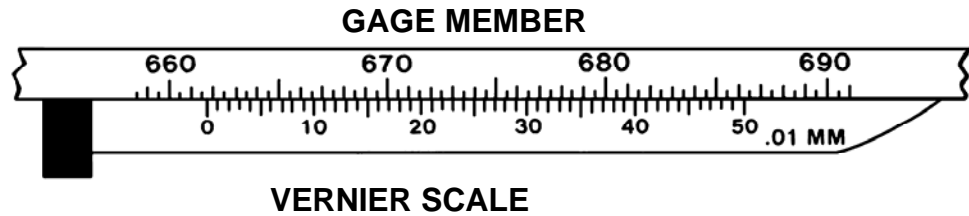




TO READ INSIDE DIAMETER METRIC TAPES



Make certain the tape is free of damage and the tape and object to be measured are both clean.

Each line on the gage scale of the tape represents .5mm of diameter, while each line on the vernier represents .01mm.

Place the tape inside the object to be measured. The vernier scale should be just below the gage scale. Make certain the tape is aligned on the inside diameter flat and snug to the part, straight and parallel so the gage member is flat against the vernier scale.

Locate the “zero” on the vernier scale and note the highest value achieved on the gage scale above it (the highest value to the left of the zero). In this example, that value is 661.5mm.

Next, observe the vernier scale’s value at the point where it lines up exactly with a marked division line on the gage scale. In this example, that value is 23 (0.23mm).

Finally, to obtain the diameter of the object, simply add the two values together:
 $661.5\text{mm} + 0.23\text{mm} = 661.73\text{mm}$

Inside diameter tapes are manufactured at 68°F under no tension. All inside diameter tapes are marked I.D. and are calibrated for direct inside diameter readings.

As a suggestion for checking very large diameters – pieces of masking tape can be used to hold the tape in the proper parallel position.

Pi Tape® Gages are guaranteed +/- .03mm accuracy on standard tapes up to 3600 mm.

Care

When not in use, wipe clean and apply a light rust preventive oil. Store in tape container.

No periodic adjustments are needed.

Make sure the tape has not been stepped on or kinked, which may destroy the accuracy.