Calibration of micrometers DIN 863

Hartig

We thank you for buying this quality product. This micrometer has been checked exactly and calibrated at 20°C. The used checking gauges confirm with national standards (DKD/PTB).

After longer use and/or according to the intervals defined through your quality management system the micrometer can be calibrated again as follows:

Regulation of the indication - calibration

1. Clean micrometer and measuring faces careful with a non fibrous patch, check flat measuring faces with plane face glass for planeness and cuts.

2. If available, unscrew the grub screw of the inner sleeve with a screwdriver.

3. Temper micrometer minimum 2 hours together with checking gauges at 20°C.

4. Screw measuring spindle by **slow** twisting at the friction clutch/ratchet against the anvil or against the checking gauge.
   Internal micrometers: Screw the measuring faces by cautious twisting at the thimble and/or at the friction clutch / ratchet (if available) against setting ring gauge or corresponding checking facility. In the case of 2-point internal micrometers find out the deepest point in axial direction, in peripheral direction the highest point.

5. Activate (if available) spindle locking device (locking ring). Twist the inner sleeve by mean of the supplied hook spanner as far as the longitudinal line from the inner sleeve agrees with the zero line of the external thimble (to pay attention to possible offsizes of the setting gauges).

6. If available, tighten up again the grub screw of the inner sleeve.

7. Check again zero adjustment as above, repeat regulation again if necessary.

8. Should through repeated reset the longitudinal line of the inner sleeve come into an unfavourable reading position, you may loosen the thimble after unscrewing the rear screw of the friction clutch / ratchet through a slight knock with a bright plastic hammer and screwing on after that in the new position again.

   With greater wear, in particular of the measuring faces, we beg you, to submit those micrometers to us to the inspection and repair.

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