

Precision Level

Precision Fix Level

Instruction Manual

To ensure correct use, please read this instruction manual carefully before use. After reading, keep it in a safe place where the user can always refer to it.



[524A]



[524B]



[524C]



[524D]

OBISHI KEIKI SEISAKUSHO Co., Ltd.

Safety Precautions

- ※Before use, please read this instruction manual carefully and use the product correctly.
- ※The precautions shown here are intended to ensure the safe and proper use of the product and to prevent any potential hazards to the user.
- ※The precautions are categorized into three levels — **Danger, Warning, and Caution** — to clearly indicate the severity and urgency of potential harm or damage that may occur if the product is mishandled.

For Safe and Proper Use		
This instruction manual includes various symbols and pictograms throughout the text to ensure correct use of the product and to prevent harm or damage to the user. The symbols and their meanings are as follows. ● Please read the text after fully understanding the symbols and their meanings. ● After reading, be sure to keep this manual in a place where anyone using the product can easily refer to it at any time. ● All of these are safety-related instructions, so please be sure to follow them.		
	Danger	This indicates situations where incorrect handling could result in imminent risk of death or serious injury.
	Warning	This indicates situations where incorrect handling could potentially result in death or serious injury.
	Caution	This indicates situations where incorrect handling may result in injury to persons or only property damage.
Examples of symbols		The △ symbol indicates the presence of danger, warning, or caution messages, with specific precautions described within the figure. (The left figure is used to indicate general danger, warning, or caution without specifying details.)
		The ○ symbol indicates prohibited actions, with specific precautions described within or below the figure. (The figure on the left is used for general prohibition notices without specifying particular actions.)
		The ● symbol indicates mandatory actions, with specific instructions detailed within the figure. (The figure on the left is used for general mandatory actions or instructions without specifying details.)

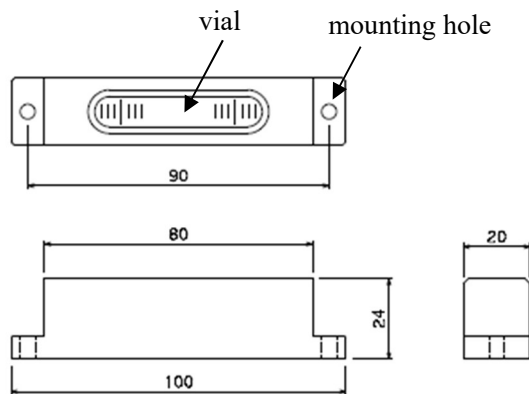
Precision Fix Level Instruction Manual

1. Product Features

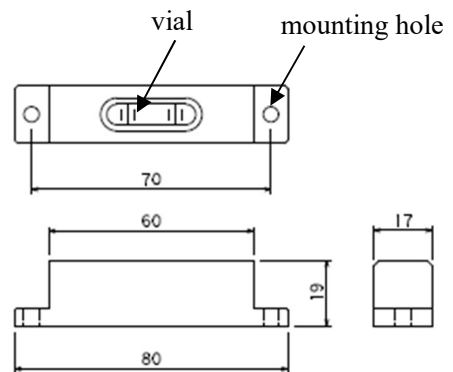
- It is a compact, high-sensitivity precision level.
- It is manufactured with the same sensitivity as flat levels for general workshop use.
- It is suitable for a wide range of applications such as alignment in confined spaces, machine inspection, assembly, and built-in installation on machines.
- Each model is available with different sensitivities to accommodate various applications.

2. Names of Parts

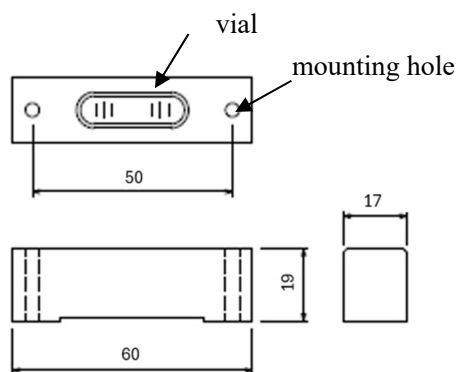
Model: 524 A



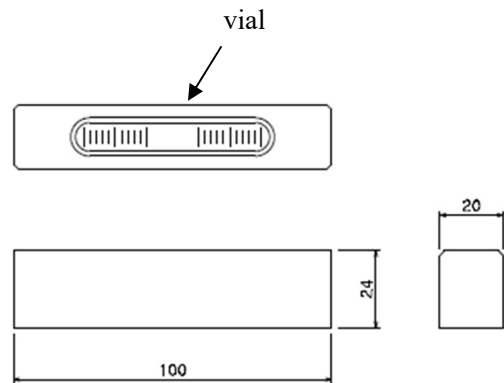
Model: 524 B



Model: 524 C



Model: 524 D



3. Specifications

Code No.	Model	Size (L×W×H mm)	Sensitivity (mm/m)	Mass (g)	Hole Diameter× Hole Pitch(mm)
AS101	524A	100×20×24	0.05	200	4.5×90
AS102			0.1		
AS201	524B	80×17×19	0.5	150	4.5×70
AS202			2.0		
AS301	524C	60×17×19	0.5	120	3.5×50
AS302			2.0		
AS401	524D	100×20×24	0.02	250	—
AS402			0.05		
AS403			0.1		

4. Sensitivity

The sensitivity of a level refers to the inclination required to move the bubble in the vial by one division (Fig. 2).

