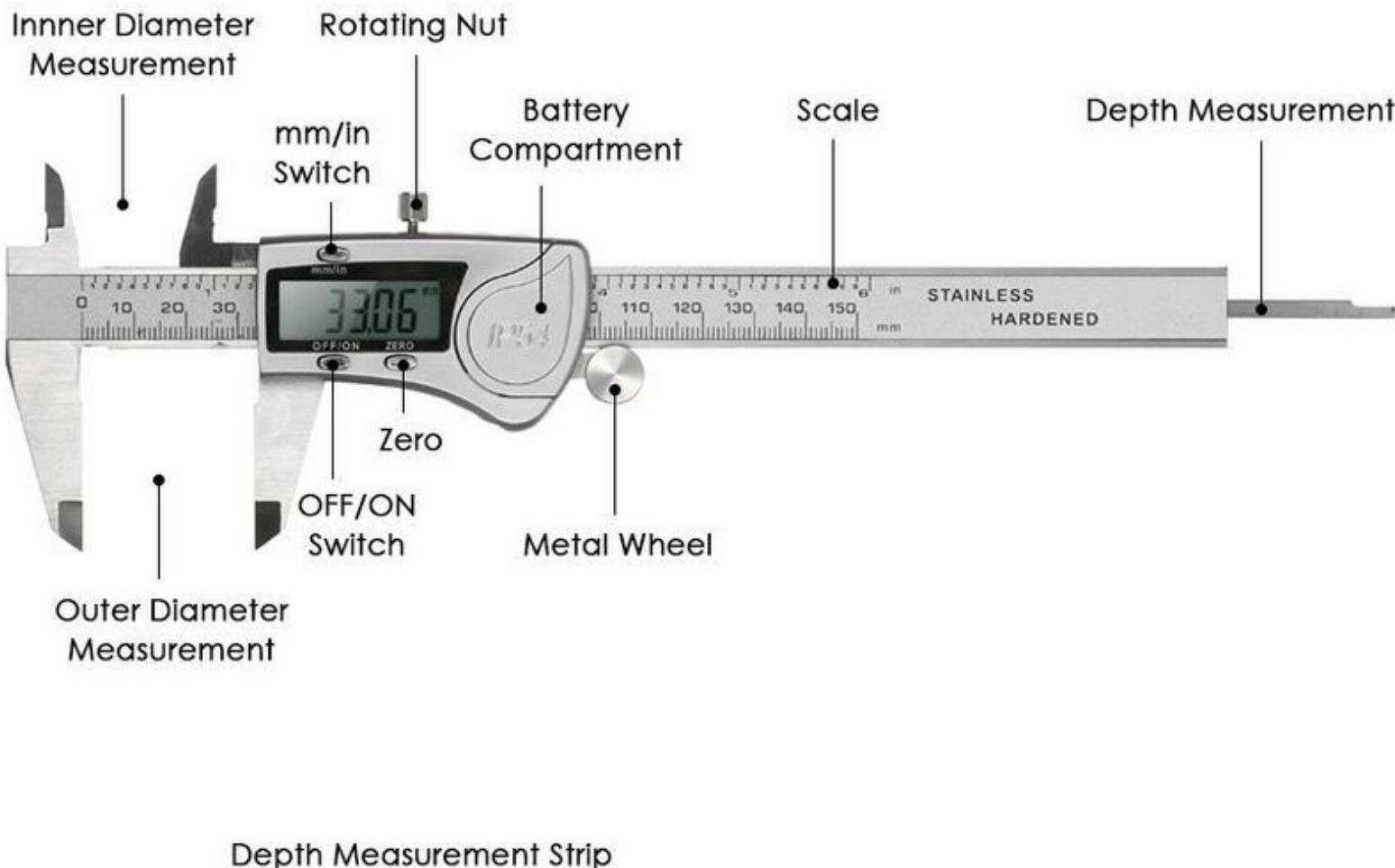




# How to Position a Vernier Caliper

This guide demonstrates the different methods for taking measurements with a vernier calliper.

