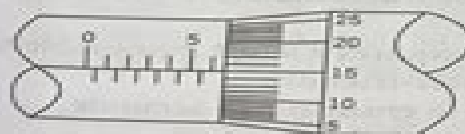


Figure 4.1: Outside micrometer

- The reading on the sleeve, above the line, is full millimetres. This is read first and written down.
- Check whether you can see a half-millimetre line below the centre line, to the right of the last full millimetre line, above. There is a half millimetre line below the centre line between every full millimetre above the centre line. If you can see this, add 0,50 mm to the reading you have already written down.
- The next step is to write down the reading on the thimble, below the last reading. See random example:

Spindle reading, full mm reading above centre line:	18,00 mm
Spindle reading below centre line:	0,50 mm
Thimble reading:	<u>0,45 mm</u>
Total reading:	18,95 mm

Reading an outside micrometer (0 – 25 mm and 25 – 50 mm)



Reading

$$6 + 0 + 0,15 = 6,15 \text{ mm}$$

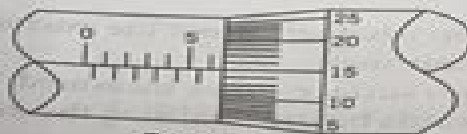


0-25 mm



Reading

$$6 + 0,5 + 0,15 = 6,65 \text{ mm}$$

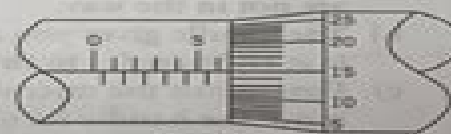


Reading

$$25 + 6 + 0 + 0,15 = 31,15 \text{ mm}$$



25-50 mm



Reading

$$25 + 6 + 0,5 + 0,15 = 31,65 \text{ mm}$$

When using a micrometer that is bigger than a 0 – 25 mm micrometer, if, for example, the micrometer is the 25 – 50 mm one, take the reading and add 25 mm. If the reading is 21,31 mm the result would be $25 + 21,31 = 46,31$.

Fitting And Machining Theory N1

Jessica J Manson



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Table of Contents **Fitting And Machining Theory N1**

1. Understanding the eBook **Fitting And Machining Theory N1**
 - The Rise of Digital Reading **Fitting And Machining Theory N1**
 - Advantages of eBooks Over Traditional Books
2. Identifying **Fitting And Machining Theory N1**
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an **Fitting And Machining Theory N1**
 - User-Friendly Interface
4. Exploring eBook Recommendations from **Fitting And Machining Theory N1**
 - Personalized Recommendations
 - **Fitting And Machining Theory N1** User Reviews and Ratings
 - **Fitting And Machining Theory N1** and Bestseller Lists

5. Accessing Fitting And Machining Theory N1 Free and Paid eBooks
 - Fitting And Machining Theory N1 Public Domain eBooks
 - Fitting And Machining Theory N1 eBook Subscription Services
 - Fitting And Machining Theory N1 Budget-Friendly Options
6. Navigating Fitting And Machining Theory N1 eBook Formats
 - ePub, PDF, MOBI, and More
 - Fitting And Machining Theory N1 Compatibility with Devices
 - Fitting And Machining Theory N1 Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Fitting And Machining Theory N1
 - Highlighting and Note-Taking Fitting And Machining Theory N1
 - Interactive Elements Fitting And Machining Theory N1
8. Staying Engaged with Fitting And Machining Theory N1
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Fitting And Machining Theory N1
9. Balancing eBooks and Physical Books Fitting And Machining Theory N1
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Fitting And Machining Theory N1
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Fitting And Machining Theory N1
 - Setting Reading Goals Fitting And Machining Theory N1
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Fitting And Machining Theory N1
 - Fact-Checking eBook Content of Fitting And Machining Theory N1
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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