

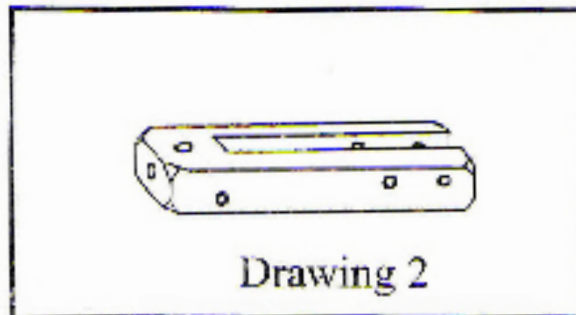
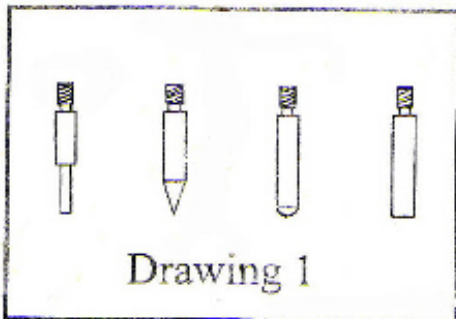
Caliper Anvil Kit (52-010-005)

SPECIFICATION

- For difficult applications or hard to reach places
- This kit measures inside, outside, step, grooves, left or right applications
- 1 set of Spline Contacts
- 1 set of Clamps
- 1 set of Ball Contacts
- 1 set of Flat Contacts
- 1 set of Point Contacts
- Contact length 20mm
- Minimum internal measurement 60mm
- Only suitable for use with 6, 8 & 12" caliper

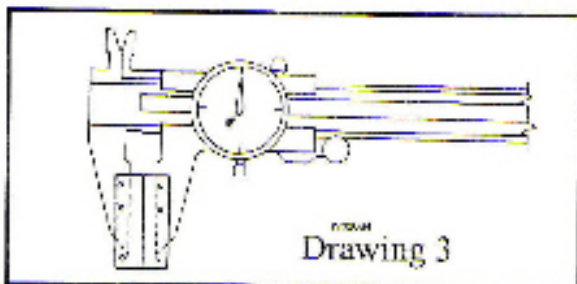
APPLICATION

Use on 4", 6", 8" calipers. For measurement of inside, outside, steps, grooves, etc.



PARTS

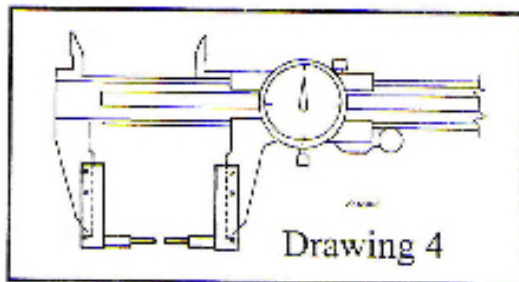
Kits includes two bodies as shown in **Drawing 2**, 8 set screws, and two each of the four attachment points (stem, cone, ball, and flat), showing in **Drawing 1**.



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SET UP

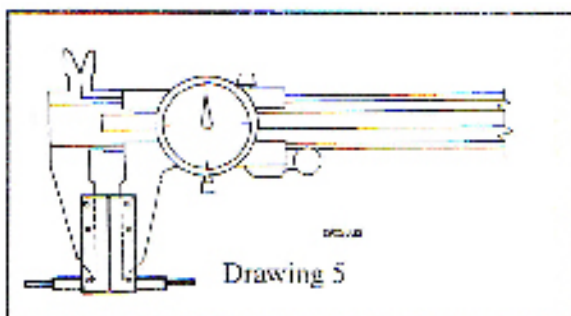
1. Insert 4 set screws into the set screw holes of each body.
2. If you are mounting these on a dial or vernier caliper, make sure the caliper is zeroes out before mounting the bodies.
3. Loosely mount the bodies onto the caliper jaws, as shown in **Drawing 3**.
4. Press the caliper jaws firmly together so the jaws seat firmly in the body slots, and the bodies are pressed back to back. Make sure bodies are aligned properly on jaws, then continue to press caliper jaws together while tightening the set screw.
5. Choose whatever style of point is applicable, and thread them into the bodies.
6. Depending on the type of measurement you wish to make, you may need to loosen the body set screws and readjust the position of the bodies so that the points touch, or are parallel with each other.



INSIDE POINTS (For outside measurements)

If you have your attachment set up such as in **Drawing 4**, you need to establish a zero, or datum point. This of course is easy with a digital caliper, as you need only to press together, zero out the caliper, and then proceed to take measurements.

If you have a dial or vernier caliper, press the points together and record the reading on the caliper. This is the zero point. When you take a measurement, write it down, and then subtract the zero point reading to get the actual measurement.



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OUTSIDE POINTS (For inside measurements)

If you have your attachment set up such as in **Drawing 5**, you need to establish a zero, or point. You must use another measuring device, such as another caliper, to measure the total outside distance from point to point, while pressing the jaws firmly together. Depending on the points used, this zero point reading will range from about 2.350" to 2.390". Record this reading as Measurement "A".  
Go to either Step 1 or Step 2 depending on the caliper you are using.

**Step 1 - For Electronic Digital Caliper only**

If you have a digital caliper, press the jaws together and zero out the caliper. Proceed to measure your workpiece. Record this reading as Measurement "B".

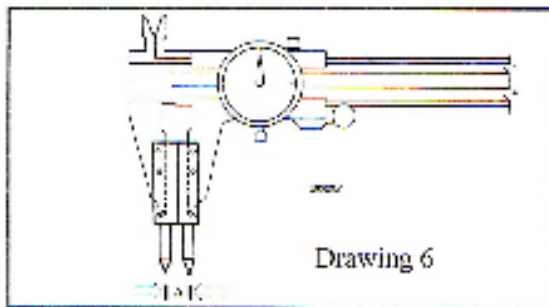
Actual Measurement of workpiece equals "A" + "B"

**Step 2 - For Dial or Vernier Caliper only**

If you have a dial or vernier, press the jaws firmly together and record the reading on the caliper as Measurement "B".

Proceed to measure your workpiece, record the reading on the caliper as Measurement "C".

Actual Measurement of workpiece equal "A" - "B" + "C"



CENTER TO CENTER MEASUREMENTS

If you have points attached as in **Drawing 6** you need to press caliper jaws firmly together and take a measurement between the cone tips with another caliper to determine Measurement "A".  
Go to either Step 1 or Step 2 depending on the caliper you are using.

**Step 1 - For Electronic Digital Caliper only**

Press caliper jaws firmly together and zero out the caliper. Take the measurement on your workpiece and record this as Measurement "B".

Actual Measurement of workpiece equals "A" + "B"

**Step 2 - For Dial or Vernier Caliper only**

Press caliper jaws firmly together and record the reading on the caliper as Measurement "B".  
Take the measurement on your workpiece and record this as Measurement "C".

Actual Measurement of workpiece equal "A" - "B" + "C"