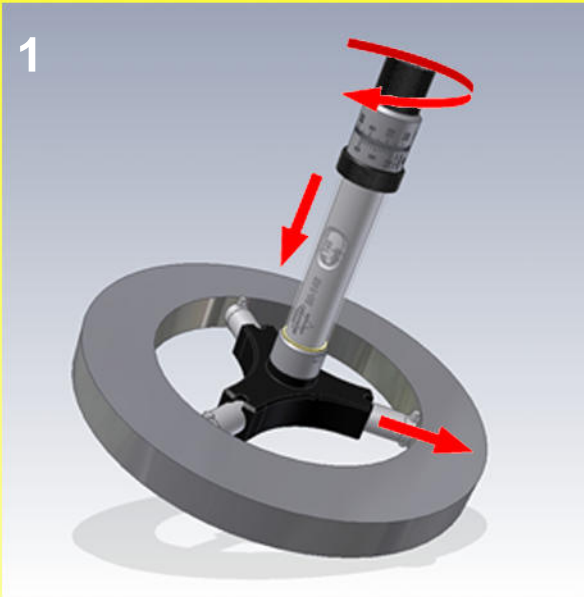


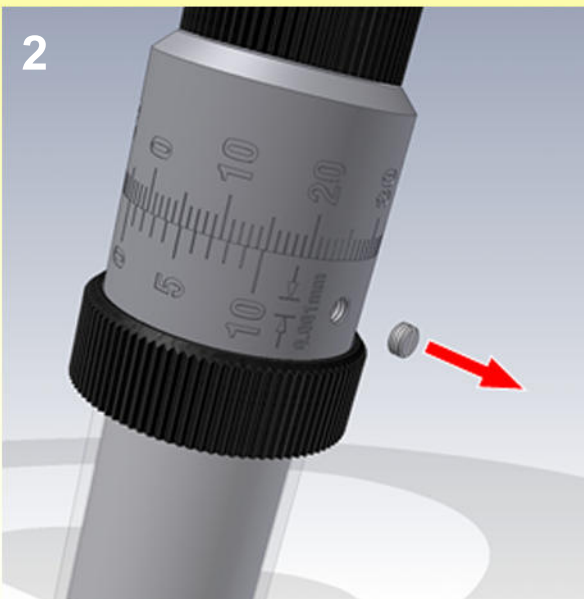
MICROTEST AG

Precision Instruments

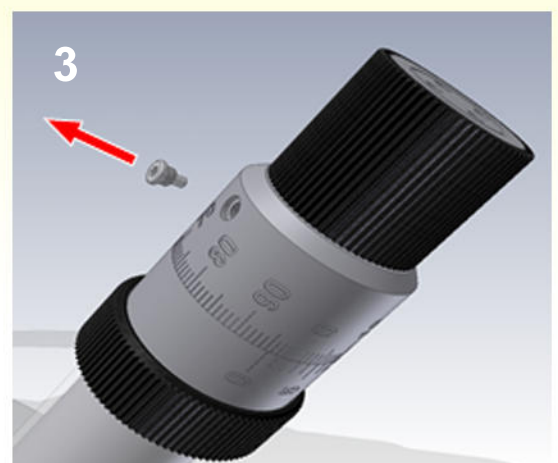
Instructions: Fitting of the extension piece

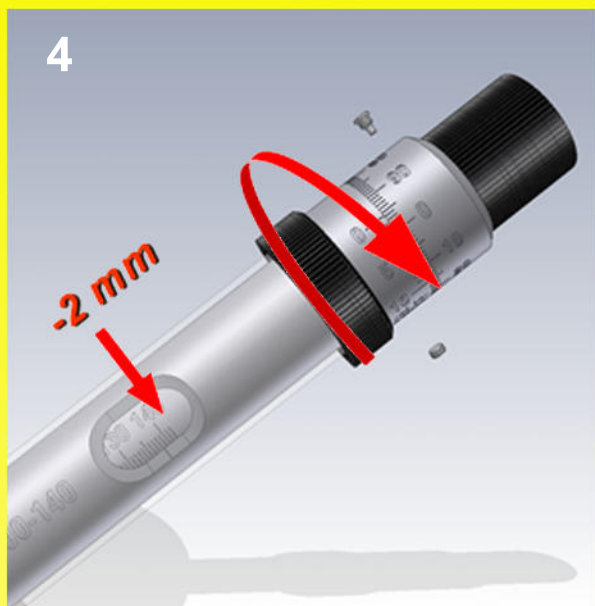


- 1 Insert the MICROTEST internal micrometer into the ring gauge or in triangle test gauge. screw out feelers until they are in contact with the side of the hole. Now turn ratchet half a revolution 5–6 times to obtain exact centring.

