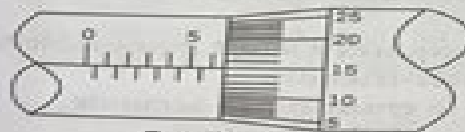


Figure 4.1: Outside micrometer

- 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:

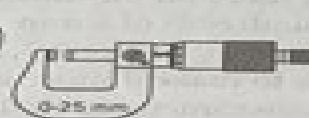
Spindle reading, full mm reading above centre line:	18,00 mm
Spindle reading below centre line:	0,50 mm
Thimble reading:	<u>0,45 mm</u>
Total reading:	18,95 mm

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



Reading

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

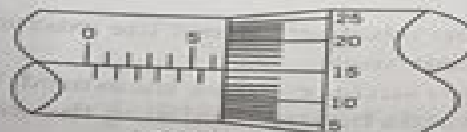


0-25 mm



Reading

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

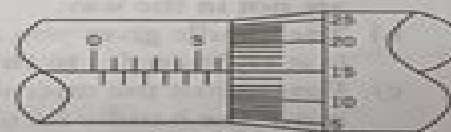


Reading

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



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

DP Hallahan



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