



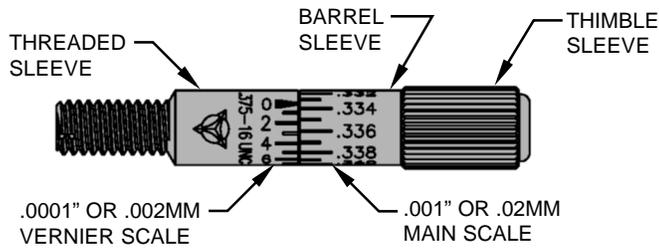
MULTI-BALL™

Internal Thread Micrometer

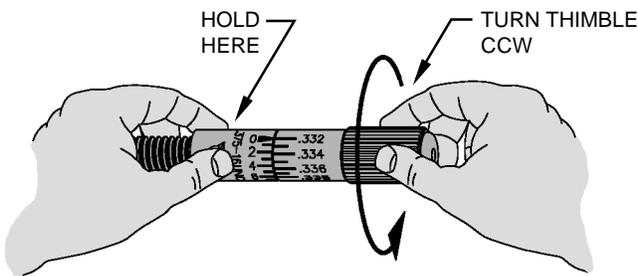
Calibration Instructions



Typical Setting-Ring

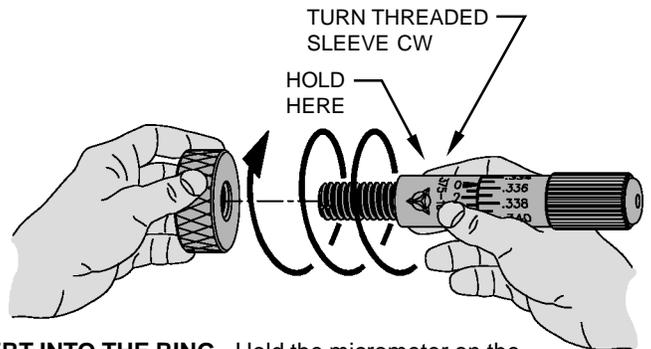


1.



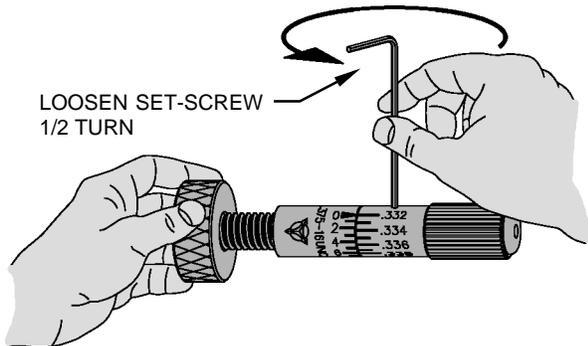
RETRACT THE BALLS - Turn the thimble counterclockwise to the limit stop. **Do Not** attempt to insert the micrometer into the setting-ring without first retracting the balls.

2.



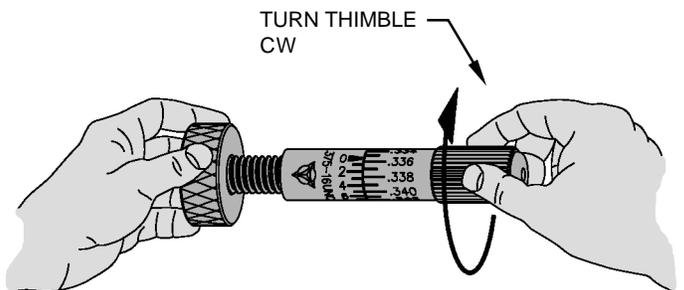
INSERT INTO THE RING - Hold the micrometer on the threaded sleeve only. Insert the micrometer so that the balls are positioned at the approximate midpoint of the setting-ring.

3.

