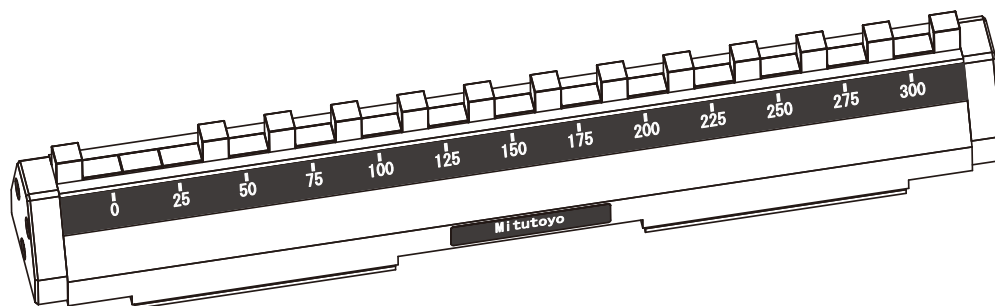


Reference Instrument for Inside Micrometers CERA Inside Micro Checker

CI-300C

CI-600C



User's Manual - Instructions for use -

Read this document thoroughly before
operating the product. After reading, retain it
close at hand for future reference.
This English language version of the document
contains the original instructions.

- For the reading order of the related User's Manuals,
see "■ Positioning of this document" on page 2.

No. 99MBF609B
Date of publication: June 1, 2025 (1)



■ Product names and model numbers covered in this document

Product name	Model number
CERA Inside Micro Checker	CI-300C CI-600C

■ Notice regarding this document

- Mitutoyo Corporation assumes no responsibilities for any damage to the product, caused by its use not conforming to the procedure described in this document.
- Upon loan or transfer of this product, be sure to attach this document to the product.
- In the event of loss or damage to this document, immediately contact the agent where you purchased the product or a Mitutoyo sales office (📖 "SERVICE NETWORK" on page App-1).
- Read this document thoroughly before operating the product. In particular, be sure to fully understand "Safety Precautions" on page 5 and "Precautions for Use" on page 5.
- The contents of this document are based on information current as of June 2025.
- No part or whole of this document may be transmitted or reproduced by any means without prior written permission of Mitutoyo Corporation.
- Some figures in this document may be highlighted, simplified or partially omitted for convenience of explanation. In addition, some of them may differ from actual ones to the extent that no user will misunderstand the functions and operations.
- Acrobat Reader is recommended for viewing PDF user's manuals.
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About This Document

■ Positioning of this document

This describes the positioning of this document and its relationship with other installments.

CERA Inside Micro Checker
User's Manual (This document)

Provides an overview of this product as well as a description of how to use the product and perform maintenance.

Inside Micrometer User's Manual

Provides a description of how to operate the measuring instrument on which this product is to be used to perform a zero-point check.
Inside micrometers of the following series are not subject to zero-point checking.
IMJ-MJ, IMZ, IMZ-M, IMZ-MJ, and IMS

Gauge Block / CERA Block
User's Manual

Provides a description of how to use gauge blocks and CERA blocks as well as of the execution of maintenance, periodic calibrations, and inspections.

■ Intended readers of this document

This document is intended for operators who have already operated an inside-micrometer.
They are also assumed to be able to understand inspection procedure of measuring instruments.

Conventions Used in This Document

■ Safety reminder conventions warning against potential hazards

	Indicates a hazard with a high level of risk which, if not avoided, will result in death or serious injury .
	Indicates a hazard with a low level of risk which, if not avoided, could result in minor or moderate injury .
	Indicates a situation which, if not avoided, may result in property damage .
	Flammable material Alerts the user to a specific hazardous situation that means "Caution, risk of igniting gas".

■ Conventions indicating prohibited and mandatory actions

	Indicates concrete information about prohibited actions.
	Indicates concrete information about mandatory actions.

■ Conventions indicating referential information or reference location

IMPORTANT	Indicates information that must be known when using the product.
Tips	Indicates further information and details relevant for the operating methods and procedures that are explained in that section.
	Indicates reference location if there is information that should be referred to in this document or an extraneous User's Manual. Example: For details about XX, see  "1.2 Name of Each Part" on page 11.

■ Other conventions

(): Round brackets	Represent a paraphrase of an immediately preceding phrase or a supplementary explanation.
" ": Double quotation marks	Represent a highlighted phrase. They also indicate an index where information to be referenced is described.
1, 2, 3...	Indicates the order and the contents of tasks.

