

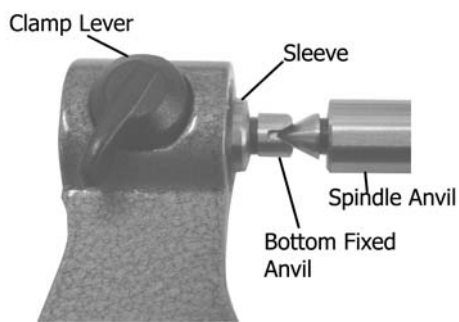
# MeasumaX

## Thread Micrometers

**Measumax** screw thread micrometers are used to measure the pitch of a thread. The screw thread micrometer can have either 55deg, or 60deg anvils with a pointed anvil mounted in the spindle, and a V-shaped anvil mounted in the sleeve to become the bottom anvil.

**Measumax** screw thread micrometer is supplied with a series of anvils designed to cover most of the threads in that diameter range.

When the micrometer is set to zero, the pitch line of the spindle and bottom anvil coincide. When the micrometer is measuring the thread, it is measuring the pitch diameter of the thread.



### Re-Setting the Micrometer

1. Select the anvils required to cover the thread pitch. The sizes are printed on the side of the anvils. (Fig.1) There will need to be a pointed anvil (Spindle anvil) and a V-shaped anvil (Bottom anvil). Make sure that both the anvils cover the thread pitch range that is to be measured.



Fig.1

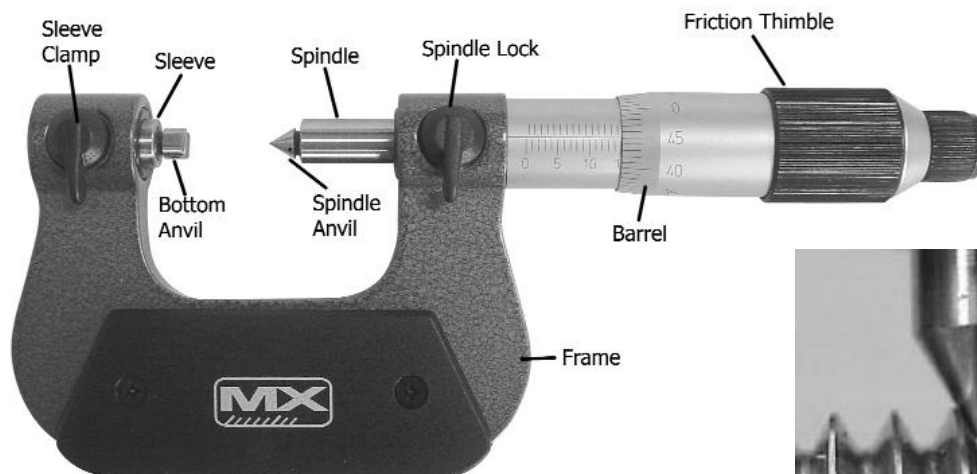
The anvils are pushed in and held in place by the spring ring on the end of the anvils.

2. Loosen the sleeve lock and push the sleeve away from the spindle.

3. Set the spindle and barrel to read zero (0-1" and 0-25mm). For larger thread mics the lowest denominator should be used. (e.g. 25mm on a 25-50mm)

4. With both the anvils in place push the sleeve up gently to meet the spindle so that the anvils fit into each other, and secure the sleeve lock.

5. Withdraw the spindle slightly and bring the anvils back in contact with each other using the friction thimble. Repeat the process until the micrometer is set.

