

Precision V Blocks

V Blocks(Granite)

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.



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.

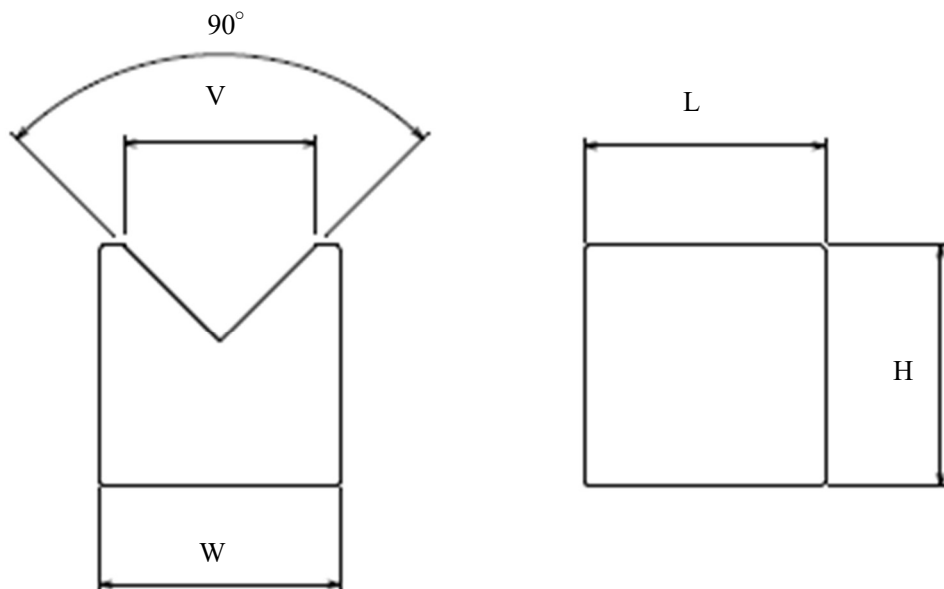
For Safe and Proper Use		
This instruction manual includes various symbols and pictograms throughout the text to ensure correct use of the product and to prevent harm or damage to the user. The symbols and their meanings are as follows. ● Please read the text after fully understanding the symbols and 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.)

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1. Product Features

- They are manufactured as a set of two, with the parallelism between the two base surfaces and the V-grooves ensured.
 - It features minimal aging and temperature variation, high wear resistance, and resistance to rust.
 - They are highly convenient for inspecting cylindrical workpieces and for use as auxiliary blocks (straightedges).
 - The V-groove is 90 degrees.
- ※ We also manufacture custom-sized products upon request.

2. External View



3. Specifications

Nominal	Size (W × H × L × V mm)	Grade AA		Grade A		Range (Φ)	Mass (kg/Set)
		Code No.	Base and V-groove Parallelism	Code No.	Base and V-groove Parallelism		
50	50 × 50 × 50 × 40	JC101	3 μ m	JC201	5 μ m	3~53	1.0
75	75 × 75 × 75 × 60	JC102		JC202		4~80	2.5
100	100 × 100 × 100×80	JC103		JC203		4 ~ 110	5.5
150	150 × 150 × 150×120	JC104		JC204		4 ~ 165	19.0

4. Instructions for Use

【Measurement of cylindrical workpieces (Figure 1)】

Example 1) Place the product on a reference surface plate and position the workpiece in the V-groove. Bring the contact point of a dial gauge into contact with the workpiece to measure parallelism or eccentricity.

Note: When measuring, move the stand with the dial gauge by sliding it on the surface plate.

【Use as a Parallel Block (Figure2)】

Example 2) Place this product on a reference surface plate with the top surface facing upward. Place the workpiece on top, and use the dial gauge's measuring tip to measure Parallelism and straightness.

Note: During measurement, slide the stand holding the dial gauge smoothly on the surface plate to move it.

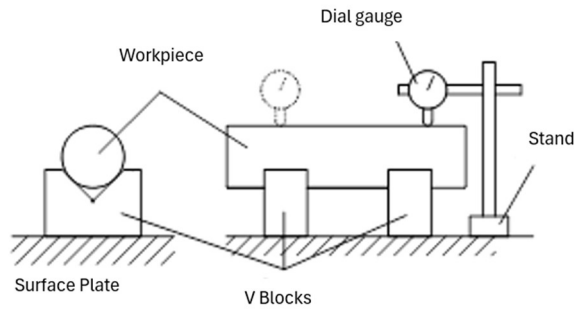


Figure 1

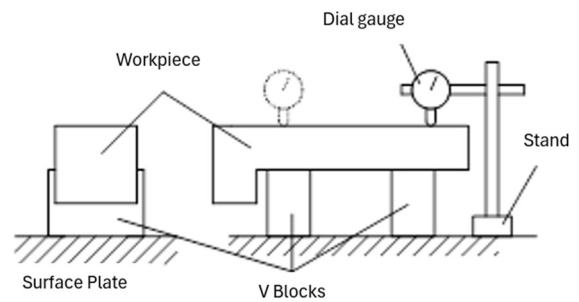


Figure 2

5. Precautions for Use

- ① Before use, please clean the measuring face and the measurement surface of the workpiece.
- ② When using or storing this instrument, handle it carefully to avoid impact or shock.
- ③ Allow the instrument to acclimate to the ambient temperature before use.
- ④ Do not use or store the instrument in places with drastic temperature changes.
- ⑤ After use, be sure to wipe the instrument clean and store it in the storage case.
- ⑥ In the following cases, please check for any abnormalities in the instrument before use.
 - When the instrument has been dropped.
 - When an object has been dropped onto the instrument.
- ⑦ If there are any scratches or damage, repair and inspection are recommended.
- ⑧ Check the accuracy regularly and use the product.
- △ ⑨ If the product has sharp parts, please handle it carefully to avoid injuring your fingers or other parts of your body.
- △ ⑩ Wear protective gloves and safety glasses as necessary to prevent injury while working.
- △ ⑪ Do not use this product if it is damaged or deteriorated, as it may cause injury or accidents.
- △ ⑫ If an injury occurs, provide first aid immediately and consult a physician if necessary.

Contact Information

JIS Certified Factory



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Head Office and Factory

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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).