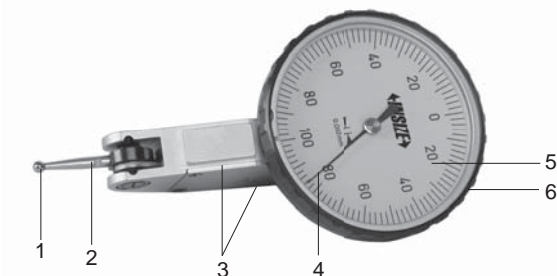




OPERATION INSTRUCTION

Dial Test Indicator 2880-02

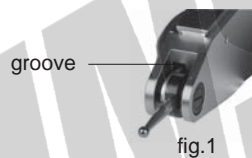
Range: 0.2mm
 Graduation: 0.002mm
 Accuracy(f_{ges}): 0.004mm
 Hysteresis(f_u): 0.002mm



- 1-Contact point
- 2-Styli
- 3-Dovetail groove
- 4-Needle
- 5-Dial face
- 6-Bezel
- 7-Clamp(diameter \varnothing 8mm)



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



1. Dial test indicator should be fixed firmly to use. It can be fixed by dovetail groove directly (fig.2), also can be fixed by clamp(fig.3).



fig.2

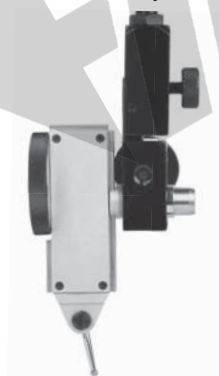


fig.3

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.

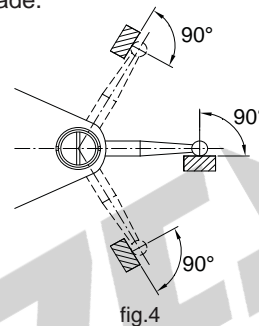


fig.4

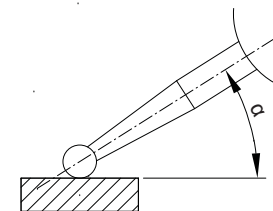


fig.5

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 0.15mm, then:
 True value = 0.15mm \times 0.985 = 0.148mm

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 following table to choose correct styli.

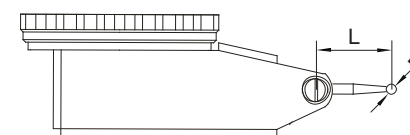


fig.6

Code	For dial test indicator	Material of contact point	L	D
6284-41	2880-02	steel	15.3	S \varnothing 1
6284-42		carbide	15.3	S \varnothing 2
6284-43		carbide	15.3	S \varnothing 3

(mm)

MN-2880-02-C/E