■ Example of conventions use

Important information

Supplementary information

Indicates an alert.

Indicates an alert.

Indicates an operating procedure to be performed or its outline.

A "»" mark at the beginning of a sentence indicates the result of an operation.

X Operation

X Operation

X.X Precautions for Use

X.X.X Connecting the Power Cable

Mitutoyo service personnel or the agent where you purchased the product will connect the power cable at the installation of the main unit.

IMPORTANT

Use only the power cable that is supplied with this product.

Tips

In case of emergency or for maintenance purposes, after unplugging the power cable from the AC inlet, plug it in again.

X.X.X Mounting the Probe

Mount the probe onto the probe head by "auto joint connection". This section explains connection procedure.

CAUTION

There is a risk of injury due to accidents that accompany the movements of the probe.

!

Turn off the main unit before mounting the probe.

NOTICE

There is a risk of damage to this product due to the instability of input signals.

!

Turn off the main unit before mounting the probe even if the input signals are disabled.

1 Make sure that the keyway on the rear of the probe is set to the unlock position.

2 Align the marks on the probe head and the probe.

3 Using the accessory tool, turn the keyway on the rear of the probe to the lock position.

» The probe mounting is completed.

X Operation

Safety Precautions

Read these "Safety Precautions" thoroughly before operating the product to use it properly. These safety precautions include such information as to prevent injury to the operator and other persons, damage to property and product defects. Be sure to observe these precautions carefully.

DANGER



Organic solvents such as diluents and benzine spirits may catch fire either due to being ignited or due to combusting spontaneously. Inhaling them also poses a risk of poisoning.



Do not use organic solvents such as diluents or benzine spirits.

CAUTION

Handling this product or its optional accessories improperly during transport poses a risk of injuries.



Falling or toppling of the product may lead to injuries. Handle with care.

Precautions for Use

■ Use and handling of the product

- This product is an instrument that is used for checking the zero-point of inside micrometers. Do not use this product for purposes other than for zero-point checking.
- The product is a precision instrument.
Handle with sufficient care. During the unpacking, installation, operation, and storage of this product, take sufficient care that its parts do not sustain any shocks and that no excessive force is applied. If this product sustains any shocks, its measuring accuracy may become impaired.

■ Environment for operation

Use the product in the following places.

- Where there is minimal dust and grit
- Where there are minimal vibrations
- An environment that varies minimally from the recommended temperature of 20 °C
- An environment in which the humidity is low (70% or less)

Do not use or store the product in the following places where the temperature and humidity drastically fluctuate.

The product's functions and measurement results will be adversely affected and it will cause malfunction.

- An environment that directly receives the influence of cutting fluid, water, etc.
- An environment that directly receives sunlight as well as both hot and cold airflows (such as those from an air conditioner)

■ Transport

Before transporting this product, apply corrosion protective lubricant to the spacing blocks (☞ "1.2 Name of Each Part" on page 11), and wrap a piece of corrosion protective packaging paper and a plastic packaging sheet around the product. After that, the product is to be packed into the cardboard box that is used for shipping. For that reason, the packing materials are to be securely stored and re-used. However, please contact the agent where you purchased the product or a Mitutoyo sales office (☞ "SERVICE NETWORK" on page App-1) if you require the delivery of additional packing materials.

■ Disassembly and modification

This product is adjusted precisely during its assembly.

Performing disassembly, modification, or any adjustments other than those described in this document will affect the measuring accuracy and functions of this product. Therefore, please refrain from doing so. Doing so will void the warranty.

■ About daily care

After each use, remove any adhering particles such as dust by blowing them away with clean air, and then wipe off any grime by using a soft, lint-free cloth that has been moistened with a solvent. After that, apply liquid-type corrosion protective lubricant in a thin layer to the spacing blocks (to prevent rusting). Do not use organic solvents such as diluents or benzine spirits.

Recommended solvent: Normal heptane

Recommended liquid-type corrosion protective lubricant: MOLYKOTE® Supergliss

For details, see ☞ "4 Maintenance" on page 19.

Export Control Compliance

This product falls into the Catch-All-Controlled Goods and/or Catch-All-Controlled Technologies (including Programs) under Category 16 of Appended Table 1 of Export Trade Control Order or under Category 16 of Appended Table of Foreign Exchange Control Order, based on Foreign Exchange and Foreign Trade Act of Japan.

