

Code	Range of external diameter	Accuracy	Repeatability
6847-50	1.5-50mm/0.06-2"	±0.001mm	0.0005mm



- 1-Digital indicator(optional)
- 2-Indicator/point lock wrench
- 3-Point trimming wrench
- 4-Point fine adjustment lock nut
- 5-Measuring base
- 6-Measuring base locking screw
- 7-Handwheel
- 8-Slotted screwdriver

1. To measure diameter and roundness of cylinders and steel balls.

2. Adjustment and use :

---The measuring stand is measured using the comparative method. Before measurement, a calibrated standard part with measurement values is prepared based on the diameter of the workpiece being measured

---Before measuring, loosen the Indicator/point lock wrench (2) based on the diameter of the measured part, adjust each part to a position that can approximately calibrate the diameter of the standard part, and then tighten each wrench (2)

---Placing the calibration standard on the measuring base (5), so that the probe of the meter contacts the two fixed points and the calibration standard, loosening the point fine adjustment lock nut (4) and then adjusting the point trimming wrench (3), so that the points carried everywhere are at the maximum diameter of the calibration standard.

---After the adjustment, tighten the point fine adjustment locking nut (4) to ensure that all parts are stable and reliable.

---Finally, set digital indicator to zero or set digital indicator to the diameter of the calibration standard part to complete the calibration

Note 1: If the tilt angle of the measuring base cannot meet the measurement requirements, the handwheel (7) can be loosened, adjusted to the appropriate angle, and then locked tightly

Note 2: When adjusting the height of the measuring base (5), the measuring base locking screw (6) can be loosened using a slotted screwdriver (8) to adjust the height

---Remove the calibration standard and place the measured workpiece for measurement

---Rotate the measured workpiece for more than one cycle and observe the value of the digital indicator. The maximum and minimum values are the diameter dimensions of the measured workpiece, and the difference is the roundness of the measured workpiece

Note 3: When measuring, it is necessary to rotate the measured workpiece evenly and smoothly, otherwise it will affect the accuracy of the measurement

Note 4: When measuring for a long time or in large quantities, calibration standard parts should be frequently used for recalibration

3. Optional accessory: $\varnothing 28\text{mm}/\varnothing 8\text{mm}$ bush (code **6843-B8**), high precision digital indicators (code **2140-6**, **2140-6WL**)

4. Matters needing attention :

---Pay attention to product protection after measurement. If it is not used for a long time, it should be stored.

---Oil shall be applied for protection during long-term storage to avoid rusting of products.