

INSTRUCTION MANUAL FOR SELF CENTERING THREE POINT BORE GAUGE (706-008)

➤ Features

- ✓ Three-Point pistol type bore gauge with head for quick, easy, and accurate measurements of internal measures such as (blind) bores
- ✓ Easy single-handed operation use
- ✓ High degree of accuracy can be achieved without the need for special skills
- ✓ Three-Point pistol type bore gauge design with an ergonomic pistol grip handle with an advanced trigger action, giving the user the advantages of both speed of operation and a constant measuring pressure
- ✓ Required only four handles to accommodate the entire range of 6 - 300 mm
- ✓ Repeatability of gauge 0.002 mm
- ✓ Extensions available for increased gauging depths.(Optional)
- ✓ Ergonomically designed handle offer single handed operation
- ✓ Ideal suited to simple or integrated measurement
- ✓ Available as single instruments and set, with setting ring(s) and extension

➤ Example:

FM/09/000 range 40-50 mm
Pistol grip (1)
Anvil (head) 40-50 (1)
Ring gauge 40 mm (1)
Extension bar 150 mm (1)
Aluminum box

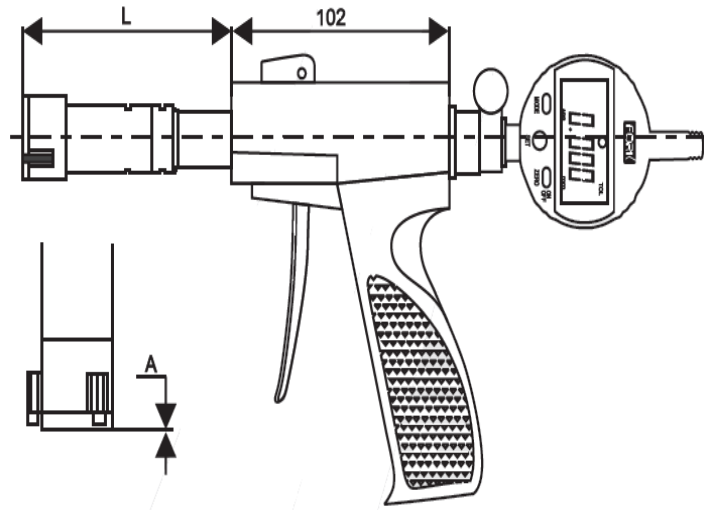
FM/48/000 range 20-50 mm
Pistol grip (1)
Anvil (head) 20-25, 25-30, 30-40, 40-50 (4)
Ring gauge 25, 40mm (2)
Extension bar 150 mm (1)
Aluminum box



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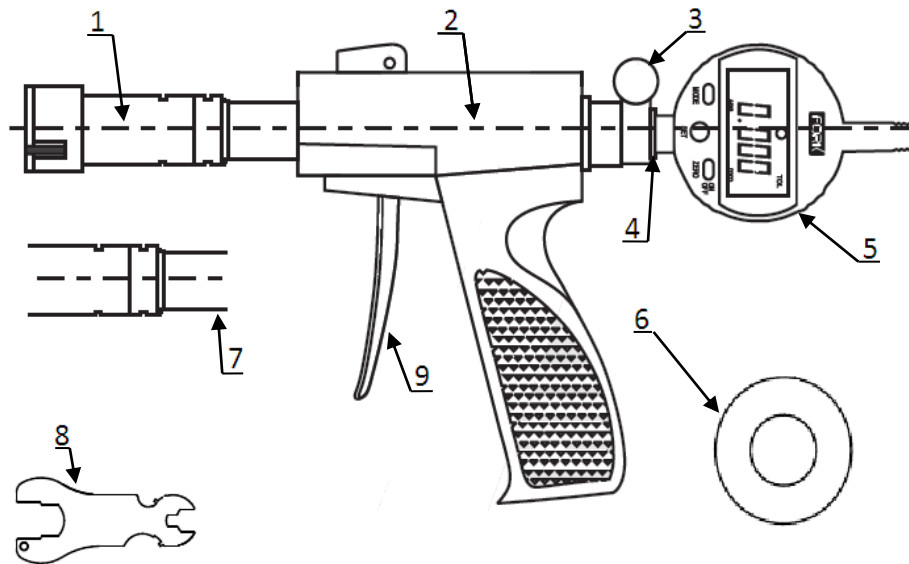
➤ Specification