If you intend re-export of the product from a country other than Japan, re-sale of the product in a country other than Japan, or re-providing of the technology (including Programs), you shall observe the regulations of your country.

Also, if an option is added or modified to add a function to this product, this product may fall under the category of List-Control Goods, List-Control Technology (including Programs) under Category 1 - 15 of Appended Table 1 of Export Trade Control Order or under Category 1 - 15 of Appended Table of Foreign Exchange Control Order, based on Foreign Exchange and Foreign Trade Act of Japan. In that case, if you intend re-export of the product from a country other than Japan, re-sale of the product in a country other than Japan, or re-providing of the technology (including Programs), you shall observe the regulations of your country. Please contact Mitutoyo in advance.

Notes on Export to European Countries

When you intend exporting of this product to any of the European countries, it may be required to provide User's Manual(s) in English and Declaration of Conformity in English (in some cases, the official language of the country to be exported).

For detailed information, please contact Mitutoyo in advance.

Disposal of Products outside the European Countries

Please follow the official instruction in each community and country.

Warranty

This product has been manufactured under strict quality management, but should it develop problems within one year of the date of purchase in normal use, repair shall be performed free of charge. Please contact the agent where you purchased the product or Mitutoyo sales representative (図 "SERVICE NETWORK" on page App-1).

If this product fails or is damaged for any of the following reasons, it will be subject to a repair charge, even if it is still under warranty.

- Failure or damage owing to fair wear and tear
- Failure or damage owing to inappropriate handling, maintenance or repair, or to unauthorized modification
- Failure or damage owing to transport, dropping, or relocation of the product after purchase
- Failure or damage owing to fire, salt, gas, abnormal voltage, lightning surge, or natural disaster
- Failure or damage owing to use in ultra-hazardous activities

This warranty is effective only where the product is properly installed and operated in conformance with the instructions in this document within the original country of the installation.

EXCEPT AS SPECIFIED IN THIS WARRANTY, ALL EXPRESS OR IMPLIED CONDITIONS, REPRESENTATIONS, AND WARRANTIES OF ANY NATURE WHATSOEVER INCLUDING, WITHOUT LIMITATION, ANY IMPLIED WARRANTY OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, NONINFRINGEMENT OR WARRANTY ARISING FROM A COURSE OF DEALING, USAGE, OR TRADE PRACTICE, ARE HEREBY EXCLUDED TO THE MAXIMUM EXTENT ALLOWED BY APPLICABLE LAW.

You assume responsibility for all results due to the selection of this product to achieve your intended results.

Disclaimer

IN NO EVENT WILL MITUTOYO, ITS AFFILIATED AND RELATED COMPANIES AND SUPPLIERS BE LIABLE FOR ANY LOST REVENUE, PROFIT, OR DATA, OR FOR SPECIAL, DIRECT, INDIRECT, CONSEQUENTIAL, INCIDENTAL, OR PUNITIVE DAMAGES HOWEVER CAUSED AND REGARDLESS OF THE THEORY OF LIABILITY ARISING OUT OF THE USE OF OR INABILITY TO USE THIS PRODUCT EVEN IF MITUTOYO OR ITS AFFILIATED AND RELATED COMPANIES AND/OR SUPPLIERS HAVE BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

If, notwithstanding the foregoing, Mitutoyo is found to be liable to you for any damage or loss which arises out of or is in any way connected with use of this product by you, in no event shall Mitutoyo's and/or its affiliated and related companies' and suppliers' liability to you, whether in contract, tort (including negligence), or otherwise, exceed the price paid by you for the product only.

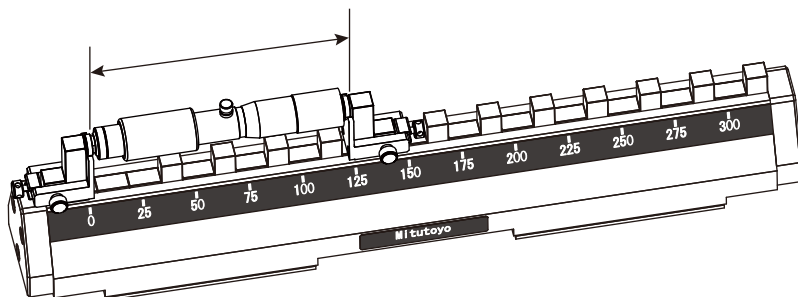
The foregoing limitations shall apply even if the above-stated warranty fails of its essential purpose. BECAUSE SOME COUNTRIES, STATES OR JURISDICTIONS DO NOT ALLOW THE EXCLUSION OR THE LIMITATION OF LIABILITY FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES, IN SUCH COUNTRIES, STATES OR JURISDICTIONS, MITUTOYO'S LIABILITY SHALL BE LIMITED TO THE EXTENT PERMITTED BY LAW.

