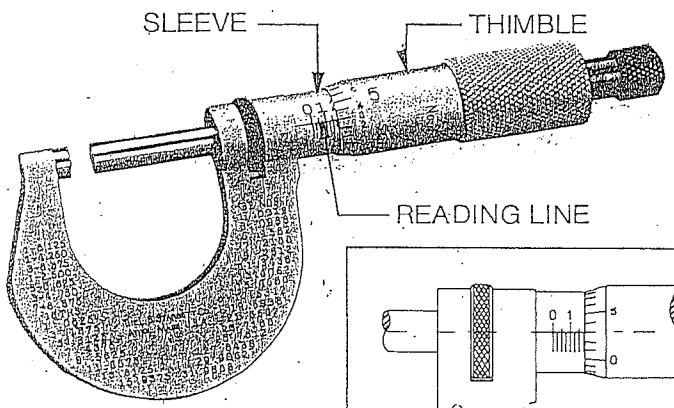
Starrett®

THE OUTSIDE MICROMETER
.001 Graduation

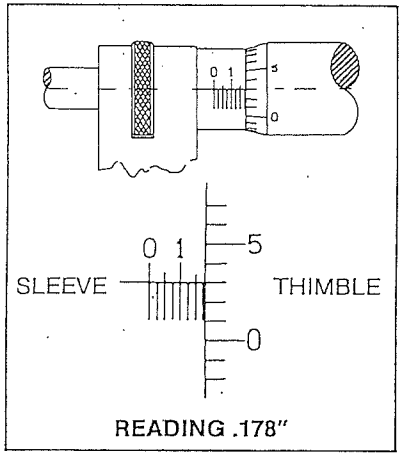


No. 230RL

- Each numbered sleeve graduation 0,1,2 etc. = .100"
- Each graduation between the numbered lines = .025"
- Each thimble graduation = .001"

EXAMPLE

Number "1" showing	= .100"
3 lines beyond "1" showing 3 X .025"	= .075
Line 3 on Thimble coincides with zero line on sleeve 3 X .001"	= .003"
The micrometer reading is	.178"

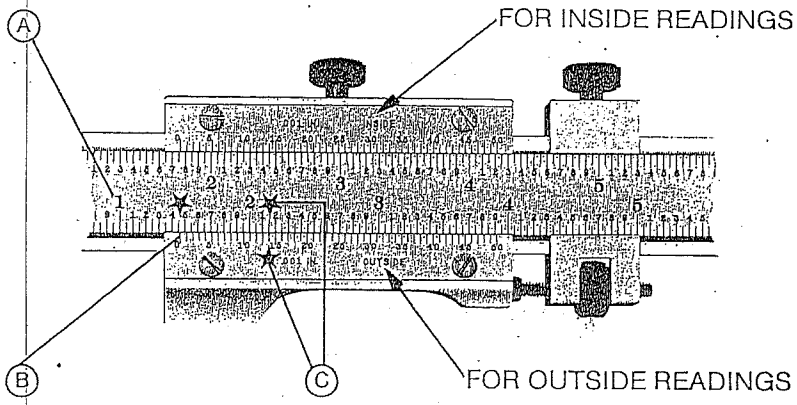


READING .178"

NOTE: To read an English Micrometer with a vernier, use the above method first, then see which vernier graduation (on the back side of the sleeve) coincides exactly with a thimble graduation. If the vernier line is marked 4, add .0004", if 7, add .0007" to the preliminary readings.

HOW TO READ ENGLISH MEASURING TOOLS

THE ENGLISH VERNIER CALIPER



- Each bar graduation = 1/20th of an inch (.050")
- Every second division = 1/10th of an inch (.100") and is numbered.
- The vernier plate is divided into fifty parts. Numbered 0,5,10,15,20,25 thru 50.
- The fifty divisions on the vernier plate occupy the same space as forty-nine divisions on the bar.
- To read the tool, note how many inches, tenths (or .100") and twentieths (or .050") the 0 mark on the slide vernier is from the 0 mark on the bar.
- Then note the number of divisions on the slide vernier from the 0 to any line which EXACTLY COINCIDES with a line on the bar.

EXAMPLE

In the above illustration the (outside reading) Vernier plate has been moved to the right one and four tenths and one twentieth inches (1.450), as shown on the bar and the fourteenth line on the slide Vernier EXACTLY COINCIDES with a line on the bar, as indicated on the illustration above. Fourteen thousandths of an inch are, therefore, to be added to the reading on the bar and the total reading is one inch, four hundred and sixty-four thousandths inches (1.464).

YOU ADD TO GET YOUR MEASUREMENT

A.	1.000 on the bar
B.	.450 also on the bar
C.	.014 on the Vernier plate (outside)
	1.464 is your measurement.

NOTE: To obtain inside readings use the same procedures except now use the upper Vernier plate for your readings.

The L. S. Starrett Company, Athol, Massachusetts 01331, U.S.A.

Printed in U.S.A.
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