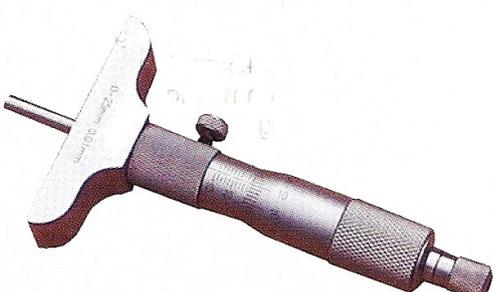
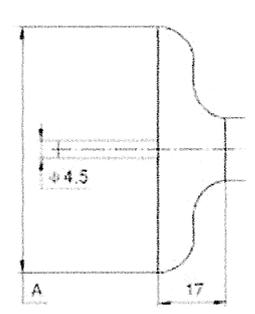


Mechanical Depth Micrometers

	<p>Accuracy conforms to DIN 863 Resolution: Metric 0.01mm, Inch 0.001” Micro fine graduations for accurate reading Hardened and ground base Spindle locking lever Ratchet stop Non-glare satin chrome barrel and sleeve Supplied in fitted case with adjustment tools</p>
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Packed Weight and Dimensions

Code	Range	Code	Range	Weight g	W mm	H mm	L mm
Metric	mm	Inch	inch				
50-170-025	0-25	50-170-001	0-1	461	132	30	250
50-175-100	0-100	50-175-004	0-4	583	132	30	250
50-175-150	0-150	50-175-006	0-6	666	160	37	268

	<table border="1"> <thead> <tr> <th>Code</th> <th>Range mm/Inch</th> <th>A Mm/in</th> <th>Rods</th> <th>Accuracy Mm/in</th> </tr> </thead> <tbody> <tr> <td>50-170-025</td> <td>0-25</td> <td>63</td> <td>1</td> <td>0.004</td> </tr> <tr> <td>50-175-100</td> <td>0-100</td> <td>101.5</td> <td>4</td> <td>0.005</td> </tr> <tr> <td>50-175-150</td> <td>0-150</td> <td>101.5</td> <td>6</td> <td>0.005</td> </tr> <tr> <td>50-170-001</td> <td>0-1</td> <td>2.5</td> <td>1</td> <td>0.00016</td> </tr> <tr> <td>50-175-004</td> <td>0-4</td> <td>4</td> <td>4</td> <td>0.0002</td> </tr> <tr> <td>50-175-006</td> <td>0-6</td> <td>4</td> <td>6</td> <td>0.0002</td> </tr> </tbody> </table>	Code	Range mm/Inch	A Mm/in	Rods	Accuracy Mm/in	50-170-025	0-25	63	1	0.004	50-175-100	0-100	101.5	4	0.005	50-175-150	0-150	101.5	6	0.005	50-170-001	0-1	2.5	1	0.00016	50-175-004	0-4	4	4	0.0002	50-175-006	0-6	4	6	0.0002
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Instructions and Care

Recommended Setting Method for 0 -25mm Depth Rod

- Check all new and in use micrometers for correct zero setting prior to use
- Clean micrometer depth rod and base with soft cloth or paper to remove any oil or particles which may affect the measurements
- Insert spring retaining end of depth rod into base of instrument
- Ensure that the micrometer is thermally stabilised with the temperature where it is to be used
- Ensure that the spindle lock is off
- Push rod firmly until it positively engages with datum stop inside micrometer body
- Wind depth rod up into base
- Place base onto a clean flat surface plate
- Hold base firm against surface plate and advance depth rod to contact surface plate using the ratchet stop
- Use the ratchet stop to obtain repeat readings on the surface plate
- In this position the zero position on the thimble should coincide with the horizontal line on the sleeve
- If the two lines do not coincide, small adjustments can be made by using the “C” spanner provided
- Insert the “C” spanner into the hole at the back of the sleeve and gently turn the sleeve in the direction required to achieve line up
- The micrometer is now set and ready for use

Mechanical Depth Micrometers

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Recommended Setting Method for Depth Rods above 25mm

Clean micrometer base and required depth rod

Insert spring retaining end of depth rod into base of instrument

Push rod firmly until it positively engages with datum stop inside micrometer body

Stand 2 equal piles of gauge blocks on the surface plate at a size within the range of the selected rod

Sit micrometer base across gauge block piles

Hold base firm against gauge piles and advance depth rod to contact surface plate using the ratchet stop

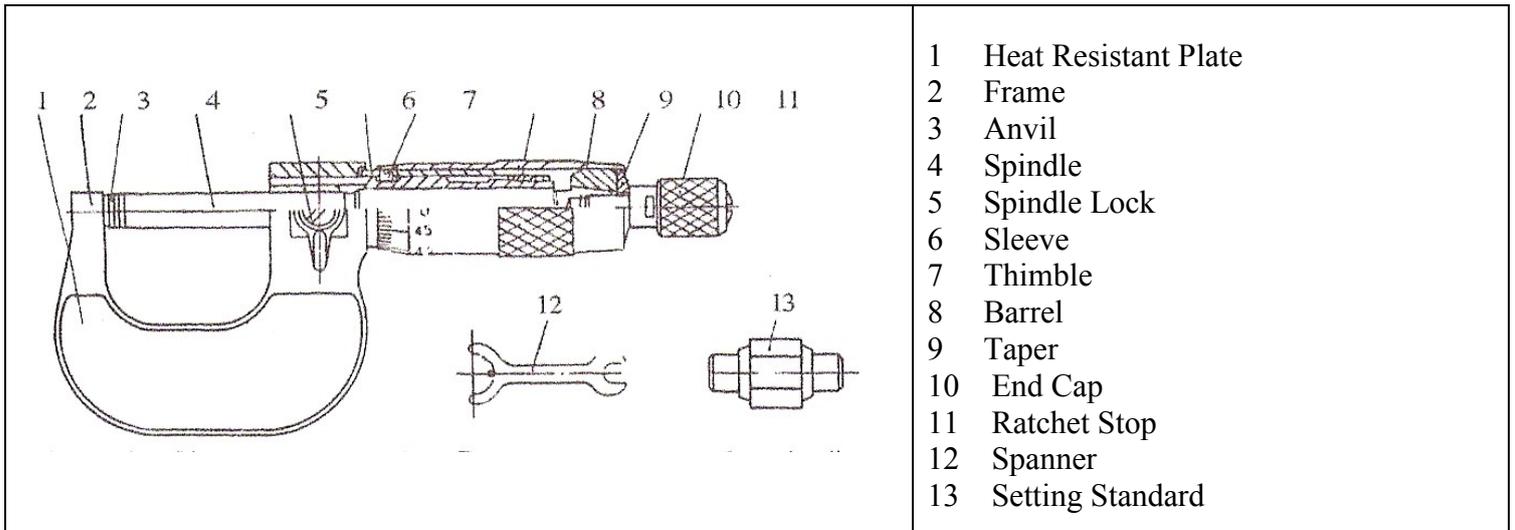
Use the ratchet stop to obtain repeat readings on the surface plate