1 Overview

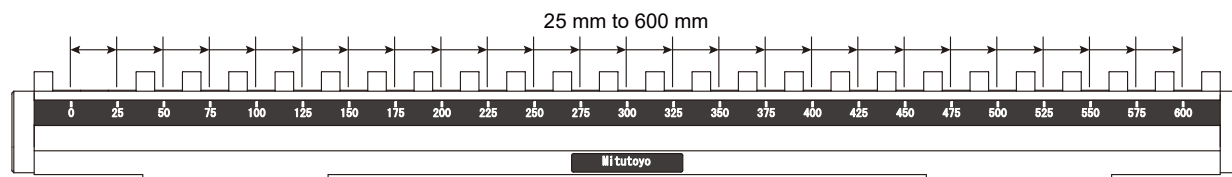
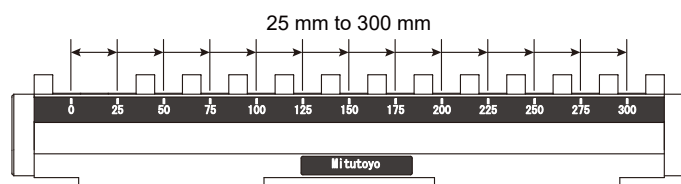
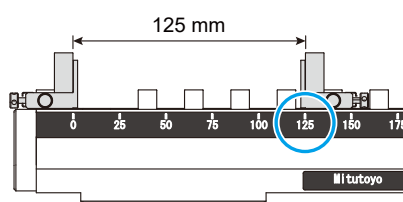
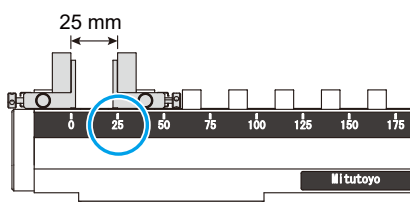
1.1 Features

This product is a precision instrument that is used to check the zero-point of inside micrometers*.

* Only inside micrometers that have an anvil diameter of $\varnothing 8$ mm are testable (excluding three-point inside micrometers).

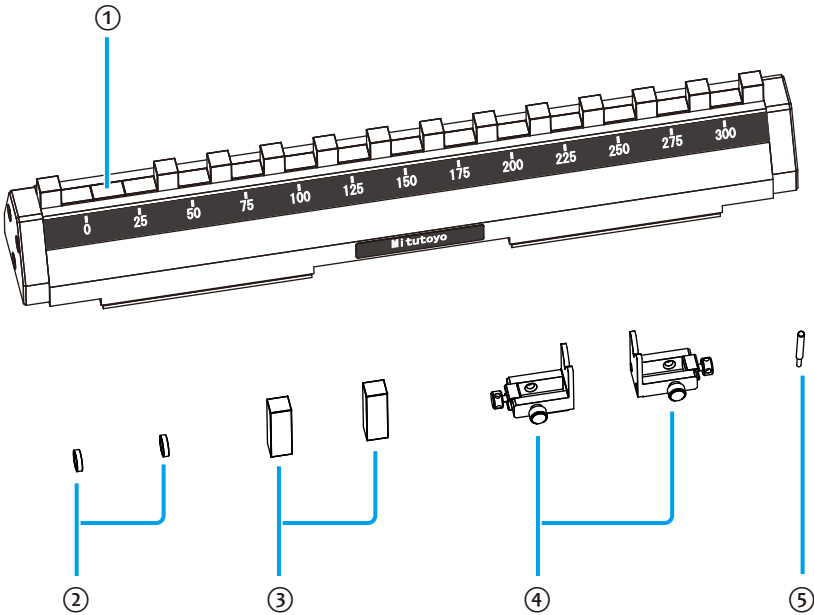


The graduations marked on this product indicate the distance between the auxiliary blocks that are attached to the product.



1.1.1 Included Components

The following components are included with the CERA Inside Micro Checker.



