



# ULTRATEST<sup>TM</sup>

PRECISION MICROMETERS

## MICROMETER INSTRUCTIONS

All ultratest micrometers are factory calibrated for accuracy. However micrometer accuracy can be affected by temperature changes, shock during transportation and eventual wear.

### ZERO ADJUSTMENT

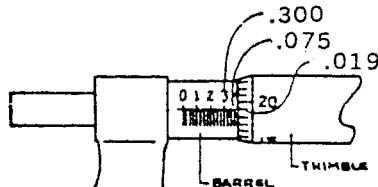
Clean and close measuring faces and lock spindle with locking lever. Using wrench provided, insert wrench into hole in micrometer sleeve and rotate until both zero lines on barrel and sleeve line up. Unlock spindle and recheck zero setting.

### HOW TO READ A MICROMETER WITH THOUSANDTH (.001") GRADUATIONS

Each number graduation on barrel equals .100" (one hundred thousandths). Each line graduation on barrel, between the number graduations, equals .025" (twenty-five thousandths).

Each line graduation on thimble equals .001" (one thousandth).

To read a micrometer take the highest number graduation visible on barrel, and add to this the number of line graduations visible. Add to this sum, the number of the line graduation of the thimble, that lines up with the long horizontal line of the barrel.

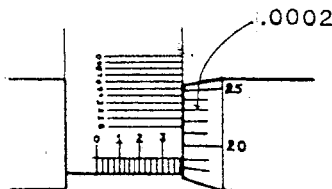


### Illustrated example

.300	Number graduation on barrel (3)....	.300"
.075	Line graduation on barrel (3rd).....	.075"
.019	Line graduation on thimble (19th)....	.019"
	<hr/>	
		.394"

### HOW TO READ TEN THOUSANDTHS (.0001") GRADUATIONS

A tenth micrometer has 10 additional number graduations on TOP of barrel. Each number equals .0001" (one ten-thousandth). Whichever number graduation on top of barrel coincides with any line graduation of thimble, this number is added to the thousandth total found previously.



### Illustrated example

First three steps as above .....	.394"
Number graduation on TOP of barrel coinciding with thimble graduation (2nd)....	.0002"
	<hr/>
	.3942"

### HOW TO READ A MICROMETER WITH METRIC GRADUATIONS

Line graduations on barrel equal 0.5 MM (7 lines equal 3.5 MM)....	3.50 MM
Line graduations on thimble equal 0.01 MM (23 lines equal 0.23 MM) .....	0.23 MM
Metric reading is the total of these 2 figures .....	3.73 MM

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