Accusize Industrial Tools S916-C001

Accusize Industrial Tools S916-C001 12-Piece Replacement Anvil Set

Instruction Manual

1. Introduction

This manual provides essential information for the proper use and maintenance of the Accusize Industrial Tools S916-C001 12-Piece Replacement Anvil Set. This set is designed for accurate measurement of internal and external thread pitch diameters when used with compatible Accusize screw thread micrometers. Adherence to these instructions will ensure optimal performance and longevity of the anvils.

2. Package Contents

The Accusize S916-C001 Replacement Anvil Set includes 12 anvils, provided in pairs, covering the following imperial thread pitch ranges:

- One pair for 64–48 TPI
- One pair for 44–28 TPI
- One pair for 24–14 TPI
- One pair for 13–9 TPI
- One pair for 8–5 TPI
- One pair for 4.5–3.5 TPI



Accusize S916-C001 12-Piece Replacement Anvil Set, showing all twelve anvils with their 60-degree V-profile.



Close-up view of the Accusize S916-C001 anvils, displaying their TPI (Threads Per Inch) range markings.

3. Specifications

Feature	Detail
Model Number	S916-C001
Anvil Quantity	12 pieces (6 pairs)
Thread Pitch Ranges (TPI)	64–48, 44–28, 24–14, 13–9, 8–5, 4.5–3.5
Anvil Profile	60° V-shape
Compatibility	Accusize screw thread micrometers (S916-C861, S916-C862, S916-C863, S916-C750, S916-C751, S916-C752, S916-C753, S916-C754, S916-C755)
Material	Hardened and precision ground steel

Feature	Detail
Product Dimensions	4.21 x 0.98 x 0.98 inches
Item Weight	1.76 ounces



Accusize S916-C001 anvil shown next to a Canadian 25-cent coin for size comparison.

4. Setup and Installation

These anvils are designed for quick and secure replacement in compatible Accusize screw thread micrometers. Follow these steps for proper installation:

1. **Select the Correct Anvil Pair:** Identify the appropriate anvil pair from the set that matches the TPI range of the thread you intend to measure. Each anvil is marked with its corresponding TPI range.
2. **Prepare the Micrometer:** Ensure your screw thread micrometer is clean and free of debris. If replacing existing anvils, carefully remove them according to your micrometer's instructions.
3. **Install the Anvils:** Gently insert the selected anvil pair into the micrometer's measuring faces. Ensure they are seated correctly and securely. The 60° V-profile should align properly to engage with the thread form.
4. **Verify Seating:** After installation, lightly close the micrometer to confirm that the anvils meet squarely and without obstruction. Do not overtighten.

Proper installation is crucial for accurate measurements and to prevent damage to the anvils or the micrometer.



Detailed view of a pair of Accusize S916-C001 anvils, illustrating the internal and external thread measurement profiles.

5. Operating Instructions

Once the correct anvils are installed in your screw thread micrometer, you can proceed with measuring thread pitch diameters. These anvils are designed for imperial thread systems (TPI) and feature a 60° V-shape profile to match standard thread angles.

1. **Clean the Workpiece:** Ensure the thread to be measured is clean and free of oil, chips, or burrs.
2. **Zero the Micrometer:** With the anvils installed, close the micrometer gently and zero it according to your micrometer's specific instructions.
3. **Position the Anvils:** For external threads, position the thread between the V-shaped anvil and the conical spindle. For internal threads, use the appropriate internal thread anvils. Ensure the anvils engage correctly with the thread flanks.
4. **Take the Measurement:** Slowly close the micrometer until the anvils make firm contact with the thread. Read the measurement from the micrometer's scale.
5. **Repeat Measurements:** For critical applications, take multiple measurements at different points along the thread to ensure consistency and accuracy.

These anvils are suitable for use in various precision machining environments, including lathes, inspection benches, and quality control stations.



Another detailed view of a pair of Accusize S916-C001 anvils, showing the distinct shapes for different thread pitches.

6. Maintenance

Proper maintenance ensures the accuracy and longevity of your Accusize replacement anvils.

- **Cleaning:** After each use, wipe the anvils with a clean, lint-free cloth to remove any dust, oil, or debris. For stubborn residue, a mild cleaning solution suitable for precision tools can be used, followed by thorough drying.
- **Storage:** Store the anvils in their protective case when not in use. This prevents damage from impacts, scratches, and environmental factors. Keep them in a dry, temperature-controlled environment.
- **Inspection:** Regularly inspect the anvils for signs of wear, chipping, or damage to the measuring surfaces. Even minor damage can affect measurement accuracy. Replace any damaged anvils immediately.
- **Lubrication:** No lubrication is required for the anvils themselves, but ensure the micrometer's spindle and thimble mechanisms are properly maintained according to its own manual.

7. Troubleshooting

If you encounter issues with measurements or anvil performance, consider the following:

- **Inaccurate Readings:**
  - Ensure the correct TPI range anvil pair is selected for the thread being measured.
  - Verify that the anvils are clean and free of debris.
  - Check for any visible damage or wear on the anvil measuring surfaces.
  - Confirm the micrometer is properly zeroed with the anvils installed.
  - Ensure the workpiece thread is clean and free of burrs.
- **Anvils Not Seating Properly:**
  - Inspect the micrometer's anvil receptacles for any obstructions or damage.
  - Ensure the anvils are inserted fully and correctly.

For persistent issues or if you suspect a defect, please contact Accusize Industrial Tools customer support.

8. Warranty and Support

Accusize Industrial Tools stands behind the quality of its products. For specific warranty information regarding the S916-C001 Replacement Anvil Set, please refer to the documentation included with your purchase or visit the official Accusize Industrial Tools website. For technical support, replacement parts, or any inquiries, please contact Accusize Industrial Tools directly through their official channels.
Manufacturer: Accusize Co., Ltd.

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