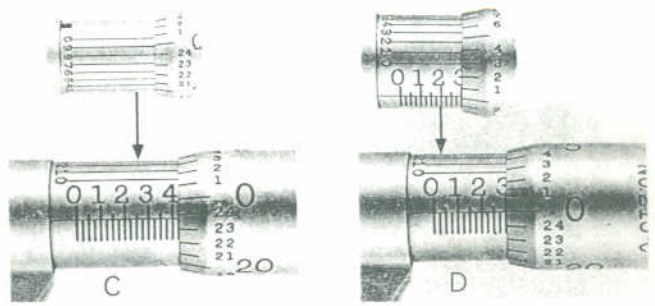


important to set this instrument to a thread plug gage before measuring a threaded workpiece. The screw micrometer is used for quick comparison of threads, as well as for checking small grooves and recesses where regular micrometers cannot be used.

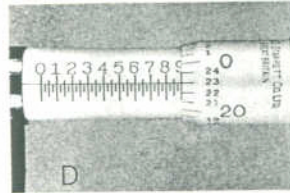
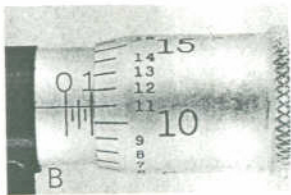
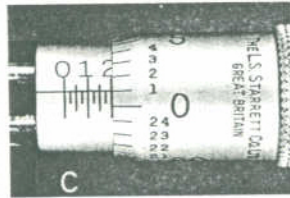
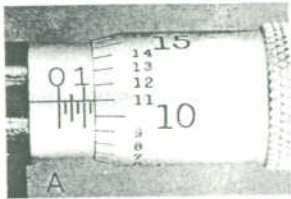
When thread micrometers or comparators are not available, threads may be accurately checked by the *three-wire method*, which we discuss fully in Unit 49.



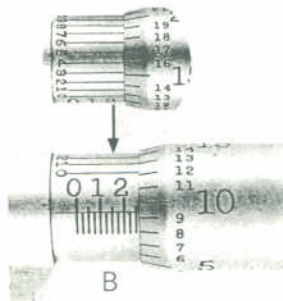
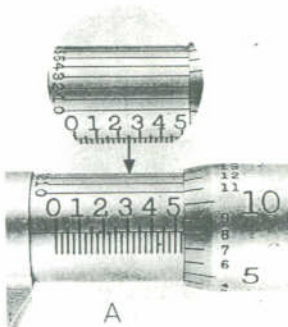
REVIEW QUESTIONS

MICROMETERS

- How many threads per inch are there on a standard inch micrometer?
- What is the value of:
 - Each line on the sleeve?
 - Each numbered line on the sleeve?
 - Each line on the thimble?
- Read the following standard micrometer settings.



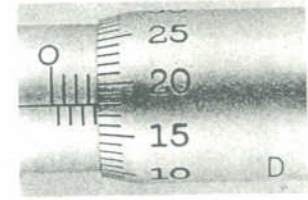
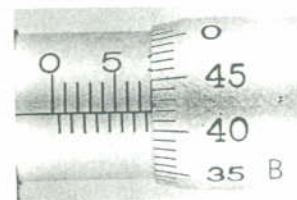
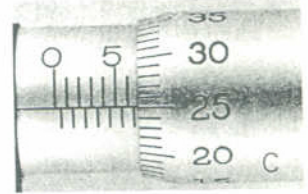
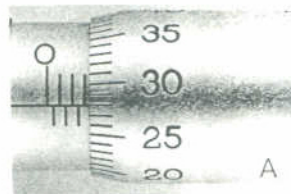
- Describe briefly the principle of the vernier micrometer.
- Describe the procedure for reading a vernier micrometer.
- Read the following vernier micrometer settings.



- Explain how to adjust a micrometer:
- To remove play in the spindle threads
 - For accuracy

METRIC MICROMETERS

- What are the basic differences between a metric and an inch micrometer?
- What is the value of one division on:
 - The sleeve above the index line?
 - The sleeve below the index line?
 - The thimble?
- Read the following metric micrometer settings.



INDICATING MICROMETER

- State two uses for an indicating micrometer.
- What is the purpose of the relieving button on the indicating micrometer?

SCREW THREAD MICROMETERS

- Describe the construction of the contact points of a screw thread micrometer.
- What dimension of the thread is indicated on a screw thread micrometer reading?
- List the four ranges covered by screw thread micrometers.
- How many threads be measured *accurately* with a screw thread micrometer?