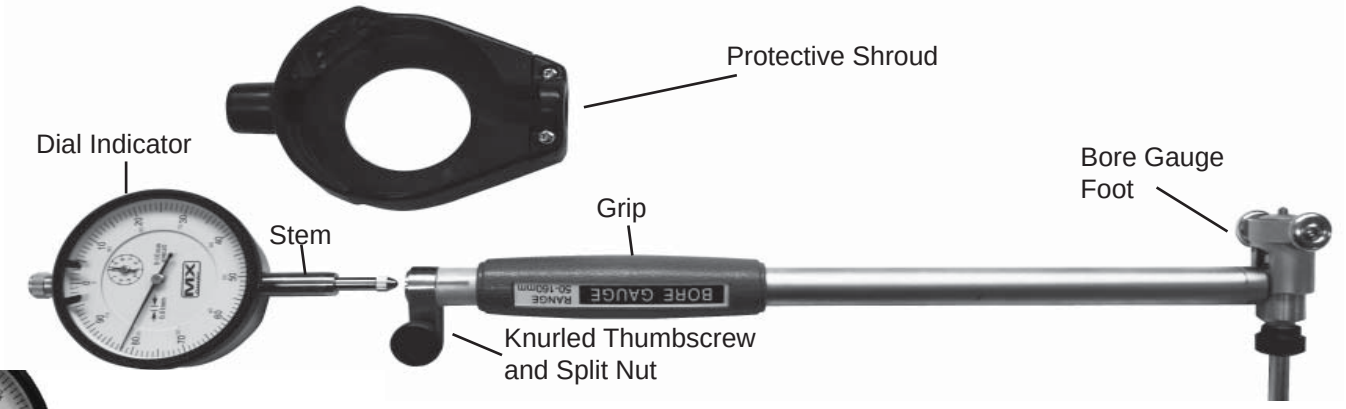
MeasumaX MX

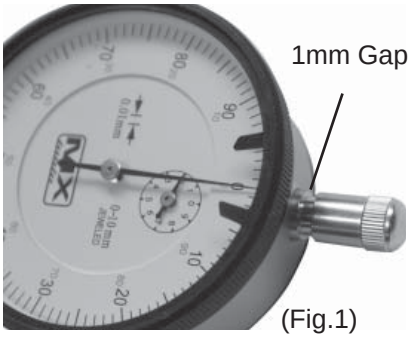
DIAL BORE GAUGES

34-226, 34-2265, 34-227, 34-228, 34-229, 34-230, 34-231, 34-232



Assembling the Dial Bore Gauge

1. Remove dial indicator from the protective shroud and remover the plastic spindle protector
2. Insert the indicator stem into top of bore gauge
3. Position the indicator stem into bore gauge with one revolution of dial gauge hand so that the spindle end has 1mm gap between the body and the end of the spindle (Fig.1)
   Use the knurled thumbscrew on the split clamp to clamp the indicator.
4. Select the anvil and shim washer to get nearest to required measurement size.
5. Fit the shim washers behind datum flange on the anvil
6. Remove the knurled retaining nut from the bore gauge foot and insert the anvil with the shims. Replace the retaining nut and clamp the anvil positively.

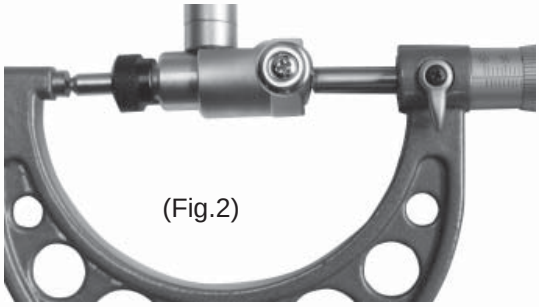


(Fig.1)

Setting the Dial Bore Gauge

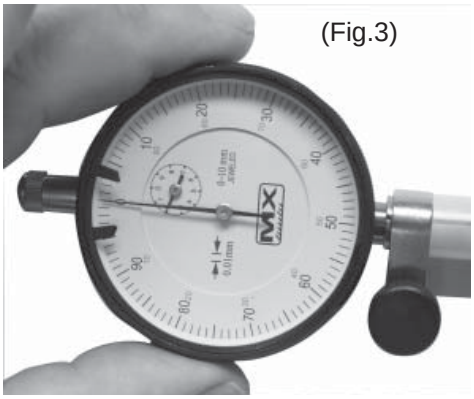
7. At this stage it is necessary to set the gauge to the size that is to be measured This can be done with a ring gauge, Zero checker with gauge blocks, or a pre-set micrometer.
8. Insert the anvils of the bore gauge into the ring gauge or between the faces of the setting master or micrometer anvil faces
9. Rock the bore gauge in ring or between the setting master faces to achieve the correct dimension. If the indicator needle does not coincide with the zero on the dial, re-position the dial gauge down the top of the bore gauge stem to achieve this position.
   The final setting of zero can be made by rotating dial gauge bezel so that the zero coincides exactly with the zero point on the indicator scale. (Fig 3)

Re-check the size in the setting gauge or with the micrometer
Finally replace protective shroud and clamp firmly the indicator stem to top of bore gauge body. (Fig.4)



(Fig.2)

(Fig.4)



(Fig.3)

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