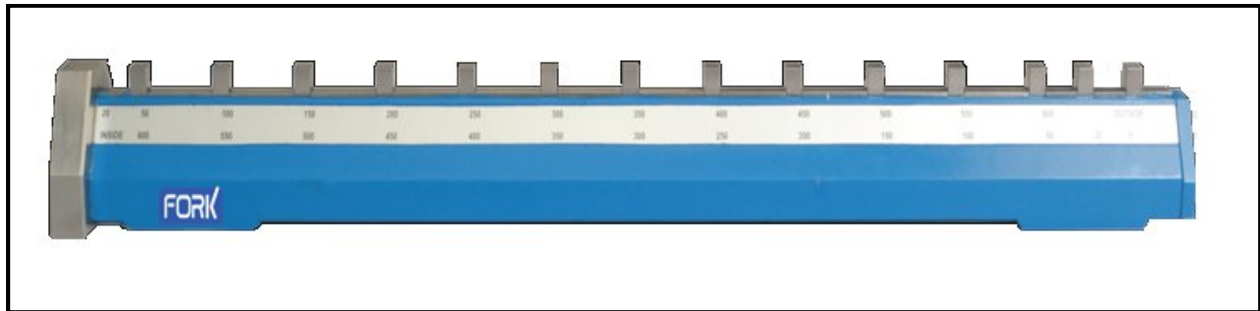


INSTRUCTION MANUAL FOR CALIPER CHECKER (101-300)

INTRODUCTION

Caliper checker is a precision-measuring instrument used for calibration of vernier calipers, Dial caliper & height gauges. Dimensionally stabilized hardened ground, lapped gauge blocks are stacked in the rigid housing selected measuring steps provides calibration of main Scale as well as vernier scales of the instrument.

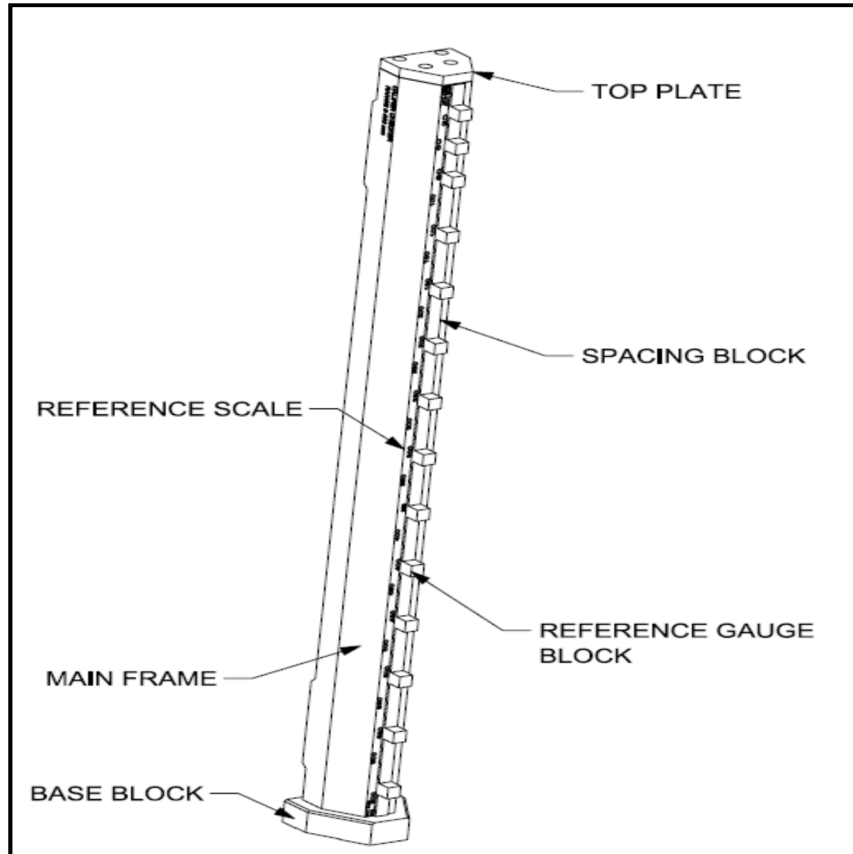


TECHNICAL SPECIFICATIONS

Code	Range	Measuring Step	Overall Accuracy
101-300	300	20,50,100,150,200,250,300	± 0.005 mm
101-600	600	20,50,100,150,200,250,300, 350,400,450,500,550,600	± 0.005 mm
101-1000	1000	20,50,100,150,200,250,300 350,400,450,500,550,600,650, 700,750,800,850,900,950,1000	± 0.005 mm

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COMPONENTS OF CALIPER CHECKER



APPLICATIONS

I. Height measurement

Caliper checker is a precision for used for calibration of height gauges as shown in fig. 01 keep the Caliper checker in vertical position on clean dust free surface plate. Muunt lever type dial Indicator on height gauge instead of saribe , to get constant measuring force nake zero on Making zero on dial indicator at various measuring steps read the height gauge scale Which will show you the displacement or scale error of height gauge.

