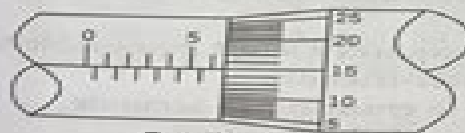


Figure 4.1: Outside micrometer

- The reading on the sleeve, above the line, is full millimetres. This is read first and written down.
- Check whether you can see a half-millimetre line below the centre line, to the right of the last full millimetre line, above. There is a half millimetre line below the centre line between every full millimetre above the centre line. If you can see this, add 0,50 mm to the reading you have already written down.
- The next step is to write down the reading on the thimble, below the last reading. See random example:

Spindle reading, full mm reading above centre line:	18,00 mm
Spindle reading below centre line:	0,50 mm
Thimble reading:	<u>0,45 mm</u>
Total reading:	18,95 mm

Reading an outside micrometer (0 – 25 mm and 25 – 50 mm)



Reading

$$6 + 0 + 0,15 = 6,15 \text{ mm}$$

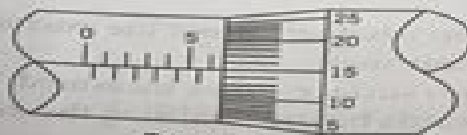


0-25 mm



Reading

$$6 + 0,5 + 0,15 = 6,65 \text{ mm}$$

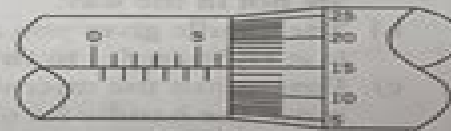


Reading

$$25 + 6 + 0 + 0,15 = 31,15 \text{ mm}$$



25-50 mm



Reading

$$25 + 6 + 0,5 + 0,15 = 31,65 \text{ mm}$$

When using a micrometer that is bigger than a 0 – 25 mm micrometer, if, for example, the micrometer is the 25 – 50 mm one, take the reading and add 25 mm. If the reading is 21,31 mm the result would be $25 + 21,31 = 46,31$.

Notes For Fitting And Machining Theory N1

Hussin A.Rothana



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Table of Contents Notes For Fitting And Machining Theory N1

1. Understanding the eBook Notes For Fitting And Machining Theory N1
 - The Rise of Digital Reading Notes For Fitting And Machining Theory N1
 - Advantages of eBooks Over Traditional Books
2. Identifying Notes For Fitting And Machining Theory N1
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Notes For Fitting And Machining Theory N1
 - User-Friendly Interface
4. Exploring eBook Recommendations from Notes For Fitting And Machining Theory N1
 - Personalized Recommendations
 - Notes For Fitting And Machining Theory N1 User Reviews and Ratings
 - Notes For Fitting And Machining Theory N1 and Bestseller Lists
5. Accessing Notes For Fitting And Machining Theory N1 Free and Paid eBooks
 - Notes For Fitting And Machining Theory N1 Public Domain eBooks
 - Notes For Fitting And Machining Theory N1 eBook Subscription Services
 - Notes For Fitting And Machining Theory N1 Budget-Friendly Options

6. Navigating Notes For Fitting And Machining Theory N1 eBook Formats
 - ePub, PDF, MOBI, and More
 - Notes For Fitting And Machining Theory N1 Compatibility with Devices
 - Notes For Fitting And Machining Theory N1 Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Notes For Fitting And Machining Theory N1
 - Highlighting and Note-Taking Notes For Fitting And Machining Theory N1
 - Interactive Elements Notes For Fitting And Machining Theory N1
8. Staying Engaged with Notes For Fitting And Machining Theory N1
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Notes For Fitting And Machining Theory N1
9. Balancing eBooks and Physical Books Notes For Fitting And Machining Theory N1
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Notes For Fitting And Machining Theory N1
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Notes For Fitting And Machining Theory N1
 - Setting Reading Goals Notes For Fitting And Machining Theory N1
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Notes For Fitting And Machining Theory N1
 - Fact-Checking eBook Content of Notes For Fitting And Machining Theory N1
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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