



Bore Gage Setting Reference Card

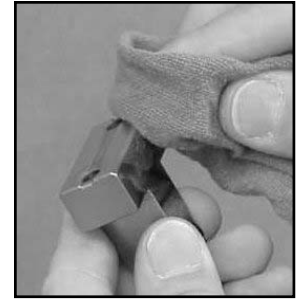


Setup

Materials Needed:

- MIC TRAC MT-3000 base unit and CPU readout
- Bore gage support fixture (TF-BI Block) and cap screws
- Flat face anvils (TF-1F Blocks) and cap screws
- 5/32" hex wrench
- 30 in/lb torque wrench
- Cloth
- ZEP I.D. Red cleaner

1. Clean both of the receiver pads and mounting surfaces of the flat face anvils using the cloth and ZEP I.D. Red cleaner.

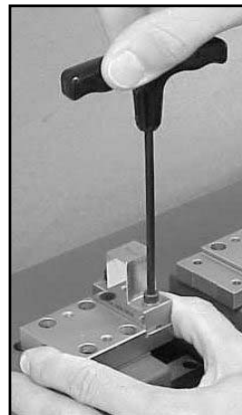


2. Place the shoulder side of the flat face anvil against the left receiver pad shoulder.



3. While holding the anvil against the receiver pad shoulder, insert the two cap screws into the holes on either side of the anvil.

4. While applying pressure toward the receiver pad shoulder, use a 5/32" hex wrench to slightly tighten the screws.



5. Use a 30 in/lbs torque wrench to secure the cap screws.





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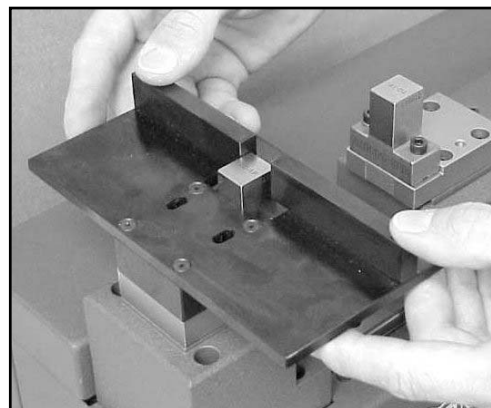
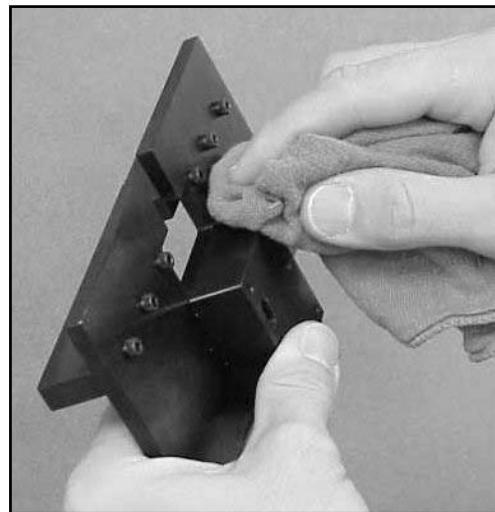
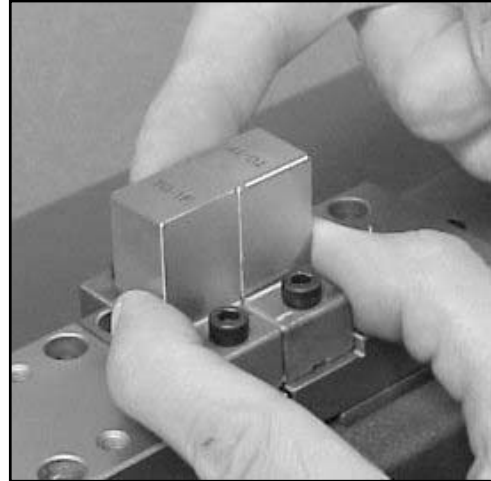


Setup

6. Repeat the same process with the right flat face anvil, but before completely tightening the screws, be sure the anvils are aligned:
 - Bring the flat face anvils together using the coarse adjust knob.
 - While holding the anvils together with your fingers, move your finger back and forth along the backside of the anvils to verify alignment.
 - If not aligned, loosen the right anvil and align.
 - Once aligned, use the torque wrench to secure the right anvil.

7. Clean the mounting surfaces of the bore gage support fixture using the cloth and ZEP I.D. Red cleaner.

8. Place the bore gage support fixture over the left flat face anvil and rest it on the left receiver pad.



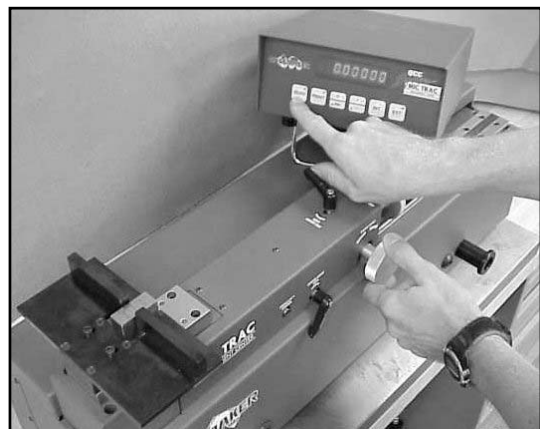
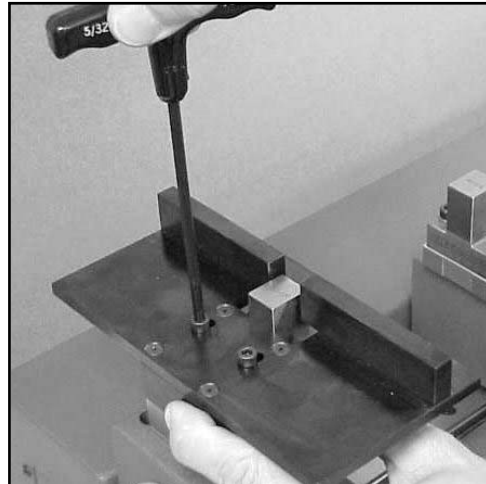


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9. Insert the two cap screws into the holes on either side of the bore gage support fixture.
10. While holding the bore gage support fixture, use a 5/32" hex wrench to tighten the screws.
11. Turn the coarse adjust knob counterclockwise to bring the flat face anvils together.
12. On the front panel of the CPU, press the INT (internal measurement) pad.
13. Press the ZERO pad on the CPU panel twice. The readout displays 0.00000.





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14. Turn the coarse adjust knob clockwise until the CPU reading is close to the desired bore gage setting value.



15. Secure the coarse adjust lock.



16. Turn the fine adjust knob clockwise until the CPU reads the exact bore gage setting value.





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17. Secure the fine adjust lock.





Bore Gage Setting Reference Card



Gage Setting

Materials Needed:

- MIC TRAC MT-3000 base unit and CPU readout
- Bore gage with extension
- 5/32" hex wrench
- Lightweight gage oil

1. Place the bore gage on the shelf of the bore gage support fixture, so the bore gage extension touches the right flat face anvil and the bore gage contact point touches the left flat face anvil.
2. To ensure the gage is properly seated in the fixture, sweep the bore gage back and forth to locate the smallest reading on the gage's indicator dial.
3. Align the indicator dial with zero.
4. After setting the bore gage, be sure to remove the flat face anvils and bore gage support fixture from the MT-3000. Oil the fixtures and return them to the storage case.

