

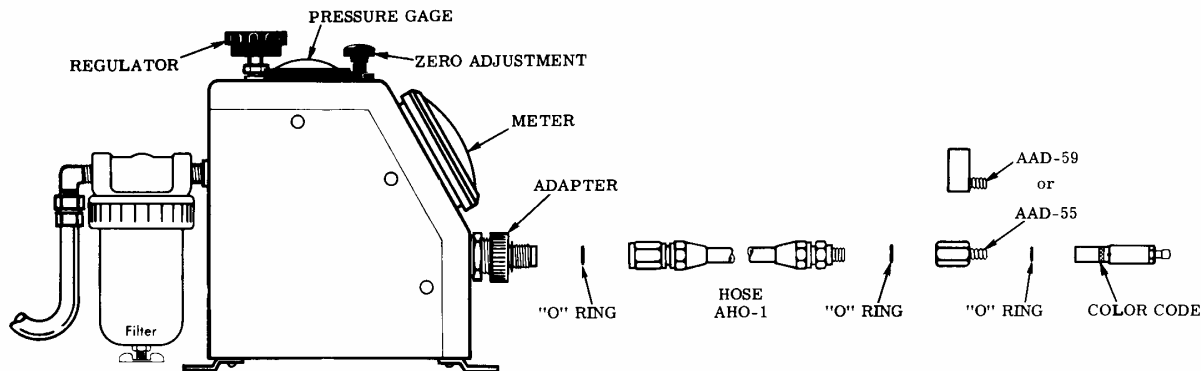


INSTRUCTIONS

AIRPROBES - Normal Action

Models AA-1-3, AA-1-6, AA-1-15, AA-1-30

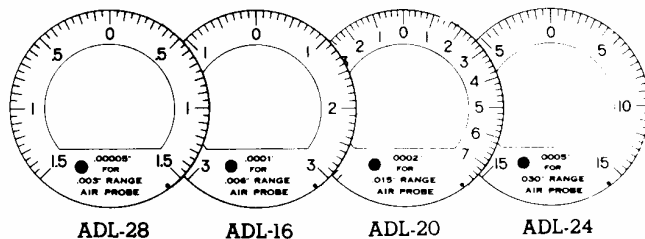
IMPORTANT: READ THESE INSTRUCTIONS CAREFULLY AND COMPLETELY



- Using either straight adapter (AAD-55) or right-angle adapter (AAD-59), connect AirProbe to male end of plastic hose (AHO-1). Attach female end of hose to adapter on front of Dimensionair unit. Be sure that all "O" rings are in place. These connections need only be finger-tight.
- Turn air ON. Check air pressure setting on the pressure gage. Adjust regulator if necessary.
- Push AirProbe plunger all the way in and hold it there. Turn Zero Adjustment Knob until meter reads exactly "Zero". Release plunger. Because AirProbe has a built-in master, no external zero-setting or calibrating masters are required.
- Position AirProbe loosely in its clamp. Always clamp AirProbe around its larger diameter (machined to the same size as stem of a-n AGD Dial Indicator-- .375"). Do NOT restrict air escape holes on AirProbe body. Do NOT use clamps that cause heavy localized stress. Do NOT use set screws, etc.
- Place size master (or nominal size work piece) in gaging position.
- COARSE Adjustment: Adjust AirProbe and its clamp until meter reads within +/- 2 scale divisions of "Zero". Tighten clamp; do NOT use excessive force because it may cause AirProbe plunger to bind.
- FINE Adjustment: Turn Zero Adjustment Knob until meter reads exactly "Zero". Check for repeat by reintroducing master several times in exactly the same way. "Zero" is now set. (If meter does not repeat to "Zero", loosen clamp and repeat steps 5 through 7. Recheck repeat.

DIMENSIONAIR MUST BE EQUIPPED WITH DIAL THAT SUITS AIRPROBE RANGE

| Use with Gage Model | AirProbe Model No. | Graduations | Range | Color Code |
|---------------------|--------------------|----------------------|-------------------|------------|
| D-2500 D-5000 | AA-1-3 | .00005'' .00002'' | .003'' .0015'' | Red |
| D-2500 | AA-1-6 | .0001'' | .006'' | Green |
| D-2500 | AA-1-15 | .0002'' | .015'' | Yellow |
| D-2500 | AA-1-30 | .0005'' | .030'' | Blue |



FEDERAL AIRPROBE CLEANING INSTRUCTIONS

DISASSEMBLY

1. Remove hose adapter and place AirProbe in suitable device. (Be careful not to apply more pressure than is needed to hold AirProbe firmly. Greater pressure will distort AirProbe).
2. Unscrew the contact point. Avoid scratching the plunger.
3. Loosen the plunger assembly at the front end of the AirProbe with an adjustable wrench.
4. Remove the AirProbe from the holding device.
5. Remove the plunger assembly.
6. Grasp the collar and compress the spring. Caution, the pin is loose and may drop. Remove the pin and slide the plunger out of the plunger assembly.
7. Using tweezers, remove each of the 3 rubber "O" rings: one from the end of the plunger assembly, one from inside the body, and one from inside the hose adapter.

CLEANING

Clean all parts in a volatile solvent such as clean alcohol. Be careful not to damage the spring on the plunger assembly when cleaning. A pipe cleaner may be used

to scrub the plunger assembly bore and the body bore. Dip all parts in the cleaning fluid and blow dry. Care should be taken during the entire cleaning process.

REASSEMBLY

1. Place the "O" rings in position.
2. Slide the plunger into the plunger assembly then grasp the collar and compress the spring. Line up the hole in the plunger with the slot in the plunger assembly.
3. Insert the pin so that its shoulders seat in the collar.
4. Replace plunger assembly in the AirProbe and screw in as far as it will go.
5. Grip the body in a holding device. Tighten the plunger assembly with an adjustable wrench. Remove from holding device.
6. Check for free operation of the plunger. If plunger still sticks, repeat cleaning and look for burrs.
7. Screw the contact point into the plunger and tighten gently with pliers. Connect the air hose adapter. Connect AirProbe assembly to hose with finger tightness.

TO MAKE SURE THAT AIRPROBE IS WORKING PROPERLY BEFORE RETURNING IT TO SERVICE -

1. Attach AirProbe to a Dimensionair gage which has previously been set to zero by other means (that is, air plug and master ring or other Air Probe known to be in good condition).
2. Depress AirProbe plunger as far as possible and note meter reading. Indicating hand should be within .00025" of zero (5 divisions on 2500:1 model). If it is not, AirProbe is either defective or has not been cleaned properly. Repeat cleaning procedure or return unit to Federal Products for service.

