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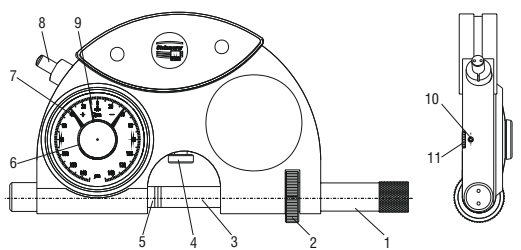
GB **Passameter**
76 3901

Operating Instruction

GB



1 Clamping nut
2 Adjusting nut
3 Adjusting bolt
4 Supporting bolt
5 Measuring spindle
6 Tolerance mark adjuster
7 Tolerance mark
8 Lifter
9 Pointer
10 Dial fastener
11 Dial adjuster

Application range

Passameters are adjustable snap gages that are mainly used for the measurement and inspection of cylindrically ground and turned components. They replace a large number of fixgages and offer the numerical display of the deviation from the preset value as an additional advantage.

Handling during measurement

Proper handling is the most important pre-requisite to prevent measuring errors. Clean the measuring surface and the test piece carefully before each measurement. Gage blocks, gages, or a selected test piece is used to set the instrument to the nominal size. For this purpose, turn the adjusting nut (2) to move the adjusting bolt (3) in axial direction, until the pointer (9) approximates zero. Tighten the clamping nut (1) to prevent an unintentional displacement. The exact zero adjustment is made by turning the knurled knob (11) on the rear panel. The dial adjustment can be fixed by means of the setscrew (10). To insert and remove the test piece, press the lifter button (8) to pull back the measuring spindle (5). The use of the lifter (8) ensures a constant measuring force. Avoid any impulsive stress and acts of violence.

Adjusting the tolerance markers

The tolerance marker adjusting ring (6) located on the glass can adjust the tolerances;
left-hand turn - upper tolerance,
right-hand turn - lower tolerance.

General hints

All Passameters are provided with an adjustable supporting bolt (4) that facilitates handling significantly.

Maintenance

After each usage, the Passameters have to be cleaned and the bare surfaces to be lubricated.

Technical data

Precision indicator 1 µm

Scale division	1 µm
Range of indication	± 70 µm
Measuring force	approx. 8.5 N
Retraction	approx. 2.5 mm
Dial adjustment	± 8 µm

Precision indicator 2 µm

Scale division	2 µm
Range of indication	± 150 µm
Measuring force	approx. 8.5 N
Retraction	approx. 2.5 mm
Dial adjustment	± 15 µm

Adjusting bolt

Adjustment	25 mm