In this position the zero position on the thimble should coincide with the horizontal line on the sleeve

If the two lines do not coincide, small adjustments can be made by using the "C" spanner provided

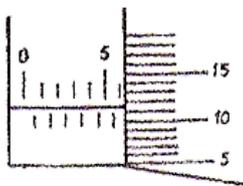
Insert the "C" spanner into the hole at the back of the sleeve and gently turn the sleeve in the direction required to achieve line up

The micrometer is now set and ready for use

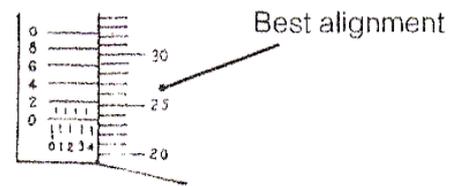


- 1 Heat Resistant Plate
- 2 Frame
- 3 Anvil
- 4 Spindle
- 5 Spindle Lock
- 6 Sleeve
- 7 Thimble
- 8 Barrel
- 9 Taper
- 10 End Cap
- 11 Ratchet Stop
- 12 Spanner
- 13 Setting Standard

Reading Examples: Metric

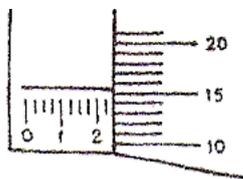


Example for division 0.01mm
 Reading:
 From Sleeve: 6mm
 From thimble: 0.11mm
 Final readings should be
 $6. + 0.11 = 6.11\text{mm}$

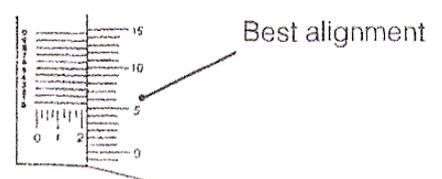


Example for division 0.002mm
 Reading:
 From Sleeve: 4mm
 From thimble: 0.23mm
 From vernier of sleeve: 0.004mm
 Final readings should be
 $4 + 0.23 + 0.004 = 4.234\text{mm}$

Reading Examples: Inch



Example for division .001"
 Reading:
 From sleeve: .2000"
 $.2 + .025 = .225"$
 From thimble: .0150"
 Final readings should be:
 $.2000" + .0250" + .0150" = .2400"$



Example for division 0.0001"
 Reading:
 From Sleeve: .2000"
 $.2 + .025 = .225"$
 From thimble: .0050"
 From vernier of sleeve: .0004"
 Final readings should be
 $.2000" + .0250" + .0050" + .0004" = .2304"$

Mechanical Micrometers

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Cleaning and Basic Checking Procedure

Remove any oil, grease, dust or small particles which may cause damage to the micrometer or affect its accuracy when taking measurements. Use a soft lint free cloth or paper together with a proprietary instrument cleaning agent. Do not use acetone as this can damage parts of the micrometer

Before use check that the ratchet mechanism functions correctly

Check the spindle movement by using the ratchet stop to traverse the spindle through its complete travel

Check that the measuring faces are in good condition

Check the locking mechanism works correctly

Zero Point Checking and Adjustment

Use the ratchet stop to move the spindle until it touches the fixed anvil. Allow the ratchet to turn $1\frac{1}{2}$ to 2 revolutions for the final positioning

The zero point on the thimble should now coincide with the reference graduated base line on the sleeve

For micrometers above 25mm / 1" use the supplied setting standard or a gauge block to check the zero position

If the zero point does not line up as required, it can be corrected by using the following procedure

When the zero point deviation on the thimble is under 2 divisions from the graduated base line

Turn the sleeve using the "C" spanner provided until correct alignment is achieved

When the zero point deviation on the thimble is over 2 divisions from the graduated base line

Hold the frame and the thimble and loosen the ratchet stop using the spanner provided

Disconnect the coupling of the thimble to the spindle by giving a light shock to the side of the thimble

Turn the thimble until the zero point is in alignment with the base line on the sleeve

Press the thimble against the spindle and re-tighten with the spanner to achieve a positive coupling

Re-check the zero position, any final small adjustment can now be made using the "C" spanner to re-position the sleeve to the thimble zero

Reading the Micrometer

When reading the micrometer ensure that your line of sight is directly above the graduated scale on the sleeve and the thimble scale to avoid parallax reading errors

Ensure that the micrometer and the work piece are at the same temperature

Handle the instrument with care, if it is dropped or knocked in any way it must be rechecked for correct working and accuracy as above