No.	Name
①	CERA inside micrometer checker main unit
②	Collar
③	Auxiliary block (ceramic)
④	Support clamp
⑤	Clamp screwdriver

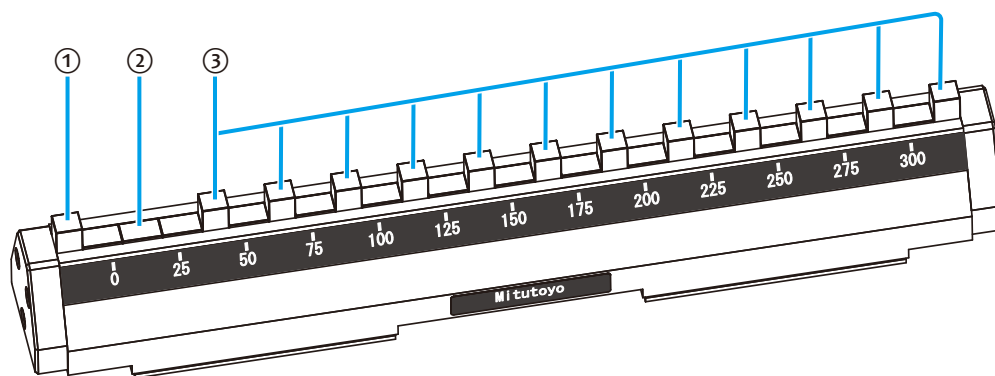
IMPORTANT

The original packaging box can be reused as packaging material for transporting this product. Please store it in a safe place.

Take special care not to lose the spacers that are in the cardboard packing box.



1.2 Name of Each Part



No.	Name
①	Zero-point block (ceramic)
②	Spacing block (steel)
③	Dimension-setting block (ceramic)

MEMO

2 Setup

2.1 Preparation 14

2.2 Attaching the Auxiliary Blocks and the Support Clamp 15

2.1 Preparation

- 1 Remove any particles such as dust adhering to this product by blowing them away with clean air.
- 2 If burrs have been found on the zero-point block, a dimension-measuring block, or an auxiliary block, remove them by using a Ceraston (optional accessory).

IMPORTANT

- Applying too much force to the Ceraston may affect the dimensions of the block. Be careful not to dent or scratch the surfaces of the block.
- In cases where it is not possible to eliminate the burrs found on the zero-point block or dimension-measuring block, a repair is required. Please contact the agent where you purchased the product or a Mitutoyo sales office (☎ "SERVICE NETWORK" on page App-1).

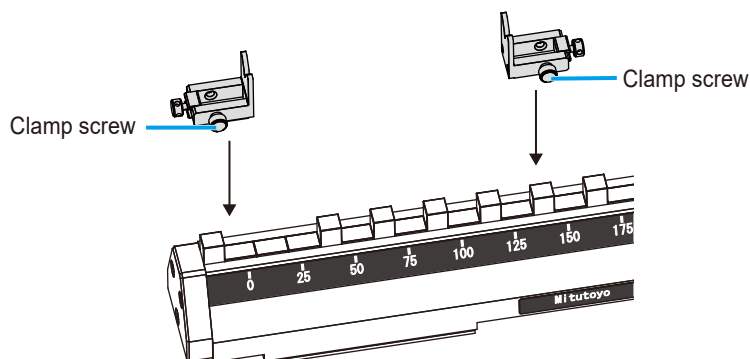
- 3 Allow enough time for this product and the inside micrometer to acclimate to room temperature.

2.2 Attaching the Auxiliary Blocks and the Support Clamp

IMPORTANT

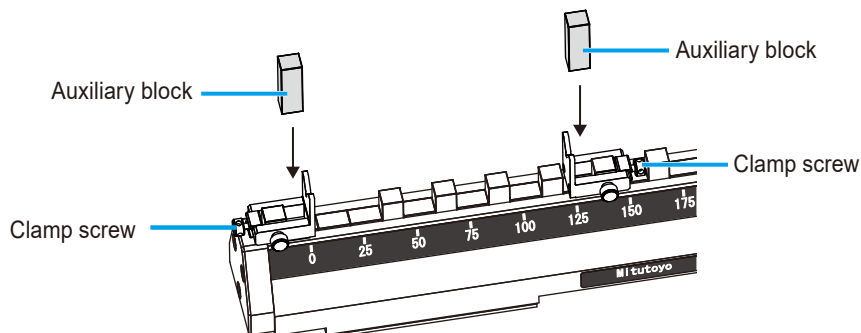
A six-digit number is engraved on one side of each support clamp (two pieces). Always use a pair of support clamps that are engraved with the same number. Using support clamps that are engraved with different numbers may lead to measurement errors.

