

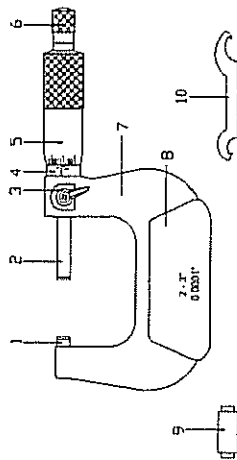
OPERATION INSTRUCTION

Micrometer

MM-01E MM-02E MM-03E MM-04E MM-05E MM-06E

Measuring range	Accuracy
MM-01E 0-1"	0.00016"
MM-02E 1-2"	0.00016"
MM-03E 2-3"	0.00020"
MM-04E 3-4"	0.00020"
MM-05E 4-5"	0.00024"
MM-06E 5-6"	0.00024"

Graduation: 0.0001"

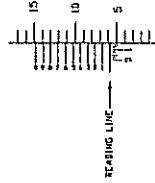


- 1-Anvil with carbide measuring face
- 2-Spindle with carbide measuring face
- 3-Locking lever
- 4-Sleeve
- 5-Thimble
- 6-Ratchet screw
- 7-Frame
- 8-Heat isolation plate
- 9-Standard rod(except 0-1")
- 10-Adjusting wrench

1. Clean measuring faces before use.
2. Remove cutting chips, dust, burrs and other foreign substance from the piece to be measured.

3. Let anvil contact with the piece first, rotate thimble or ratchet screw until spindle is close to, but not in contact with the piece. Rotate ratchet screw until you hear click. Do not rotate thimble allowing spindle to come in contact with the piece, which may damage the internal threads of micrometer.

4. Reading
- Example:



Highest figure shown on sleeve is '1' = 0.1"
 There are 2 visible lines between '1' line on sleeve and edge of thimble 2×0.025 = 0.05"
 '5' line on thimble lies below the reading line on sleeve = 0.005"
 Line '8' on sleeve coincides with a line on thimble = 0.008"

The reading is: initial length + 0.15; 8"
 The initial length is zero for 0-1" micrometer, 1" for 1-2" micrometer, 2" for 2-3" micrometer, 3" for 3-4" micrometer, 4" for 4-5" micrometer and 5" for 5-6" micrometer.

5. Micrometer should be frequently checked to make sure that it is properly calibrated. When micrometer measures the corresponding standard rod, reading must be the length of standard rod (0-1" micrometer does not have standard rod and reading should be zero when spindle is in contact with anvil), otherwise you should adjust micrometer. Put the small point of adjusting wrench into the small hole on sleeve near locking lever, rotate sleeve to make the reading to be the length of standard rod (zero for 0-1" micrometer). The other end of adjusting wrench is to tighten or loosen ratchet screw.

6. Tighten locking lever to hold reading.
7. Measuring faces should be carefully protected from being scratched or damaged. Do not operate abruptly, drop or strike micrometer. Spindle, anvil and standard rods should be oiled to prevent rust.