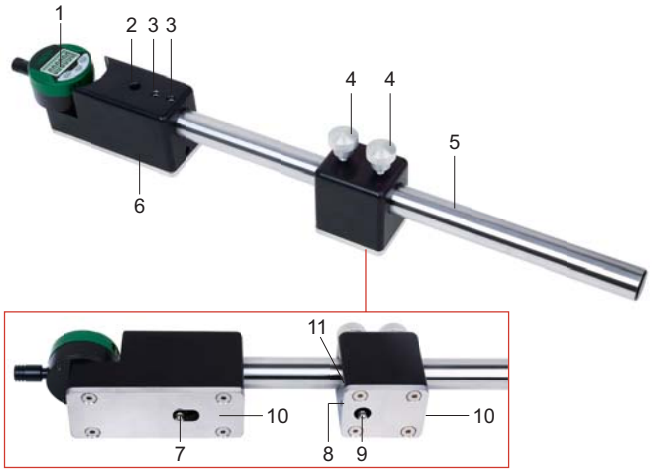
OPERATION INSTRUCTION

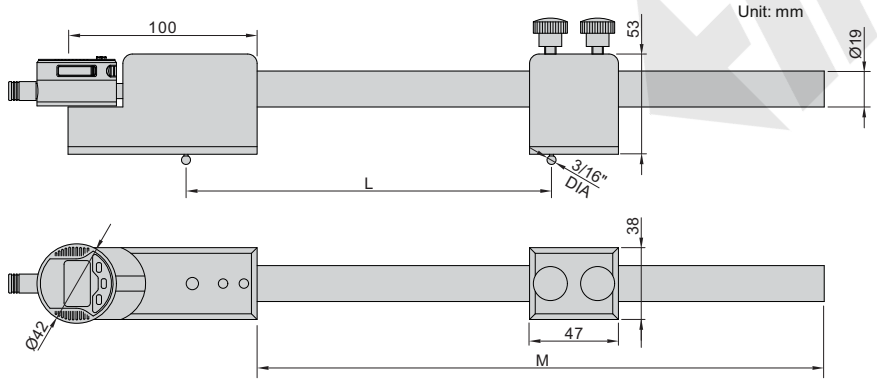
DGroove Diameter Measuring Instruments

Code	Range(L)	Movable point stroke	Resolution	Repeatability	M
2261-5	2.6"-13"/66-330mm	0.2"/5mm	0.001mm/.00005"	0.002mm	12"/300mm



1-Digital indicator
2-Height adjustment screw for movable point
3-The locking screw of main rod
4-Main rod locking screw of point base
5-Main pole
6-Height locking screw for movable point
7-Active point
8-Height locking screw for fixing point
9-Fix point
10-Measure contact surface
11-Height adjustment screw to fix the point
(Inside the point holder, the point holder needs to be removed from the main rod to adjust)

Product size chart



1.Measure the groove diameter of flange ring groove.

2.Point height is adjustable, point diameter can be custommade, optional main rods of different lengths.

3. Calibration before comparison measurement:

---Before measurement, select the corresponding groove standard block (code 6254, optional) or standard workpiece according to the workpiece to be measured

---According to the size of the workpiece to be measured, adjust the position and height of the movable and fixed points of the annular groove diameter measuring instrument

---After the adjustment is completed, contact the movement of the measuring instrument with the fixed point and the annular groove of the workpiece to be measured; at the same time, the measuring contact surface of the measuring instrument is in close contact with the upper end surface of the workpiece (Fig 1).

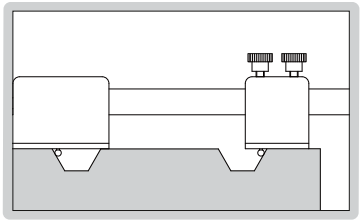
Note: After the movable and fixed point are in contact with the workpiece, the small dial of the gauge should be in the middle position. For example, when it is close to the extreme positions at both ends, it is easy to exceed the measuring range of the gauge when calibrating and measuring.

---Keep the fixed point still, slowly swing the movable point of the measuring instrument left and right to find the smallest point

---Set the digital indicator to zero

---Calibration complete

fig 1



3. Comparative measurement:

---Use the calibrated measuring instrument to measure the workpiece to be measured according to the operation steps during calibration

---After the measurement is completed, check the value of the indicator, and the value represents the deviation between the measured workpiece and the standard workpiece.

4.Optional: groove standard block (code **6254**), stem(code **2261-M24/2261-M30/2261-M36**).

MN-2261-C/E
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