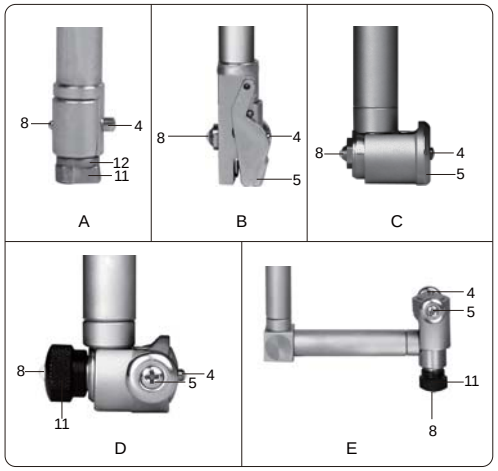
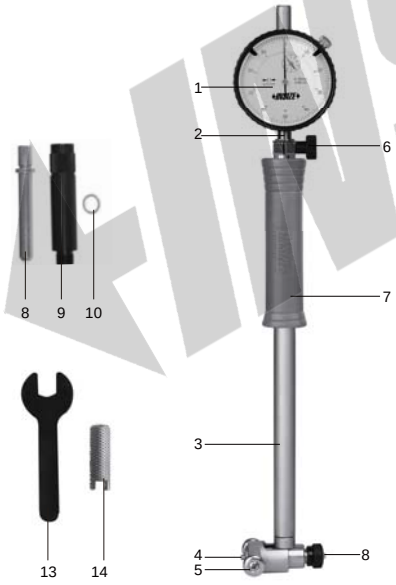
OPERATION INSTRUCTION

Bore Gage

Code	Range	Indicator	Accuracy	Repeatability	Contact point
2852-10	6-10mm	dial indicator, range 3mm graduation 0.01mm(code 2311-3F)	±0.012mm	0.003mm	A
2852-18	10-18.5mm		±0.012mm	0.003mm	B
2322-35A	18-35mm	dial indicator, range 10mm, graduation 0.01mm (code 2308-10FA)	±0.015mm	0.003mm	C
2322-60A	35-60mm		±0.018mm	0.003mm	D
2322-100A	50-100mm		±0.018mm	0.003mm	D
2322-160A	50-160mm		±0.018mm	0.003mm	D
2322-161A	100-160mm		±0.018mm	0.003mm	D
2322-250A	160-250mm		±0.018mm	0.003mm	D
2322-450A	250-450mm		±0.018mm	0.003mm	D
2827-160A	50-160mm		±0.018mm	0.003mm	E
2827-250A	160-250mm		±0.018mm	0.003mm	E
2827-450A	250-450mm		±0.018mm	0.003mm	E

Contact point

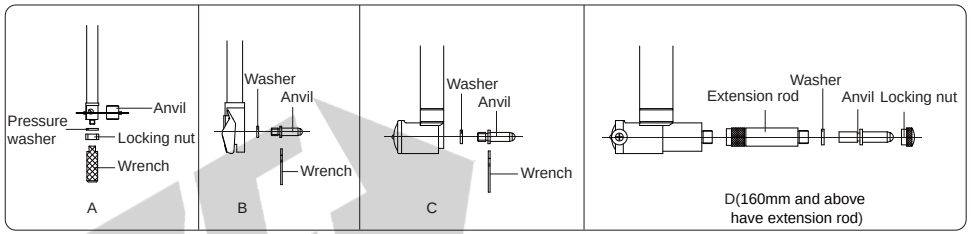




2322-160A

1-Dial indicator
2-Stem
3-Main pole
4-Contact point
5-Protect bridge
6-Locking device
7-Handle
8-Anvil
9-Extension rod
10-Washer
11-Locking nut
12-Pressure washer
13-Wrench(2852-18, 2322-35A)
14-Wrench(2852-10)

1. The bore gage used to compare measurement. It is mainly used for measuring internal diameter size.
2. Usage:
   (1)Set size: Choose anvil, extension rod and washer according to the size of workpiece, then install them as follow figures, please make each part be installed steadily. Use wrench to tighten the anvil when range is less than 35mm. Press contact point several times after installation, the pointer of indicator move smoothly, flexibly.



   (2)Set calibration size: Select setting ring, outside micrometer, or standard workpiece, clean measuring faces with soft cloth.
   (3)Set zero(as setting ring gage for a example): Insert the bore gage into setting ring and sway the bore gage wiggly(fig.1), to find the "turning point" of the pointer(the maximum reading of the dial indicator). Loosen bezel locking screw and rotate bezel to make "zero line" coincide with "turning point", then tighten bezel locking screw. Sway the bore gage wiggly several times to make sure the "zero line" coincide with the "turning point".

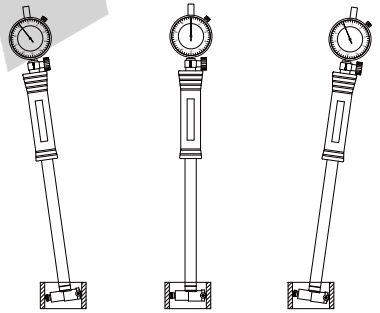


Fig.1

   (4)Measuring: Insert the bore gage into workpiece and sway it wiggly several times to find the "turning point" of the pointer(the minimum reading of the workpiece). Get the result, the reading is deviation from the normal value.

   Caution: Please do not insert the bore gage into workpiece or setting ring from the anvil side. It is necessary to press the contact point and protect bridge into setting ring or workpiece firstly, then make the anvil contact with the inwall and turn the bore gage upright slightly.

3. Optional accessories: setting ring(series 6312), anvil(series 7350).