



FIG. 1 SETTING INTERNAL DIMENSION USING SQUARE GAGE BLOCKS WITH RECTANGULAR JAWS

HELPFUL TIPS:

- USE AN INDICATOR WITH LARGE TRAVEL WHENEVER POSSIBLE.
- SPECIAL CONTACT PIN CAN EASILY BE MADE USING A 5/32" DIAMETER DRILL BLANK.

SETTING INSTRUCTIONS

1. Insert contact pin into proper hole location.
 2. For internal measurement, install the rest button to the right side of the contact pin as shown in Fig. 1 and slide the contact point stopper all the way to the left. For external measurement, install the rest button to the left side of the contact pin and slide the contact point stopper all the way to the right.
- Lock the rest button in position.
3. Rough set gage to desired dimension within .04" (1mm).
 4. Slide the indicator and contact pin to desired depth and lock them in position.
 5. Set gage to desired dimension using gage blocks, ring gage or qualified part. Lock the thumb screw and set dial to zero.
 6. Slide the contact point stopper to the contact point, setting contact point rest position at .002" to .006" (.05mm to .15mm) and record the position. Any change of the recorded position indicates change from the original setting and the gage must be reset immediately. The contact point stopper setting also ensures smooth entry into measuring area.