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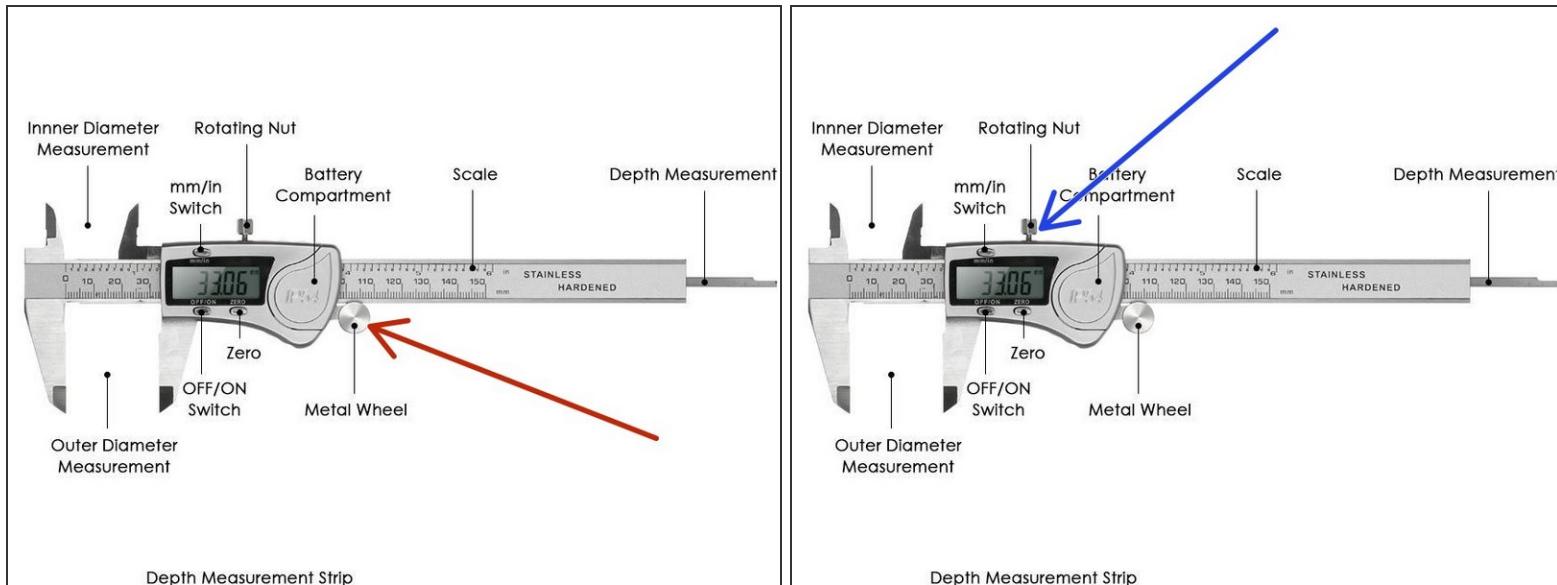
## INTRODUCTION

These instructions will cover the techniques for measuring external & internal features, as well as heights and depths.

### **TOOLS:**

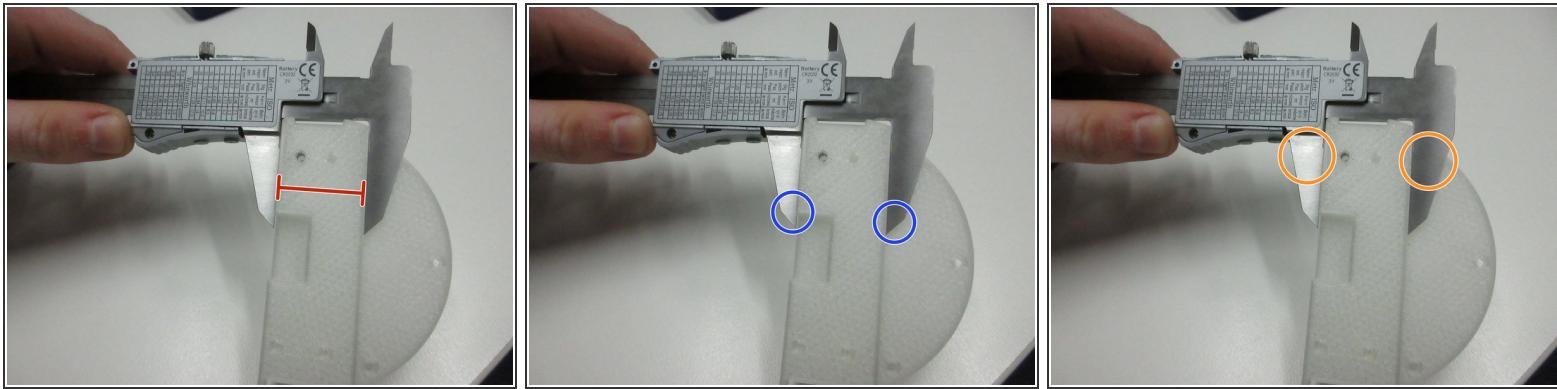
- [Digital Caliper \(1\)](#)

