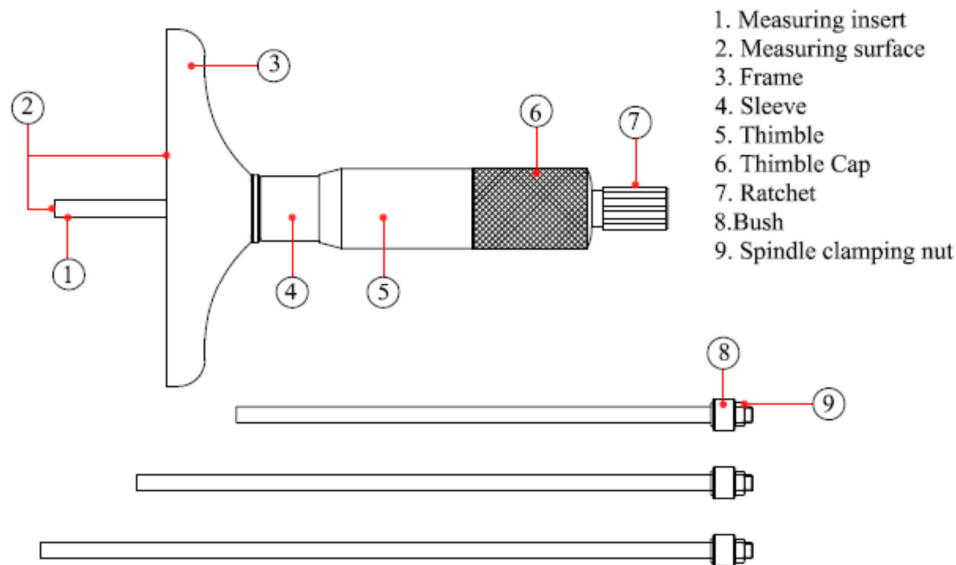


## Zero Setting Procedure for Depth Micrometer 0-100 mm



1. Before measurement and after changing the measuring range, check the zero setting referring fig.(a)

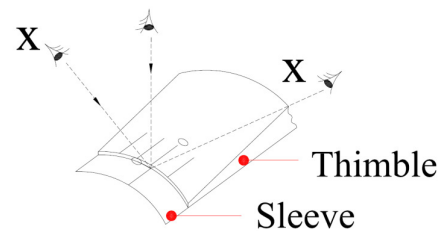


fig.(a)

First clean the measuring surface. Next Set the measuring surface on a flat surface such as a precision surface plate fig. (b) and apply an appropriate measuring force with ratchet. Then, make sure the zero line of the thimble coincides with the index line of the sleeve. If not, adjust the zero setting as per following.

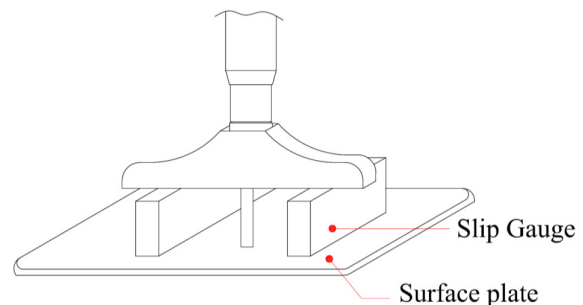


fig.(b)

### a. The zero point error is less than $\pm 0.02$ mm

Insert the spanner key into the hole on the sleeve on the opposite side of the index Line, and rotate the sleeve to align the index line with the thimble zero line.

### b. The zero point error is greater than $\pm 0.02$ mm.

- i. Unscrew the thimble cap while holding the thimble in your fingers.
- ii. Loosen the thimble lock nut with the spanner while holding the thimble in your fingers.

- iii. Press the thimble outward (in the direction of ratchet) so that it can freely move, then align the thimble zero line with the sleeve index line.
- iv. Push the thimble slightly back toward the sleeve. Tighten the thimble lock nut with the spanner while holding the thimble in your fingers

### Changing Measuring Range -

- i. Unscrew the thimble cap while holding the thimble in your fingers.
- ii. Pull the rod out fig.(c) from the thimble, and set a rod of the appropriate size there.
- iii. Screw the thimble cap into the thimble while holding the thimble in your fingers.

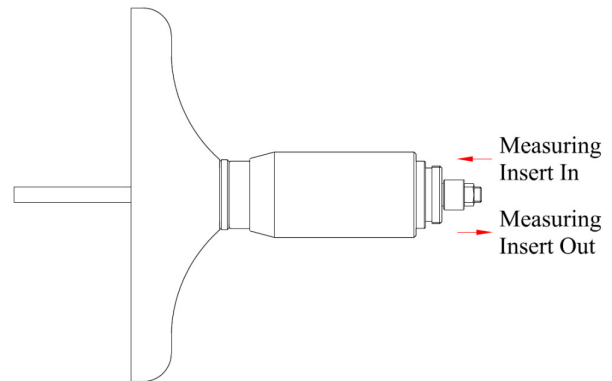


fig.(c)

### Zero setting adjustment of measuring insert

The Measuring insert have been zero adjusted before shipment, so refrain from further adjustment unless a error is found in the following Check. First check that the zero is set properly using the 0-25 mm. Then, check the zero position using a Measuring insert of size intended for measurement. If error is found, perform the following steps.

- i. Unscrew the thimble cap, holding the thimble in your fingers.
- ii. Pull the Measuring insert out from the thimble.
- iii. Loosen the spindle clamping nut with help of spanner. fig. (d)
- iv. Then, loosen the two setscrews in the bush of Measuring insert by using Allen key, push the bush toward or backward of the nut as per observed error.
- v. If Measuring insert adjustment is complete, tighten the two setscrews in the bush on spindle securely.
- vi. Tighten the spindle clamping nut with help of spanner.

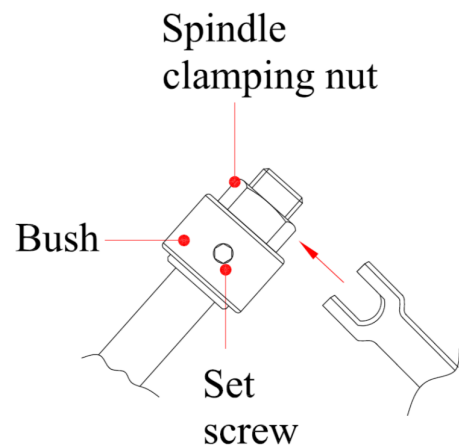


fig.(d)