

## Digitronic Bore Gauge 316 Series

Please carefully review these instructions to ensure proper and accurate use of your new Digitronic Bore Gauge.

### Powering on and powering down the Bore Gauge

- Press the ZERO key lightly, the gauge turns on
- Hold the ZERO key down to turn the gauge off

### Setting the Bore Gauge to a known size

- Press and hold the ABS/SET button
- Holding down the ABS/SET will cause the numeric values to flash in sequence from right to left
- 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 to the next digit and repeat the process
- 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 Gauge in a Master Ring

- Insert the bore gauge 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
- Ensure the bore gauge is in ABS mode by pushing the ABS button. The ABS icon will appear on the indicator
- Tap the MIN button to initiate calibration. Sweep the bore gauge back and forth in the ring. See diagram
- Observe the analogue scale on the indicator watching for a reversal point
- When the reversal point is obtained, remove the gauge from the ring. Press and hold the CAL button. This will set the ring to the master. An "ok" icon will flash to confirm successful calibration while holding down the CAL button
- With the indicator still in MIN mode, insert the bore gauge into the setting ring
- Sweep the bore gauge back and forth to obtain and hold the minimum value. The value displayed should match the ring size. Use the ZERO button to reset MIN mode and repeat to test repeatability
- If the correct value is not achieved, repeat this section

### Standard Usage

- With the bore gauge calibrated and still set in the MIN mode from the earlier calibration, insert the gauge into the bore to be measured and press the ZERO button. This will reinitialize the MIN mode. Rock the gauge back and forth in the test bore to freeze on to the diameter being measured
- Remove gauge, insert into the next test bore and reinitialize MIN mode by pressing zero
- Repeat the measuring process

Battery Type CR2032 3V

