*	Range	Depth	resolution 10 μm
			Accuracy
	mm	mm	μm
131010100	6-10	45	± 8
131018100	10-18	45	± 8
131050100	18-50	135	± 12
131050111		500	± 12
131050122		1000	± 12
131050144		2000	± 12
131160100	50-160	200	± 15
131160111		500	± 15
131160122		1000	± 15
131160144		2000	± 15
131250100	160-250	200	± 15
131250111		500	± 15
131250122		1000	± 15
131250144		2000	± 15
131450100	250-450	200	± 22
131450111		500	± 22
131450122		1000	± 22
131450144		2000	± 22
131800100	400-800	250	± 30
131800111		500	± 30
131800122		1000	± 30
131800144		2000	± 30
131900100	700-1000	400	± 30
131900122		1000	± 30
131900144		2000	± 30
WIDE RANGE BORE GAUGES			
131110100	10-100	45	± 15
131220100	20-200	200	± 15
131224100	50-250	200	± 15
131225100	18-250	150	± 20
131951100	130-1500	500	± 25



OPERATION INSTRUCTIONS

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).

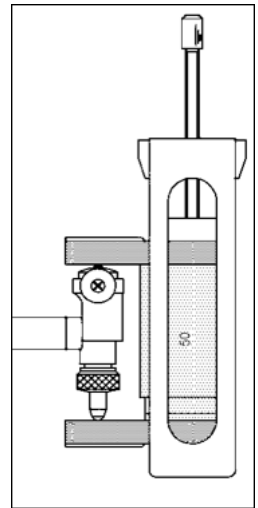
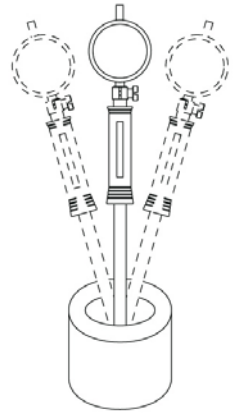
To avoid damaging the rods and threads DO NOT use excessive force when screwing body.

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 outlets 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.



IMPORTANT!

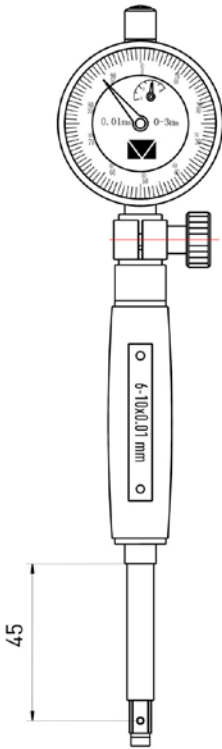
Do not make sudden shock to the measuring rod, not put more effort in the case of jamming.

Avoid contact with the indicator and oil emulsion.

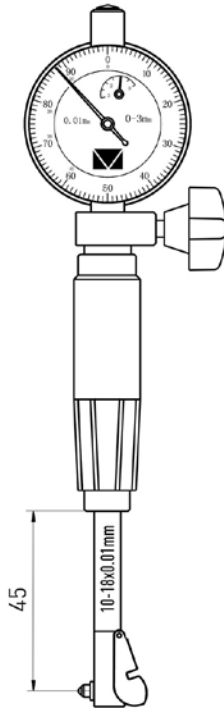
Do not turn indicator when it is fixed in the tool holder by a sleeve.



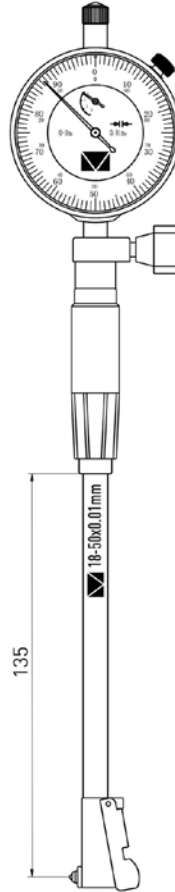
MICROTECH



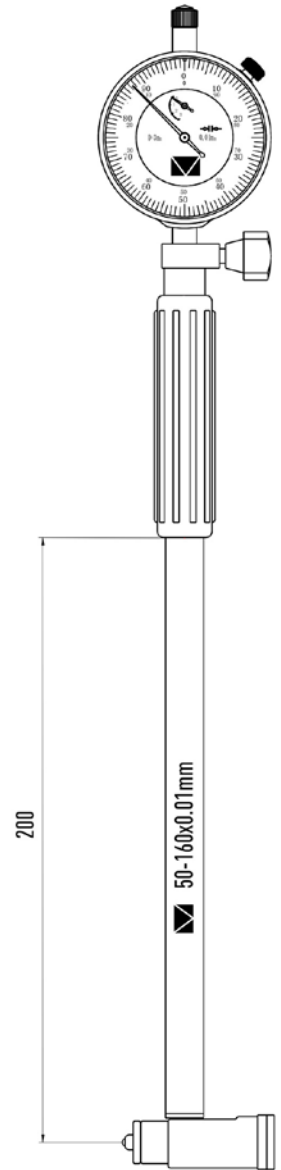
6-10mm



10-18mm



18-50mm



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