

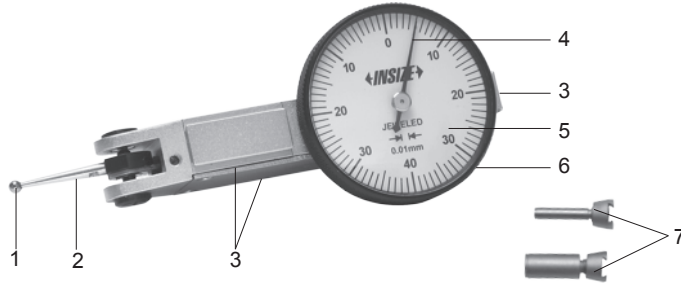


OPERATION INSTRUCTION

Dial Test Indicator

Range	Graduation	Accuracy	Hysteresis
0.8mm	0.01mm	0.013mm	0.003mm
0.2mm	0.002mm	0.006mm	0.002mm

- 1-Contact point
- 2-Styli
- 3-Dovetail groove
- 4-Needle
- 5-Dial face
- 6-Bezel
- 7-Clamps



Caution: ---Prevent dust or liquid from getting into dial test indicator through the hole, otherwise, the internal gear will be seized up(fig.1)
 ---Avoid the impact of the styli

1. Dial test indicator should be fixed as below:

- It can be fixed by dovetail groove directly (fig.2)
- It can be fixed by clamp(fig.3)

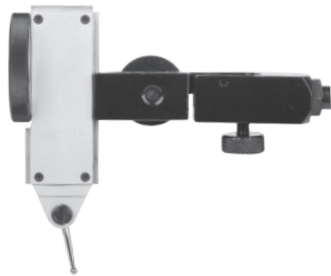


fig.2

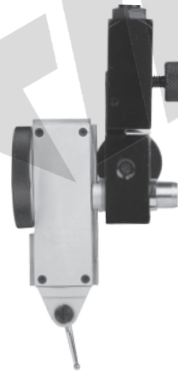
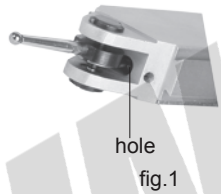


fig.3

2. During measurement, styli should be vertical to measuring direction (fig.4). When the styli is at an angle with the measuring direction (fig.5), the following correction should be made.

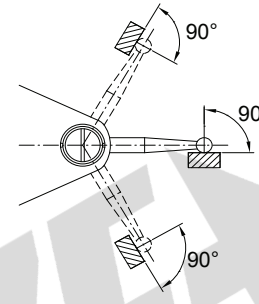


fig.4

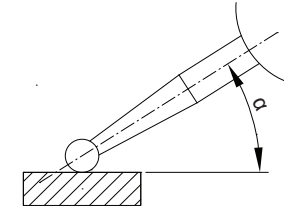


fig.5

Angle α	10°	20°	30°	40°	50°	60°
Correction	0.985	0.940	0.866	0.766	0.643	0.500

For example: angle α is 10°, the correction is 0.985, if the reading is 0.25mm, then:
 True value = 0.25mm × 0.985 = 0.246mm

3. Each type of dial test indicator has specific length of styli (L, fig.6). If the length is not correct, measurement error will result. Please refer to the table to choose correct styli series 6284.

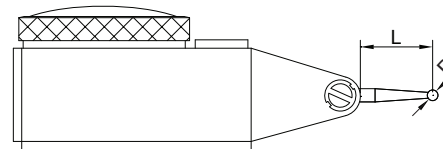


图6

Code	For dial test indicator	Material of contact point	L	D
6284-1	2380-08	steel	13.5	SØ1
6284-3	2381-08	carbide	13.5	SØ2
6284-4	2398-08	ruby	13.5	SØ2
6284-8	2399-08	carbide	13.5	SØ3
6284-21	2380-02 2381-02	steel	12.5	SØ1
6284-22		carbide	12.5	SØ2
6284-23		carbide	12.5	SØ3
6284-81	2383-08A	steel	27.4	SØ1
6284-82		carbide	27.4	SØ2
6284-83		ruby	27.4	SØ2
6284-84		carbide	27.4	SØ3

MN-TI01-C/E