## Step 1 — Good Practice



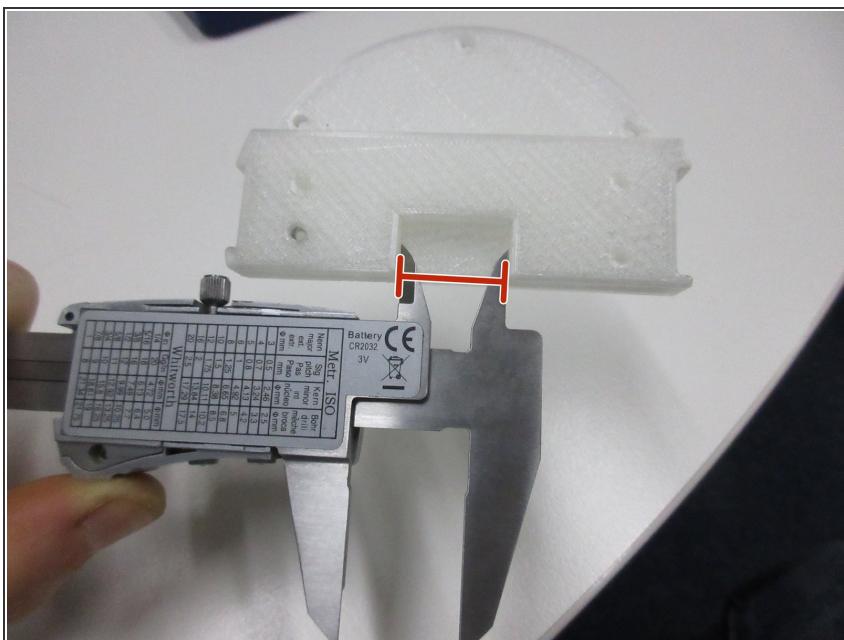
- Use the metal wheel contacting the measured surfaces.
  - This will allow for a more repeatable measurement.
  - **!** Extend the calibration life of the device. Preventing damage to the measuring surfaces or measured part.
- Make use of the locking mechanism.
  - Occasionally the device has to be positioned in a way that cannot be read.
  - Always prioritize comfort. If there is a change the jaws can move when attempting to read. **Lock the device. Move it to you.**
- **i** Ensure the part is secure, use flat surfaces, try to use the vernier comfortably with both hands.

## Step 2 — External Feature



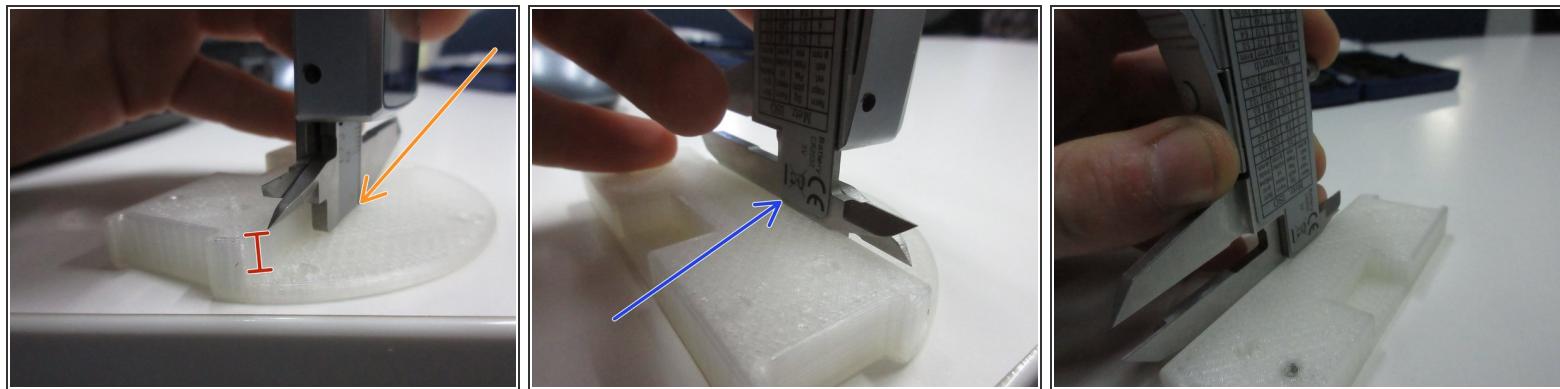
- External features are measured as shown.
- These sections of the jaws have a knife edge,
  - (i)* Used to measure smaller features with low clearances.
- These sections have a flat edge.
  - (i)* Used to measure larger features with perpendicular surfaces.