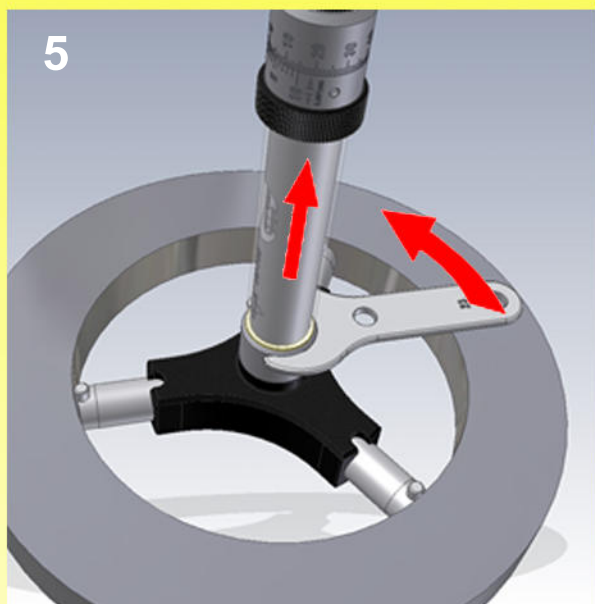


- 2 Loosen the slotted screw at Nonius,
- 3 unscrew and take out Allen screw at scale drum opposite of scale 75 with annexed special Allen key 1.27.

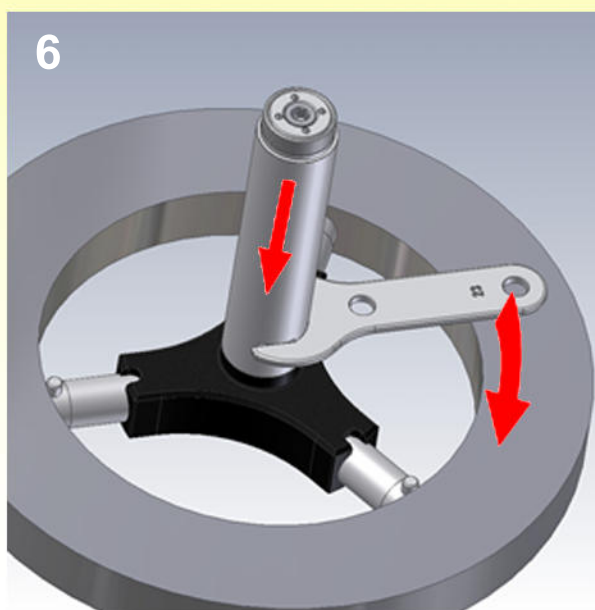




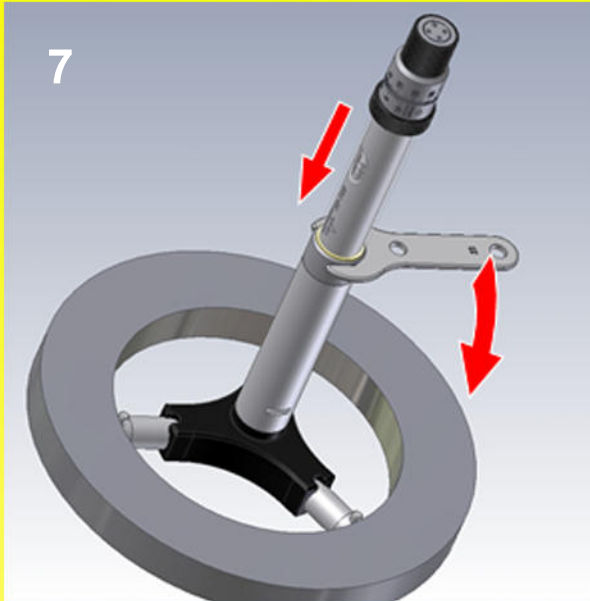
4 When Nonius screw is loosen and Allen screw is completely removed, screw knurled black ring underneath the Nonius counter-clock-wise exactly 2 mm, according to the mm-scale, upward.