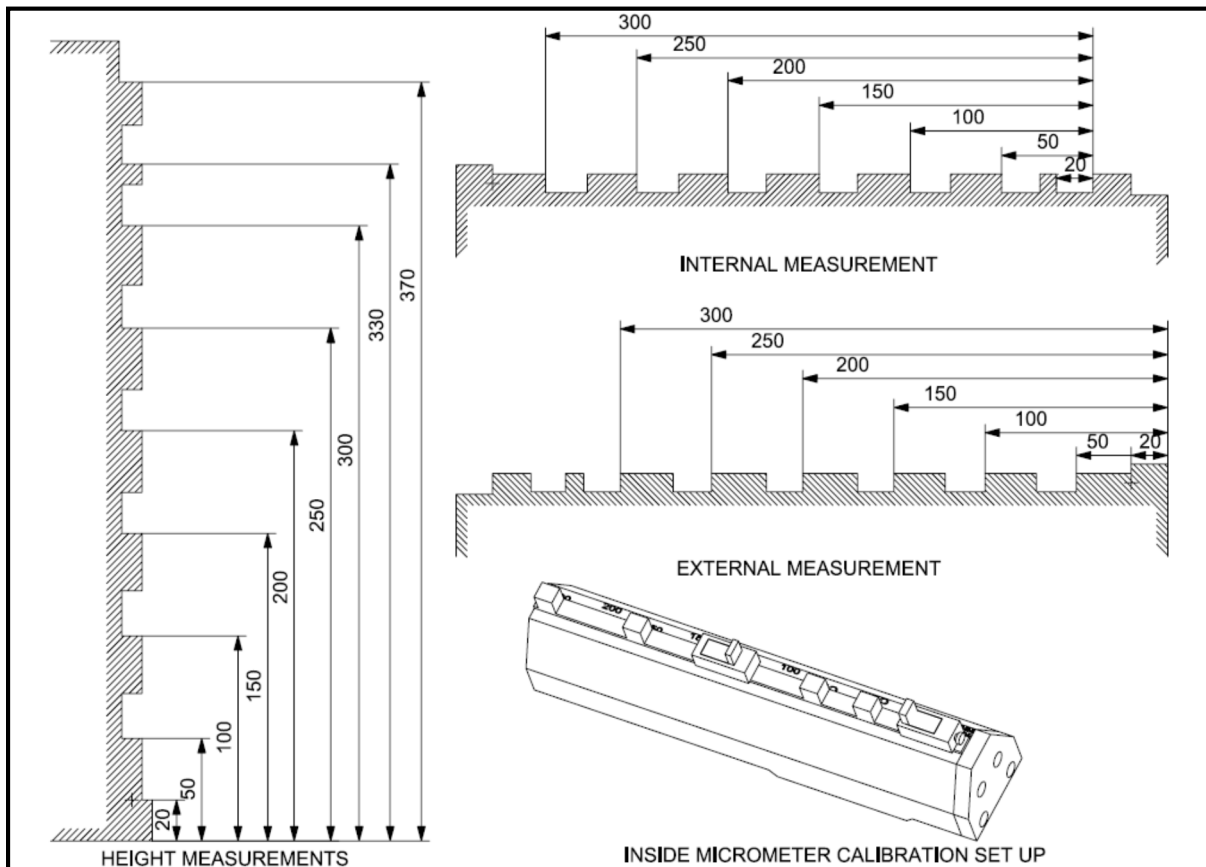
INSTRUCTION MANUAL FOR CALIPER CHECKER (101-300)

II. Outside measurement

Calibration of vernier or Dial Caliper with external jaws is possible by this type of Measurement, for outside Measurement, keep the caliper checker in horizontal position on Pads provided at back side make '0' on vernier or dial caliper now as shown in fig 02 take The first reading by using external jaws of the caliper keep the left jaw of caliper fix at one End & take the second reading on next measuring step as shown in fig.02 & proceed in the Same manner.

