

Applicable products

186-012-11 / 186-024-11 / 186-040-11

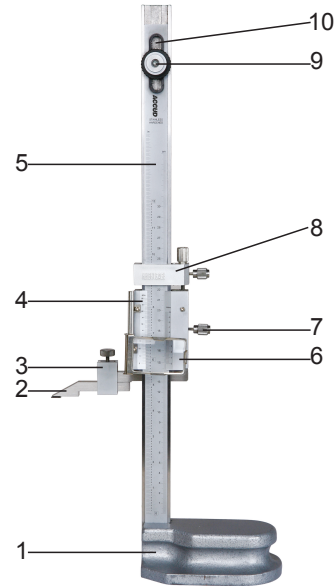
Graduation: 0.02mm/0.001"

Accuracy: $\pm 0.04\text{mm}$ (Range: 0-300mm)

$\pm 0.05\text{mm}$ (Range: 300-600mm)

$\pm 0.07\text{mm}$ (Range: 600-1000mm)

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|-----------|-------------------------|
| ① Base | ⑥ Magnifier |
| ② Scriber | ⑦ Locking screw |
| ③ Clamp | ⑧ Fine adjustment frame |
| ④ Vernier | ⑨ Locking nut |
| ⑤ Beam | ⑩ Adjustment nut |



1. Precautions before use

- This product is used to measure the height size and scribe.
- Clean the bottom of base and the scriber, install the scriber, put the height gage on an inspection plate.
- The height gage should be set zero before measuring:
 - Make sure the bottom of the base and the inspection plate is clean, without burrs and scratches and other effects.
 - Lower the scriber, make the measuring surface and the bottom of the base at the same level, check whether the reading is zero. If there is deviation, move the beam to set zero.
 - How to set zero:
 - Loosen locking nut, rotate adjustment nut, and can move beam up and down, adjust zero position, so that the zero position of vernier coincides with the beam.
 - Tighten the locking nut to finish the calibration.

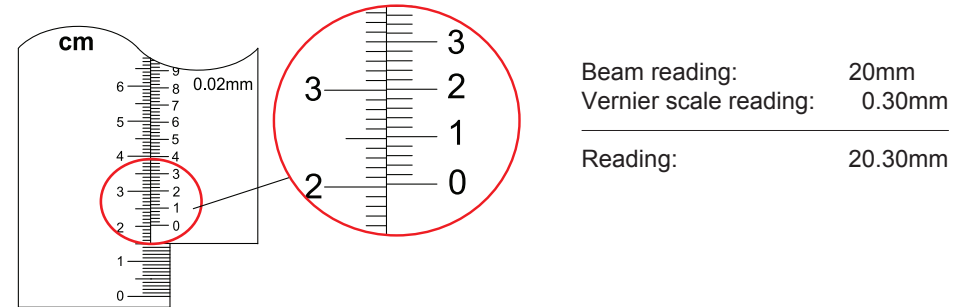
2. Measurement

- Check the bottom of the base and the inspection plate is clean, without burrs and scratches and other effects.
- When measuring the height, raise the measuring surface of the scriber slightly higher than the measured height of the workpiece, and then use the fine adjustment frame to make the measuring surface of the scriber contact with the measured surface of the workpiece and then get the reading. Be careful of the measuring force to avoid the measurement error.

- Use dial test indicator (precision dial test indicator or dial indicator) instead of scriber to position to improve measurement accuracy. Install dial test indicator into the holder. Firstly make the dial test indicator touch with the inspection plate and set zero, get the reading a_1 from the height gage, and then move the beam to make the contact point contact with the upper surface of the workpiece and set zero, get the reading a_2 , the height of the workpiece $h=a_2-a_1$.
- The scriber is made of carbide and can be used for scribing. When scribing, use the fine adjustment frame to accurately align the required size with the height of the scribe line. then tighten the locking screw and scribe. When scribing, the base should fit the inspection plate well and can move smoothly. The contact pressure between the scriber and the surface of the workpiece should be appropriate to ensure that the scribing is clear but without deep marks and damage to the scriber.

3. Reading

- During reading, the sight is perpendicular to the scale to avoid parallax reading. The reading is the sum of beam and vernier. The reading results are as follows:



4. Optional accessory

- Dial test indicator holder, for holding dial test indicator.



5. Notice

- When move the gage, you should hold the base with one hand and hold the beam with the other hand.
- After use, clean and put the gage back to the packing box and store it in a dry place.
- The gage without the box is not allowed to be placed horizontally, nor can it be leaning against other goods. Move the beam to the lowest position after use. The gage should be calibrated regularly.