MODEL 650.03B/C
CALIBRATOR

SERVICE INSTRUCTIONS
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1.0 PREPARATION OF CALIBRATOR FRAME

Two sets of gage adapters, or fixtures, are provided with the Model 650.03 B/C Calibrator. One set is for use with a clip-on displacement gage and the other set is for use with an extensometer.

1.1 CLIP-ON DISPLACEMENT GAGE CONFIGURATION

1. Attach knife edge provided to adapter surface of each fixture for clip-on displacement gage configuration. Use Allen wrench from plastic tool container.

2. Secure lower adapter in selected position using alignment blocks as shown in figure 1.


NOTE
Screws sealed in position with epoxy are not to be moved.

4. Adjust Calibrator Frame for clip-on displacement gage application as shown in figure 2. Observe the use of alignment blocks to align upper knife edge to lower knife edge after aligning lower adapter, or holder, to post.

1.2 EXTENSOMETER CONFIGURATION

1. Secure lower adapter in selected position using alignment blocks in a manner similar to that shown in figure 1.

2. Secure upper adapter in position using Allen wrench provided.

3. Adjust Calibrator Frame for extensometer application as shown in figure 3. Observe the use of alignment blocks to align upper and lower specimen rods. Reference figure 1 for alignment of gage adapters, or specimen rod holders, to post.

* Model 650.01 B-Micrometer Head Calibrated English
Model 650.03 C-Micrometer Head Calibrated Metric
2.0 PREPARATION FOR MICROMETER HEAD

1. Remove 8 millimeter-thick wood spacer from above nest block as shown in figure 4.
2. Clean contact surface of ball located in top of nest block. Use soft clean cloth.
3. Add small quantity of grease to ball contact surface.

3.0 INSTALLATION OF MICROMETER HEAD

1. Before installing, rotate micrometer head counterclockwise until scale reads approximately 25 millimeters (1 inch) as shown in figure 5. Micrometer spindle is now in the retract position.
2. Clean contact end of micrometer spindle with soft clean cloth.
3. Position micrometer head as shown in figure 5.
4. Press down firmly on micrometer head to depress nest block, and tighten related locking screw.

4.0 REMOVAL OF MICROMETER HEAD

1. Before removing, rotate micrometer head counterclockwise until scale reads approximately 25 millimeters (1 inch). Micrometer spindle is now in the retract position.
2. While pressing down on micrometer head, loosen related locking screw, as shown in figure 5.
3. Remove micrometer head.
4. Retract nest block as necessary to insert 8 millimeter-thick wood spacer. Allow nest block to press hard against spacer.

5.0 LUBRICATION

The following procedures are to be accomplished at regular intervals; frequency of lubrication is dependent on amount of usage.

1. Clean contacting surface of nest block ball and micrometer spindle with a soft clean cloth.
2. Add small quantity of heavy lubricating grease to ball contact surface.
6.0 PARTS LIST

Model 650.03 B/C Calibrator includes the following parts:

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Quantity</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>315083-01</td>
<td>1</td>
<td>Calibrator Frame</td>
</tr>
<tr>
<td>315082-01</td>
<td>1</td>
<td>Micrometer Head (English)</td>
</tr>
<tr>
<td>315082-02</td>
<td>1</td>
<td>Micrometer Head (Metric)</td>
</tr>
<tr>
<td>315084-01</td>
<td>1</td>
<td>Extensometer Attachments (Adapters)</td>
</tr>
<tr>
<td>315085-01</td>
<td>1</td>
<td>Clip-On Displacement Gage Attachments (Adapters)</td>
</tr>
<tr>
<td>None</td>
<td>1</td>
<td>Tool Set (Wrenches and Alignment Blocks)</td>
</tr>
</tbody>
</table>
Figure 1 Gage Adapter (Fixture) Adjustment
Figure 3  Adjustment of Calibrator for Extensometer