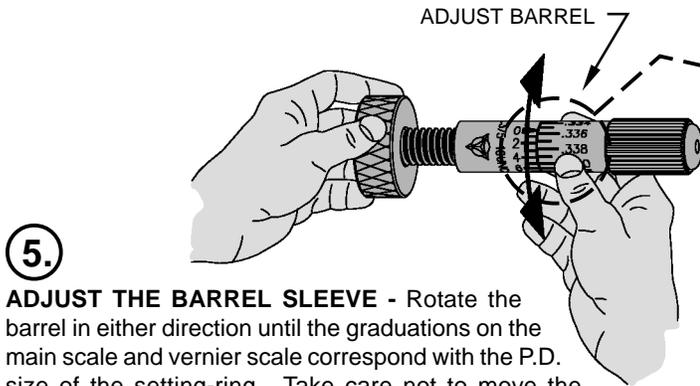


LOOSEN THE BARREL SLEEVE - Using a .050" hex key wrench, loosen the set-screw on the side of the barrel 1/2 turn.

4.

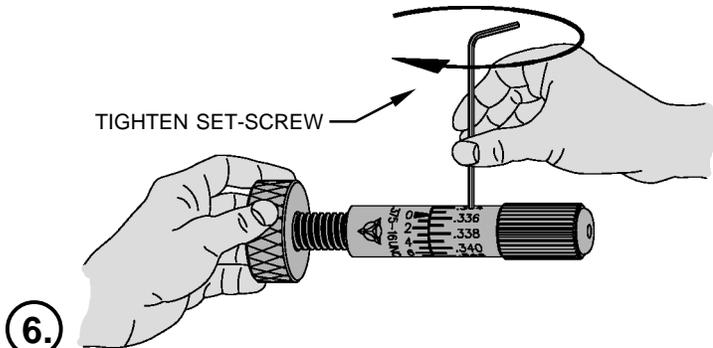


ENGAGE THE BALLS WITH THE SETTING-RING - Turn the thimble clockwise until the thimble slips.

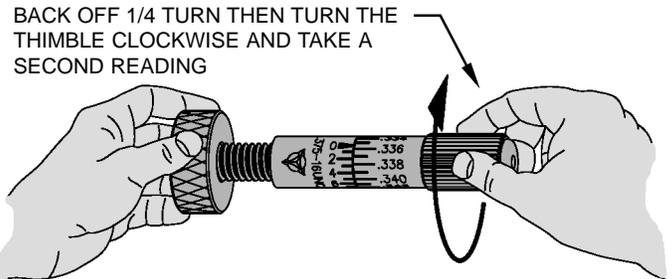


5.
ADJUST THE BARREL SLEEVE - Rotate the barrel in either direction until the graduations on the main scale and vernier scale correspond with the P.D. size of the setting-ring. Take care not to move the thimble or threaded sleeve.

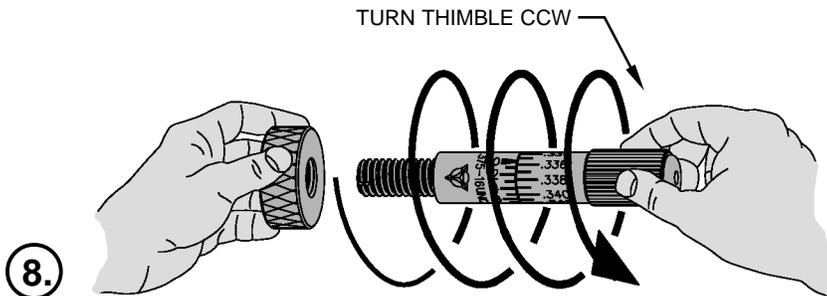
The barrel is adjusted so that the main scale and vernier scale correspond with the setting-ring P.D. size.



6.
TIGHTEN THE SET-SCREW - Lightly tighten the set-screw by turning the hex key clockwise. Take care not to move the barrel from the set position.



7.
DOUBLE CHECK THE READING - Turn the thimble counterclockwise about 1/4 turn then turn it clockwise until the thimble slips. Check the micrometer reading to be sure it corresponds to the P.D. size of the setting-ring.



8.
REMOVE THE MICROMETER FROM THE SETTING-RING - Turn the thimble counterclockwise to retract the balls then continue turning until the micrometer is completely removed.

MULTI-BALL™ Thread Inspection Products Are Available From:



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