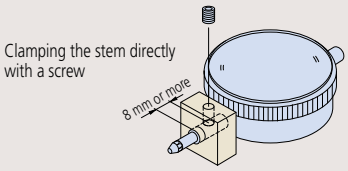
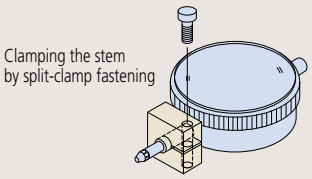
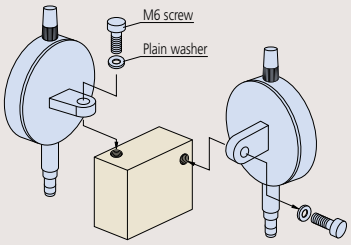
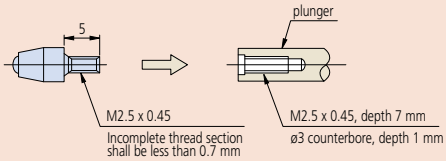
Mounting a Dial Gauge

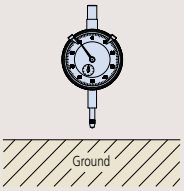
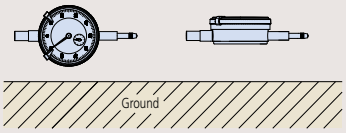
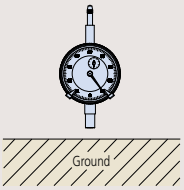
Stem mounting	Method		
	Note	• Mounting hole tolerance: ø8G7(+0.005 to 0.02) • Clamping screw: M4 to M6 • Clamping position: 8 mm or more from the lower edge of the stem • Maximum clamping torque: 150 N·cm when clamping with a single M5 screw • Note that excessive clamping torque may adversely affect plunger movement.	• Mounting hole tolerance: ø8G7(+0.005 to 0.02)
Lug mounting	Method		
	Note	• Lugs can be changed 90 degrees in orientation according to the application. (The lug is set horizontally when shipped.) • Lugs of some Series 1 models (No. 1911,1913-10 & 1003), however, cannot be altered to horizontal. • To avoid cosine-effect error, ensure that any type of gauge or indicator is mounted with its plunger in line with the intended measurement direction.	

Contact Element

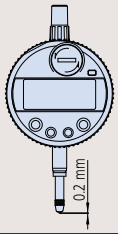
- Screw thread is standardized on M2.5x0.45 (Length: 5 mm).
- Incomplete thread section at the root of the screw shall be less than 0.7 mm when fabricating a contact point.



Effect of Orientation on Measuring Force

Position		Remarks
Contact element down (normal position)		—
Plunger horizontal (lateral position)		If measurement is performed with the plunger horizontal or contact element up, the measuring force is less than when the contact element is down. In this case be sure to check the operation and repeatability of the indicator or digital display. For guaranteed-operation specifications according to positions of digital indicators and dial gauges, refer to the product descriptions in a general catalogue.
Contact element up (upside-down position)		

Setting the Origin of a Digital Indicator



The specification in the range of 0.2 mm from the end of the stroke is not guaranteed for digital indicators. When setting the zero point or presetting a specific value, be sure to lift the plunger at least 0.2 mm from the end of the stroke.

Care of the Plunger

- Do not lubricate the plunger. Doing so might cause dust to accumulate, resulting in a malfunction.
- If the plunger movement is poor, wipe the upper and lower plunger surfaces with a dry or alcohol-soaked cloth. If the movement is not improved by cleaning, contact Mitutoyo for repair.
- Before making a measurement or calibration, confirm if the plunger moves upward and downward smoothly, and test the repeatability of the zero point.