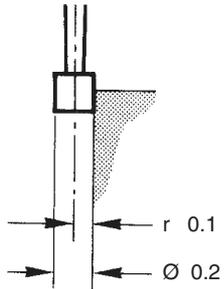


**PATENT NOTICE**

The Job Contact Probe is protected by the following patents  
DE 2347633 IT 1003537 JP 1266244 US 4270275 JP 1388652

Renishaw plc. New Mills,  
Wotton-under-Edge, Glos GL12 8JR, UK.  
Tel 01453 524 524 Fax 01453 524 901

**1. Description**



When the probe contacts the workpiece, the red LED lights up.

Stylus position repeatability (maximum  $2\sigma$ ):  
0.00004 inch

The stylus radius (0.1 inch) must be taken into account when necessary.

I.D. : Measured distance + 0.2 inch  
O.D. : Measured distance - 0.2 inch

The stylus has 0.59 inch overtravel in X and Y axes, and 0.19 inch in the Z axis.

Overtravel must not be exceeded or damage will result.

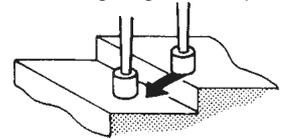
**IMPORTANT**  
The probe must not be spun under spindle power

**Application examples**

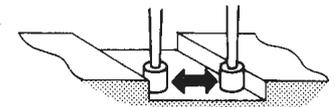
Nos 1-4 **Direct measurement of steps, slots, external features, and contours of workpiece datum surfaces or edges.**

No. 5 **Defining bore centres in line with spindle centre line.**  
Contact the sides of the bore with the stylus (1 and 2), then halve the measurement between 1 and 2 to obtain the axis centre.  
Touch on points 3 and 4, then halve the measurement between 3 and 4 to obtain the bore centre.

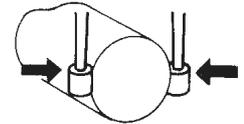
1. Measuring height and depth



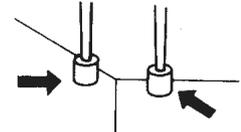
2. Measuring internal features



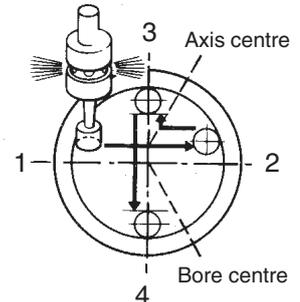
3. Measuring external features



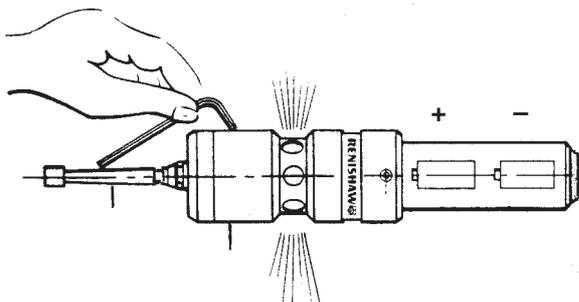
4. Measuring datum edges



5. Centering and measuring bores



**2. Batteries**



**To change the batteries**

Unscrew the cap.  
Note polarity.  
Remove exhausted batteries.  
Insert new batteries.  
Replace cap.

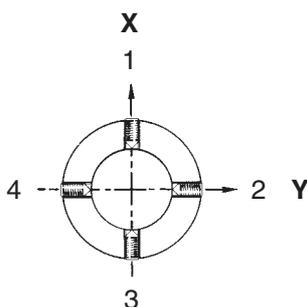
Order information for spare batteries :  
IEC No. LR 1 1.5V

**To check the battery power**

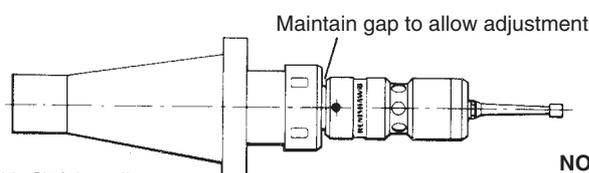
Make a contact between points A and B with a metal object (e.g. hexagon key).  
LEDs will light up if batteries are correctly fitted.

**3. Installation on taper shanks and adjustment for out of roundness**

The shank adaptor and stylus must be adjusted when assembled to achieve concentricity of 0.004 inch.



Milling collet chuck with Ø3/4in collet



**NOTE : Ensure probe is not splashed with coolant**