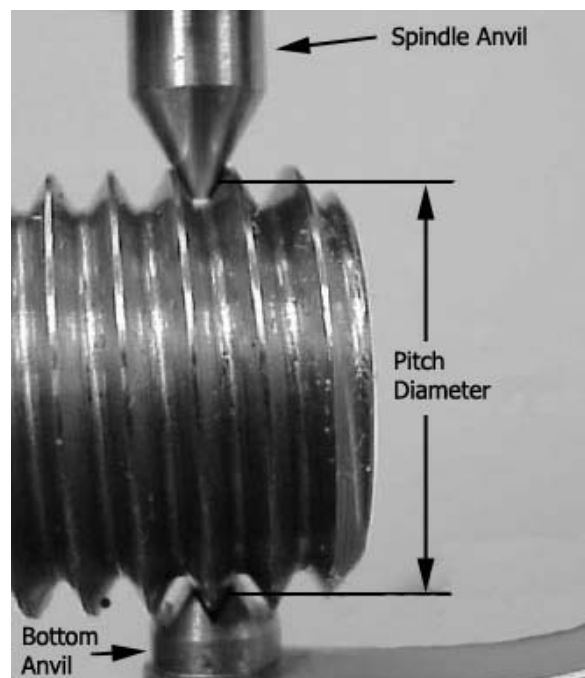


### Maintenance

Before storing your MeasumaX micrometer, back the spindle away from the anvil, wipe all exterior surfaces with a clean, soft cloth, and coat the surfaces with a light oil.

Should the spindle become loose adjustment can be made by tightening the nut at the end of the barrel until the action is smooth and easy. (Fig 3)

**"Measumax"** micrometers are set and tested during production.



# Measumax<sup>MDX</sup>

## Thread Micrometers

### Anvils

With each micrometer a number of anvils are supplied to cover the sizes in that range. Listed below are the models and the anvils supplied with them.

| Model   | Size     | Anvils        |
|---------|----------|---------------|
| 10-137  | 0-1"     | F0203 - F0206 |
| 10-138  | 0-25mm   | F0101 - F0105 |
| 10-139  | 25-50mm  | F0102 - F0106 |
| 10-1391 | 50-75mm  | F0102 - F0106 |
| 10-1392 | 75-100mm | F0102 - F0106 |

| Code No.            | SIZE       | Code No.          | SIZE      |
|---------------------|------------|-------------------|-----------|
| ANVILS IMPERIAL 55° |            | ANVILS METRIC 60° |           |
| F0201               | 60 - 48TPI | F0101             | 0.4 - 0.5 |
| F0202               | 48 - 40TPI | F0102             | 0.6 - 0.9 |
| F0203               | 40 - 32TPI | F0103             | 1 - 1.75  |
| F0204               | 32 - 24TPI | F0104             | 2 - 3     |
| F0205               | 24 - 18TPI | F0105             | 3.5 - 5   |
| F0206               | 18 - 14TPI | F0106             | 5.5 - 7   |
| F0207               | 14 - 10TPI |                   |           |
| F0208               | 10 - 7TPI  |                   |           |

### Diagram 1

1. Painted Frame
2. Barrel
3. Ratchet Thimble
4. Spindle Lock
5. Spindle
6. Anvils

### Reading a Micrometer

The first figure is taken from the last graduation showing on the sleeve directly to the left of the revolving barrel. Note Each full graduations is 1mm. There is an additional half scale divisions are 0.5 mm. The remaining two figures (hundredths of a millimetre) are taken directly from the thimble opposite the main scale. *The reading is 3.46 mm.* (See Fig.5)

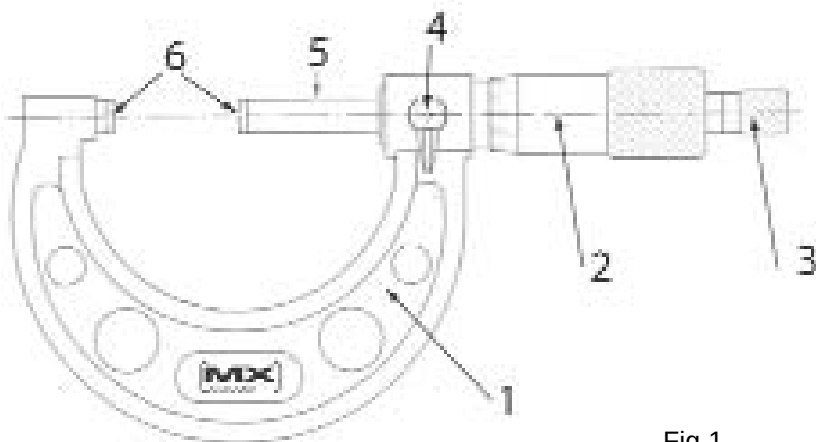


Fig 2



Fig 3



Fig 4



Fig 5