This inclination is expressed as the height difference per 1 m of base length or as an angle in seconds.

Note: The relationship between the angle and the height relative to the base length is as follows.

Angle 1 second = 4.85 μ m per 1 m ($\approx$ 5 μ m per 1 m)

The sensitivity is as follows.

Sensitivity: 0.02 mm/1 m ($\approx$ 4 seconds)

Sensitivity: 0.05 mm/1 m ($\approx$ 10 seconds)

Sensitivity: 0.1 mm/1 m ($\approx$ 20 seconds)

Sensitivity: 0.5 mm/1 m ($\approx$ 1 minute 43 seconds)

Sensitivity: 2.0 mm/1 m ($\approx$ 6 minute 52 seconds)

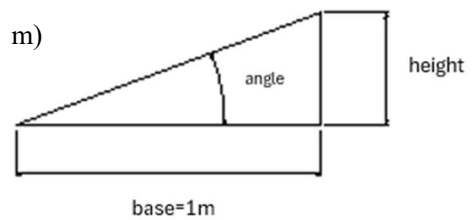
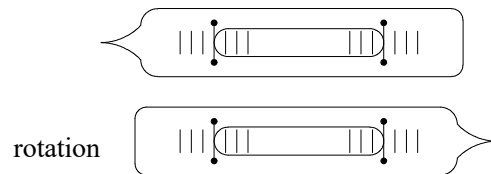


Fig. 2 Inclination for One-Division
Bubble Displacement

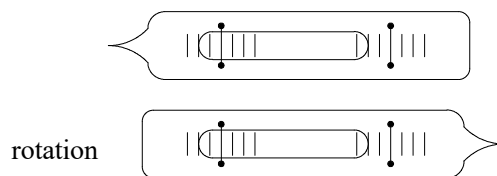
5. Preparation Before Use and Periodic Accuracy Check

- (1) Place the level on the reference surface plate and check the position of the bubble.
- (2) At the same location, rotate the level 180 degrees and check the position of the bubble again.

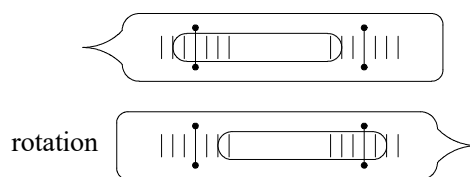
【When both the level and the reference surface plate are horizontal】



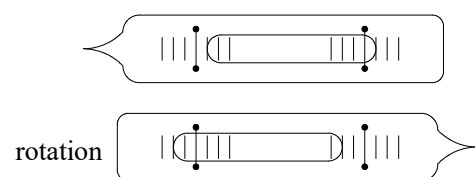
【When the level is horizontal but the reference surface plate is not horizontal】



【When the level is not horizontal】...stop using the instrument



The bubble moves equally to the left and right, offset by the same number of graduations from the reference.



The bubble moves irregularly to the left and right.

6. Precautions for Use

- ① Clean the Precision Surface and the measurement surface of the workpiece before use.
- ② Handle the instrument carefully during use and storage to avoid impact or shock.
- ③ Allow the instrument to acclimate to the ambient temperature before use.
- ④ When moving the instrument on the workpiece, avoid lifting it unnecessarily and move it by sliding.
- ⑤ Since the bubble in this instrument moves slowly, always take the reading only after the bubble has come to a complete stop.
- ⑥ When held by hand for an extended period, a level with a sensitivity of 0.02 mm/m may exhibit zero-point drift due to temperature changes from hand contact.
- ⑦ To obtain an accurate reading with the level, always use the average value of the indications at both ends of the bubble.
- △ ⑧ Do not use or store the instrument in locations subject to drastic temperature changes.
Storing or leaving the instrument in environments below -15°C or above $+40^{\circ}\text{C}$ may cause damage to the vial, such as breakage.
- ⑨ After use, always apply rust prevention treatment and store the instrument in its storage case.
- ⑩ Accurate measurement cannot be performed if there is rust, burrs, or scratches on the working surface, so handle with care.
Before use, remove minor scratches on the working surface locally with an Arkansas stone or similar tool.
- ⑪ When any of the following occurs, check the sensitivity of the instrument before use:
 - If the instrument has been dropped.
 - If an object has been dropped onto the instrument.
- △ ⑫ If the product has sharp edges, handle it carefully to avoid injuring your fingers or other parts of your body.
- △ ⑬ Wear protective gloves and safety glasses as necessary to prevent injury while working.
- △ ⑭ Do not use this product if it is damaged or deteriorated, as it may cause injury or accidents.
- △ ⑮ If an injury occurs, give first aid immediately and seek medical attention if necessary.

Contact Information

JIS Certified Factory



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Head Office and Factory

Design, development, manufacturing, and calibration services for precision measuring instruments (levels, surface plates, straight edges, reference measuring instruments, square rulers, blocks, dial gauge stands, comparators, angle measuring instruments, bench centers, squareness measuring instruments).