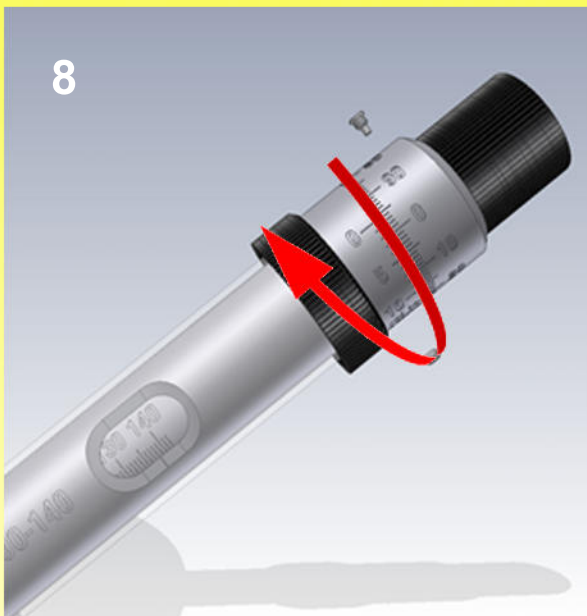
5 With the annexed special flat wrench loosen scaled shaft tube from housing and unscrew it counter-clock-wise by hand.



6 Screw the extension tube clock-wise onto the housing and fix well but moderately with special flat wrench.

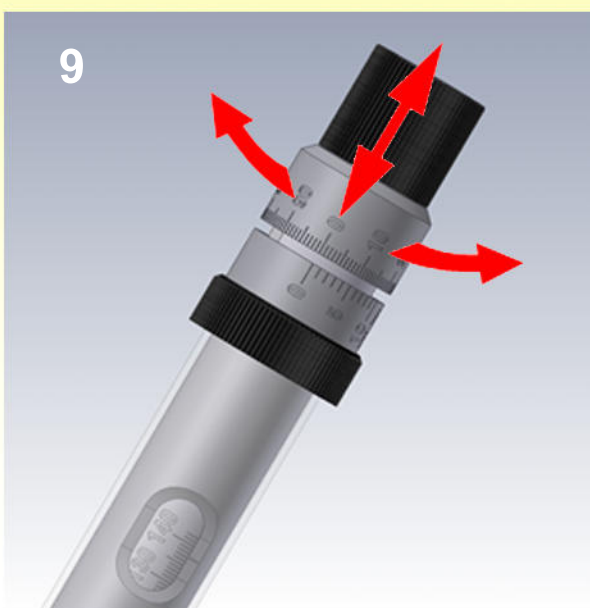


7 Afterward screw shaft tube with scale on extension and tighten well but moderately with special flat wrench.



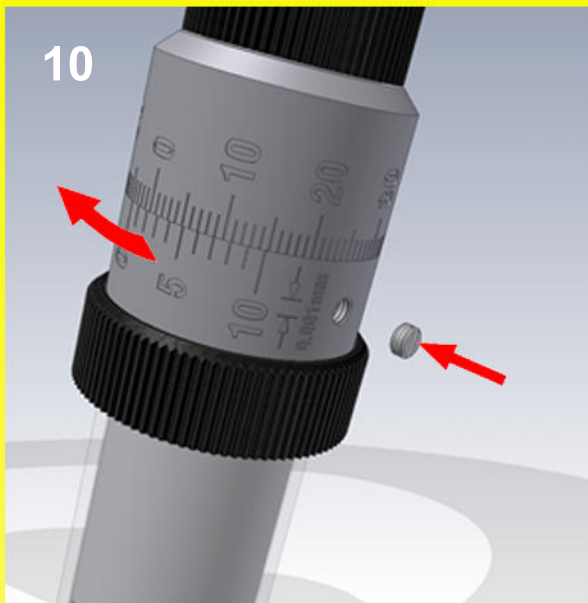
8 Turn backward black knurled ring clock-wise until it stop.

Do not tighten back the Nonius screw or the Allen screw at scale drum yet!



9 By lifting up flexible scale drum you can adjust all scales to proper position.

After adjustment let scale drum slip back slightly in order to snap in the axis.



10 Set and adjust Nonius, considering ring gauge measurement \pm linearity error according control certificate, finally fix Nonius slotted screw slightly. Check again measurement in setting device. If necessary adjust again until your measurement is perfect.



11 Finally screw the Allen screw into scale drum with annexed special Allen key 1.27.

- As internal measurement is detected directly in the measuring head, measuring accuracy remains perfect even after long or combined extensions.



12 Using long extensions it is recommended to use our new MICROTEST- tripod centring device after 2/3 of length, similar to Bessel's rule.

**Available tripod sizes:
Ø60-140, Ø140-240 and
Ø240-400.**