Code	Range	Accuracy	L	A
706-008	6-8 mm	0.004 mm	50 mm	1.5 mm
706-010	8-10 mm	0.004 mm	50 mm	1.5 mm
706-012	10-12 mm	0.004 mm	50 mm	1.5 mm
706-016	12-16 mm	0.004 mm	65 mm	0.5 mm
706-020	16-20 mm	0.004 mm	65 mm	0.5 mm
706-025	20-25 mm	0.004 mm	91 mm	0.5 mm
706-030	25-30 mm	0.004 mm	91 mm	0.5 mm
706-040	30-40 mm	0.004 mm	97 mm	0.5 mm
706-050	40-50 mm	0.005 mm	97 mm	0.5 mm
706-063	50-63 mm	0.005 mm	112 mm	0.5 mm
706-075	63-75 mm	0.005 mm	112 mm	0.5 mm
706-088	75-88 mm	0.005 mm	112 mm	0.5 mm
706-100	88-100 mm	0.005 mm	112 mm	0.5 mm
706-125	100-125 mm	0.005 mm	130 mm	0.5 mm
706-150	125-150 mm	0.005 mm	130 mm	0.5 mm
706-175	150-175 mm	0.005 mm	130 mm	0.5 mm
706-200	175-200 mm	0.005 mm	130 mm	0.5 mm
706-225	200-225 mm	0.007 mm	130 mm	0.5 mm
706-250	225-250 mm	0.007 mm	130 mm	0.5 mm
706-275	250-275 mm	0.007 mm	130 mm	0.5 mm



Code	Range	Head of No.	Length Extensions
709-012-S	6-12 mm (A=1.5 mm)	6-8,8-10,10-12mm	100 mm
709-020-S	12-20 mm (A=0.5 mm)	12-16,16-20mm	150 mm
709-050-S	20-50 mm (A=0.5 mm)	20-25,25-30,30-40,40-50mm	150 mm
709-100-S	50-100 mm (A=0.5 mm)	50-63,62-75,75-88,87-100mm	150 mm

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|---|----------------|---|------------------------|---|--------------------|
| 1 | Measuring Head | 2 | Pistol Body | 3 | Locking Nut |
| 4 | Bushing | 5 | Digital Dial Indicator | 6 | Setting Ring Gauge |
| 7 | Extension Rod | 8 | Spanner | 9 | Grip |

➤ Use

- ✓ Measurement can be taken closer to the bottom of the blind hole, and can be taken into a deep hole with an extension. Convenient for right and left hand use

➤ Installation

- ✓ Insert the digital dial indicator into the hole of the locking nut.
- ✓ Make sure the trigger is in the release position when installing the dial indicator. After the needle of the dial indicator moves slightly, rotate locking nut to lock the indicator.
 (If the clamped part of the digital dial indicator is ϕ 8mm, insert the bush into the hole of the locking nut, then insert the dial indicator; if the clamped part is 3/8" (ϕ 9.525mm) , insert the dial indicator into the hole directly.)



FORK MEASURING COMPANY
Vavdi Sr.No. 17, Plot No 55B, Rani Industrial Estate
Gondal Road, Rajkot-360002

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➤ Zero setting

- ✓ Setting zero before measuring.
- ✓ Clean the measuring jaws and hole of the setting ring with soft cloth. Pull the trigger and screw the measuring head into the hole, loosen the grip to make the jaws contact with bore of the setting ring. Set zero and check with the ring gauge again. When the display of the indicator is the same, adjust origin data to make reading coincide with number of the setting ring.

➤ Extension rod installation

- ✓ Install extension rod when measuring a deep hole.
- ✓ Uninstall the measuring head with a spanner. Again, when unscrewing the head ensures that the trigger has been pulled fully home to relieve the pressure of the head. Fix the extension rod between the measuring head and the pistol, fastening them, and reset zero according to as per zero setting.
 - **Note:** When install and uninstall the pistol, a spanner must be used to protect it from damaging.

➤ Precaution

- ✓ Do not apply excessive force when measuring.
- ✓ Do not disassemble the instrument.
- ✓ Keep the instrument clean and dry.
- ✓ Returns into the packaging box after apply anti rust oil if not used for a long time.