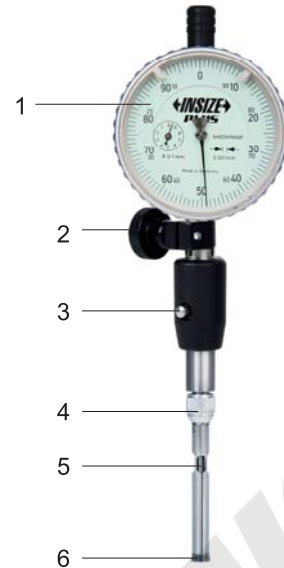


Accuracy: 3 μ m (measuring range: 1.5-10mm)
 4 μ m (measuring range: 10-20.6mm)
 Repeatability: 1 μ m

Code	Range	Quantity of points
2429-4	1.5-4.2	10
2429-7D5	4.15 - 7.8	7
2429-12	7.7-12.5	6
2429-20	12.2- 20.6	8

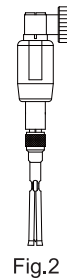
1. Dial indicator(not included)
2. Locking nut
3. Retraction button
4. Locking device
5. Measuring needle
6. Contact point



1. This product is used to measure the inner diameter size.

2. Install the contact point and measuring needle:

- Choose the contact point and measuring needle according to measuring range
- Insert the measuring needle into the contact point, then insert into body (Fig.1), tighten the locking device and complete the installation (Fig.2)



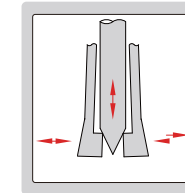
3. Calibration:

- Choose suitable setting ring according to measuring range
- Press the retraction button so that the distance between the two contact points is smaller than the setting ring value. Place the contact point into the setting ring, release the retraction button, make the contact point completely contact with the setting ring, and gently shake it to find the "turning point", adjust the dial indicator, and make the "0" line coincide with the "turning point"
- Then shake the gage to check if the "0" line coincide with the "turning point"

4. Measurement:

- Clean the contact point and workpiece before measurement
- Press the retraction button so that the distance between the two contact points is smaller than measured workpiece. Place the contact point into the setting ring, release the retraction button, make the contact point completely contact with measured workpiece, and gently shake it to find the "turning point" and read

principle of measurement



5. Optional accessory: dial indicator or precision dial indicator, dial comparator, setting ring, stand for split dial bore gages.

6. When measuring, the gage should be protected from being beaten or knocked. After use, the product should be oiled to prevent from rust.