## Step 3 — Internal Feature



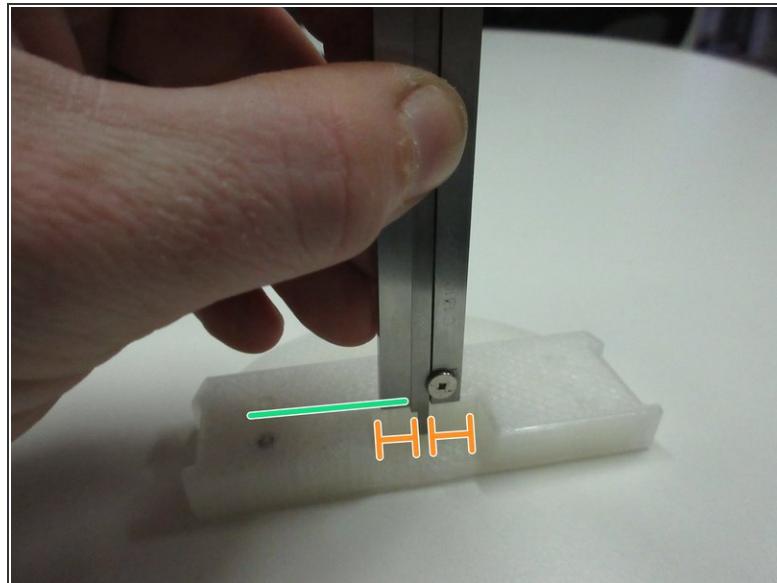
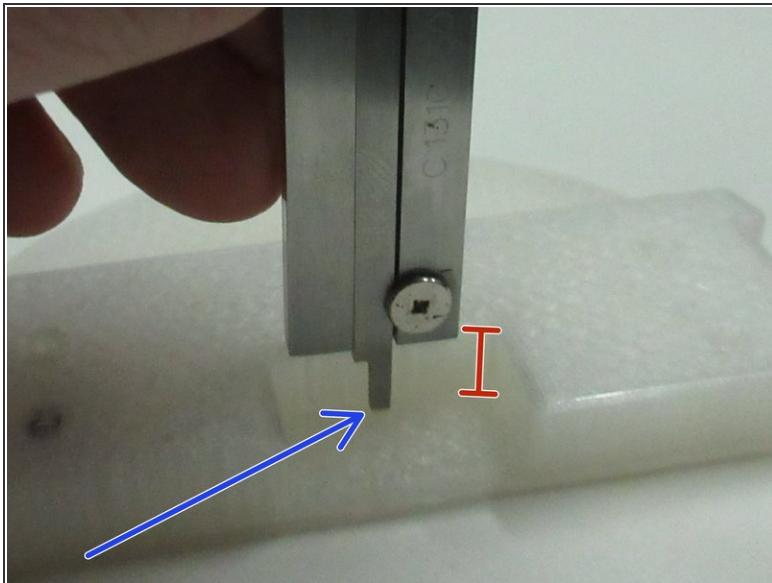
- Internal features are measured as shown.

## Step 4 — Height



- Heights of steps are measured as shown.
- Butt the head of the caliper against one surface.
- Butt the head of the slider against the other surface.

## Step 5 — Depth



- Depth of holes are measured as shown.
- Position the blade to the center of the hole.
- Hold the end of the caliper flush the surface of the hole.
- Extend the slider until the blade bottoms out the hole.

Happy Measuring