



Electronic Bore Gage Instructions

Part Number: 54-646-401

Powering on and powering down the Bore Gage

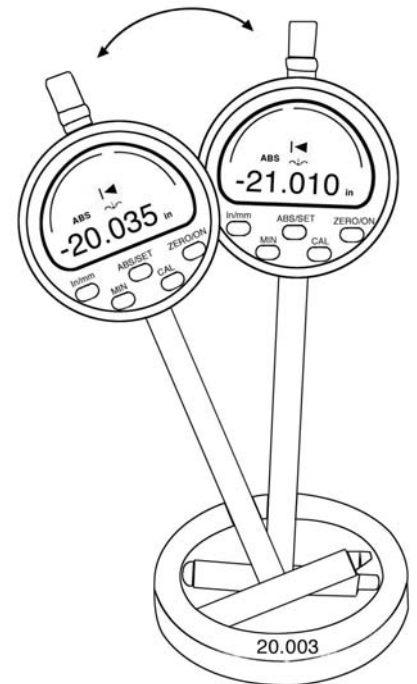
- 1) Press the Zero key lightly, the gage turns on.
- 2) Hold the Zero key down to turn the gage off.

Setting the Bore Gage to a known size

- 1) Press and hold the ABS/SET button.
- 2) Holding down the ABS/SET will cause the numeric values to flash in sequence from left to right.
- 3) Release the ABS/SET button on the flashing numeral. Tapping lightly on ABS/SET button will change the numeric value. When the desired numeral is set, hold down the ABS/SET button to move the next digit and repeat the process.
- 4) After the desired number is set, hold down the ABS/SET button until the "set" icon is flashing. Tap lightly on the ABS/SET button to confirm. The preset has been stored.

Calibrating the Bore Gage in a Master Ring

- 1) Insert the bore gage into a master ring with the appropriate post/spacers attached. The measuring faces should be touching the ring with enough travel left to facilitate easy sweeping.
 - 2) Ensure the bore gage is in ABS mode by pushing the ABS button. The ABS icon will appear on the indicator.
 - 3) Tap the MIN button to initiate calibration. Sweep the bore gage back and fourth in the ring. See figure.
 - 4) Observe the analog scale on the indicator watching for a reversal point.
 - 5) When the reversal point is obtained, remove the gage from the ring. Press and hold the CAL button. This will set the ring to the master. An "o.k." icon will flash to confirm successful calibration while holding down the CAL button.
 - 6) With the indicator still in MIN mode, insert the bore gage into the setting ring.
 - 7) Sweep the bore gage back and forth to obtain the minimum lock. The value displayed should match the ring size. Use the ZERO button to reset MIN mode and repeat to test repeatability.
 - 8) If the correct value is not achieved, repeat this section.



Standard Usage

- 1) With the bore gage calibrated and still set in the MIN mode from the earlier calibration, insert the bore gage into the bore to be measured and press the zero button. This will reinitialize the MIN mode. Rock the bore gage back and forth in the test bore to lock on to the diameter under test.
- 2) Remove gage, insert into the next test bore and reinitialize MIN mode.
- 3) Repeat the measuring process.