

## MICROMETER CALIBRATION PROCEDURE #2

### ENVIRONMENT:

The environment must be relatively dust free. Clean surrounding inspection area with Citri-Clean, clean all inspection tools.

### A. VISUAL INSPECTION

1. Inspect the casting body, ratchet, thimble and the sleeve for evidence of damage.
  - a) Inspect the anvil and spindle for wear, burrs.
  - b) Inspect the protective carrying case for cleanliness, cracks and wear.
2. Using WD-40 clean the micrometer (disassemble if extremely dirty or seized). Do not oil the carbide contact points.
  - a) Re-assemble.
  - b) Fully close the micrometer.
3. Inspect the function of the micrometer.
  - a) Does the anvil and spindle align properly?
  - b) Does the spindle rotate smoothly?
  - c) Does the spindle lock clamp properly? (Adjust or repair if necessary).
  - d) Does the ratchet stop or friction thimble work properly?
  - e) Are the numbers and lines clearly readable?

### B. CALIBRATION

1. Cleaning the storing oil from the gage blocks.
2. Clean the gauge block stand.
3. Measure the OD of .250, .500, .750, 1.000 gage blocks. 1 –2 “micrometers and larger, require the gauge blocks to be wrung together. Do this by applying a small amount of molycoat lubricant to one measuring surface, rub the surfaces of each gauge block together. Apply pressure, the two surfaces will adhere.
4. Record the actual measurements on the Inspection Report.