

THREAD MEASUREMENT INSTRUCTIONS

Holder Assembly



Caliper and insert holder.



Place caliper jaws in the holder slots.



Fasten the 4 grub screws carefully.



Remove the alignment cylinder.

Find thread pitch diameter tolerance and the relevant thread inserts.

External Thread Measurement

Mounting and using thread inserts types 21 and 26.



Push the relevant thread inserts as shown into the mounted insert holders.



Zero the caliper. The measurement result will be the pitch diameter.



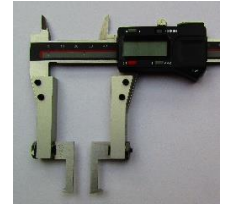
Holder assembly is not necessary With the special FMS caliper MT203

Internal Thread Measurement

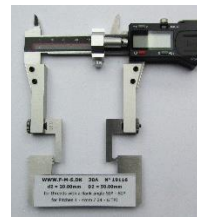
FMS internal thread inserts types 22 and 27 can measure the pitch diameter of threads from 6mm/1/4". Types 23 and 28 from approximately 36mm/1 1/2". A calibration plate is necessary for internal thread measurement.



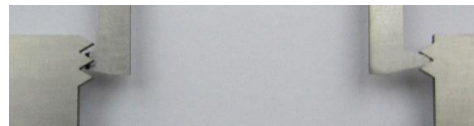
Thread inserts types 22 and 27 can overlap and measure pitch diameter on small diameter threads.



Thread inserts types 23 and 28 measure pitch diameter on threads with a diameter from 36mm / 1.5".



A calibration plate is necessary as a reference when measuring internal pitch diameter. Zero the caliper (using a pressure device) and add 50.00mm / 1.9685" to the final measurement result. Calibration plate type 30A shown



A40 40A



Using a caliper pressure device (A40 or 40A) for external or internal measurement will give a consistent, constant measurement pressure.



Digital caliper with insert holders and a pressure device (A40) mounted for external measurement.



Digital caliper with insert holders and a pressure device (A40) mounted for internal measurement.



External



Internal