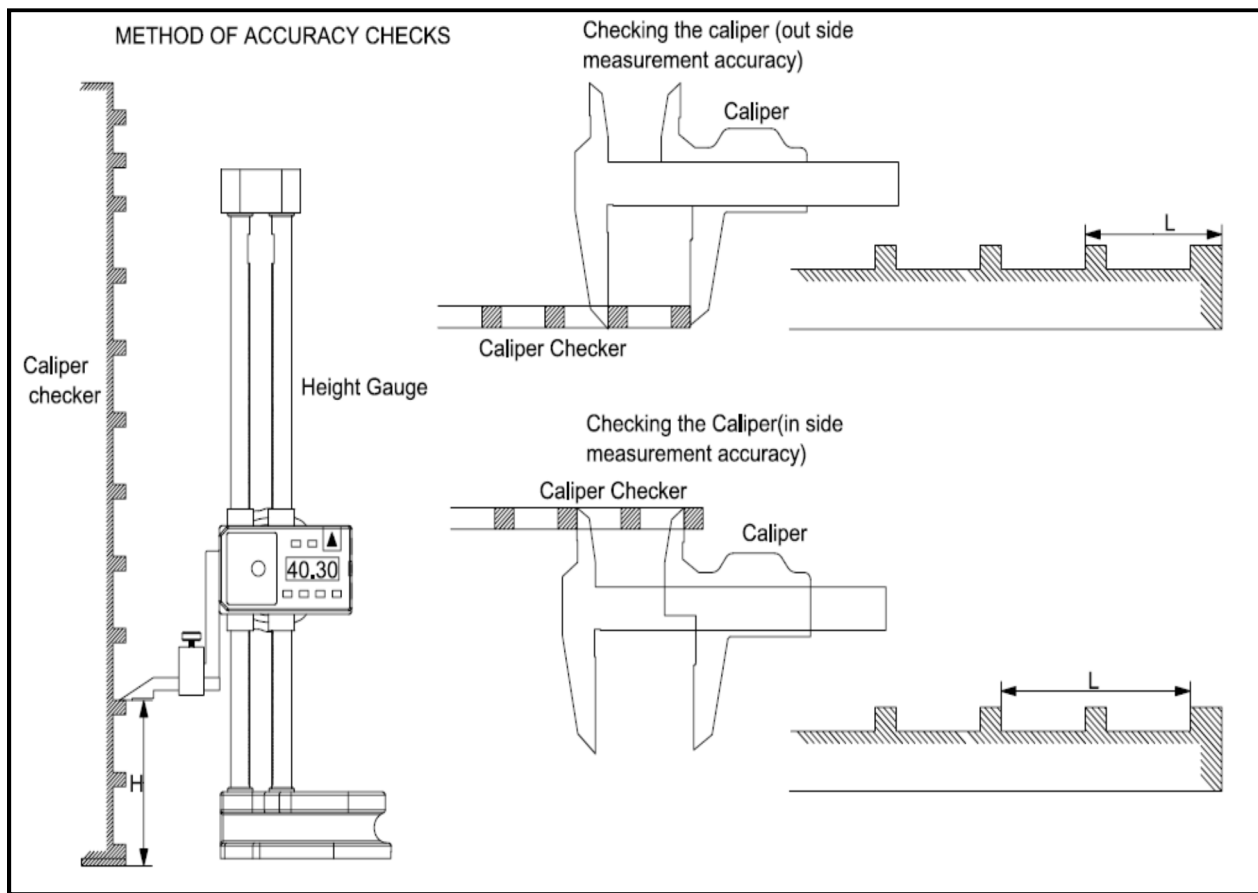
III. Inside measurement

For checking accuracy of calipers by using internal jaws this type of Measurement is Possible. For this, keep the caliper checker in horizontal position in the same manner as for Outside measurement make '0' on caliper checker.



INSTRUCTION MANUAL FOR CALIPER CHECKER (101-300)

METHOD OF ACCURACY CHECKS



OPERATION

The instrument is designed to check the accuracy of Calipers & Height gauges. In each type of use, please note the points as shown in the figure.



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INSTRUCTION MANUAL FOR CALIPER CHECKER (101-300)

PRECAUTIONS WHILE USING

- a. Handle with care so that it is not subjected to impact when you carry or place it on the surface plate
- b. Before starting operation, wipe off dust from the measuring surfaces of the gauge blocks with a clean cotton cloth or tissue paper. After use, lightly apply high quality anti-corrosive oil to the spacing blocks.
- c. Before you use the Caliper Checker on a surface plate, wipe the surface plane clean.
- d. As the gauge blocks & spacing blocks have been precisely assembled & adjusted at the Factory, never disassemble the Caliper Checker for readjustment.

PRECAUTIONS / MAINTENANCE

- 1) Caliper checker is a precision measuring instrument, handle it very carefully
- 2) Clean the measuring faces by soft banyan cloth with petroleum ether or by chamois Leather before using.
- 3) Gauge Blocks of caliper checker are manufacturing from high quality alloy steel. Protect them against atmospheric corrosion do not clean the measuring faces by Open hands use soft gloves while cleaning
- 4) After every use clean the measuring faces by above said method (2&3). Apply rust Preventive oil liquid paraffin or white petroleum jelly on measuring faces by brush only
- 5) Before applying rust preventive oiler jelly on measuring faces by brush ensure that Measuring face is totally cleaned & no thumb or finger impressions are present on The measuring faces. If this precaution is not taken moisture by finger impression Will be protected & develop as rust even after applying rust preventive oil.
- 6) In case, if rusty spots occurred on gauging surfaces, remove them by using abrasive Polish paper of '0' grit which will not affect the accuracies of the instrument
- 7) If rusty spots occurred on non – gauging surfaces, remove them by Using abrasive polish paper of '0' grit.
- 8) Protect the instrument from dust & dirt by using Rexene cover provided with the instrument.