- 1 Insert the support clamps so that their clamp screws face toward you.



- 2 Insert the auxiliary blocks.

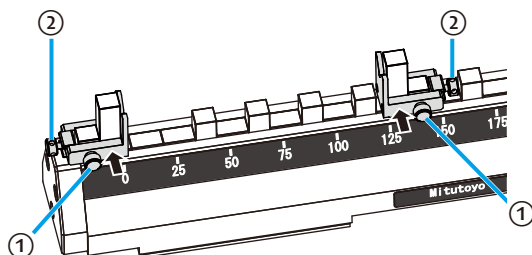
If the insertion spaces are too narrow, adjust them by rotating the clamp screws.



- 3 While using your fingers to gently push the support clamps in the direction indicated by the arrows, lightly tighten the clamp screws (①).

IMPORTANT

Do not overtighten the clamp screws (①). Otherwise, the zero-point block or dimension-setting block may become deformed.



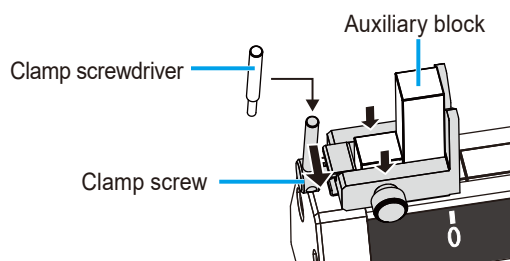
Tips

At this stage, the clamp screws (②) are left loose.

- 4** While using your fingers to hold down the left-side support clamp and right-side support clamp one at a time, firmly tighten the clamp screw with the clamp screwdriver.

IMPORTANT

- If there is a gap between the bottom surface of each support clamp and the top surface of the spacing block, it will not be possible to obtain the correct dimensions. Be sure to use your fingers to hold down the support clamp.
- Firmly tighten the clamp screws. If the screws have not been tightened firmly enough, the auxiliary blocks will tilt during measurement and thereby cause significant measurement errors.
- While tightening the clamp screws, be careful not to break the clamp screwdriver.

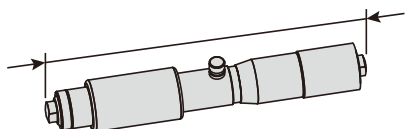


This figure shows the left-side support clamp.
Perform the same work on the right-side support clamp.

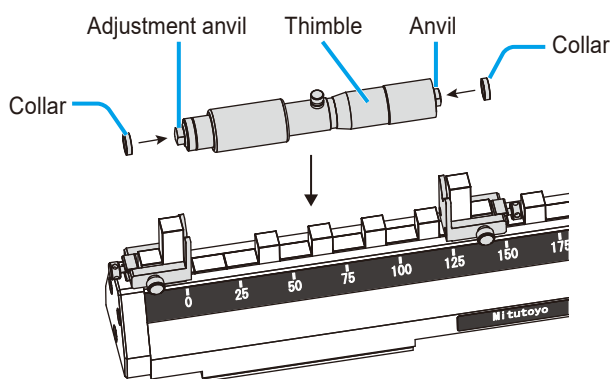
3 Checking the Zero-Point of the Inside Micrometer

In this chapter, an inside micrometer with a measurement range of 125 mm to 150 mm is used as an example.

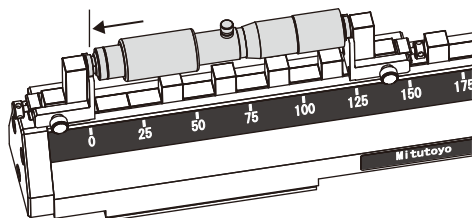
- 1 Adjust the inside micrometer main unit so that its length becomes approximately 0.5 mm shorter than the zero-point setting dimension.



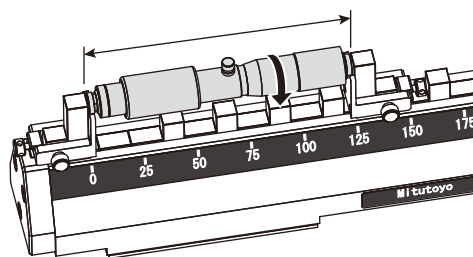
- 2 Attach one collar piece to the adjustment anvil and to the anvil on the thimble side, and then place the inside micrometer on the support clamps.



