



CYLINDER BORE GAGE MANUAL

Part Number: 52-646-220

- Range: 35-160mm (Combination of 35-50mm and 50-160mm)
- Graduation: 0.01mm
- Accuracy

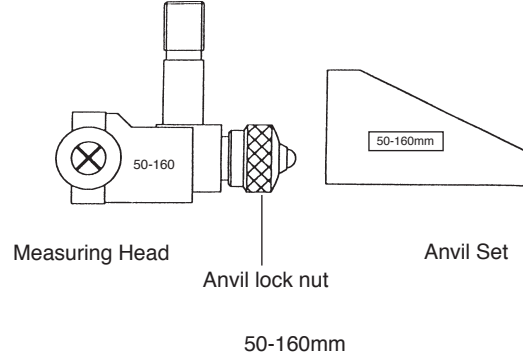
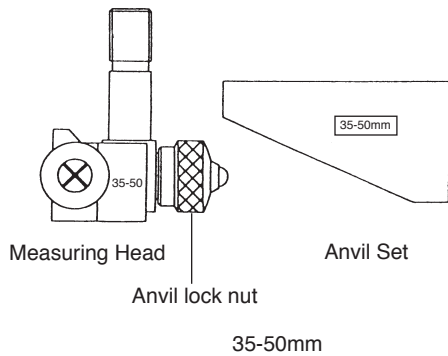
Total error	Repeatability	Self-centering error
0.02mm	0.01mm	0.005mm

• Accessory specifications

Range	Anvil Quantity	Anvil Range												Sub-anvil		Washer Quantity	Washer size			
		No.1	No.2	No.3	No.4	No.5	No.6	No.7	No.8	No.9	No.10	No.11	No.12	Quantity	Size		No.1	No.2	No.3	No.4
35-50mm	4	35	40	45	50											3	0.5	1.0	2.0	3.0
50-160mm	12	50	55	60	65	70	75	80	85	90	95	100	105	1	55					

*No.1 anvil is already installed in the measuring head.

• Method of use



1. Selecting range using

- When range equals 35-50mm, use the 35-50mm measuring head & anvil set; and when range equals 50-160mm, use the 50-160mm measuring head & anvil set. (See the above figure)

2. Attaching the indicator

- Insert the indicator spindle into the stem.
- The hand of the indicator should travel about 1 revolution (1.0mm).
- Lock the indicator with the clamp screw.

3. Selecting the accessory or combination of accessories

- Remove the anvil locking nut and the anvil or washers not used.
- Install the correct accessory or combination of accessories.
- Install the knurled locking nut tightly.

4. Dimension setting

- Set an outside micrometer to the exact dimension to be measured. Ring gages of gage blocks may also be used.
- Place the cylinder bore gage's measuring contacts between the micrometer faces and adjust the measuring contacts to position the long hand of the dial indicator at the Max. travel, tighten the locking nut. Turn the indicator's bezel to make the hand point exactly to zero.

5. Measuring and reading methods

- Place the gage in the cylinder and gently rock it to get the lowest dial reading. In order to get the exact measurements, one must generally measure several positions.