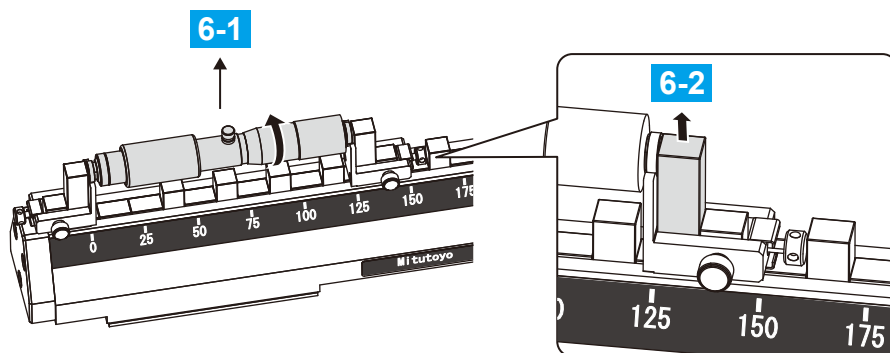
- 3 Bring the measurement surface of the adjustment anvil into contact with the auxiliary block by moving the inside micrometer in the direction indicated by the arrow.



- 4 Rotate the thimble until the measurement surface of the anvil on the thimble side comes into contact with the auxiliary block, and then check the reading on the inside micrometer.



- 5 Calculate the difference (zero-point error) between the graduation mark on this product (125 mm) and the reading on the inside micrometer.
- 6 Decrease the length of the inside micrometer by approximately 0.5 mm and remove it, then remove the left and right auxiliary blocks.



IMPORTANT

If the zero-point error is large, the inside micrometer is in need of adjustment.
For details about how to make adjustments, see  the user's manual for each inside micrometer.

4 Maintenance

This chapter describes the daily inspection and storage of this product.

In order to obtain optimum performance and to ensure safe use of this product over an extended period of time, please observe the following guidelines when performing maintenance.

CAUTION

Handling this product improperly during transport poses a risk of injuries.



Falling or toppling of the product may lead to injuries. Handle with care.

■ Daily inspection

Check for the presence of any grime or parts defects.

If the product is dirty, clean it. If any parts defects are found, they must be repaired. Please contact the agent where you purchased the product or a Mitutoyo sales office (📖 "SERVICE NETWORK" on page App-1).

■ Cleaning

After each use, remove any adhering particles such as dust by blowing them away with clean air, and then wipe off any grime such as oil stains by using a lint-free cloth that has been moistened with a solvent such as absolute alcohol.

Due to the risk that the air-spray guns furnished in the factory may have been contaminated with oil or the like, they are not to be used.

DANGER



Organic solvents such as diluents and benzine spirits may catch fire either due to being ignited or due to combusting spontaneously. Inhaling them also poses a risk of poisoning.



Do not use organic solvents such as diluents or benzine spirits.

NOTICE

Do not use detergents or organic solvents such as diluents or benzine spirits because they will adversely affect product quality and cause damage to the product.

■ Storage

After cleaning, apply corrosion protective lubricant to the spacing blocks, and then wrap a piece of anti-corrosion packaging paper and a plastic packaging sheet around the product. After that, the product is to be stored in the cardboard box that is used for shipping. (This is the same as the procedure for long-term storage.)

IMPORTANT

Store the product in an environment with a constant temperature and humidity, and avoid any environments where there are drastic changes in temperature or humidity.

Tips

The zero-point block and dimension-setting blocks are ceramic parts, so they do not require anti-rust treatment.

■ Calibration and repair

When consigning this product for calibration or repair, pack it in the cardboard box that is used for shipping along with cushioning materials. After that, please contact the agent where you purchased the product or a Mitutoyo sales office (☞ "SERVICE NETWORK" on page App-1).

■ Repacking

When repacking this product, follow the procedure below.

- 1** Wrap a piece of anti-corrosive packaging paper and plastic packaging sheet around the product and then tie a loop of fabric onto it.



- 2** Hold the packaged product by the loop of fabric and pack it into the cardboard packing box.



- 3** Check that the spacer has not deviated from its position in the cardboard packing box.



4 Set the cushioning materials.**5** Set the top inner cover.**6** Seal the cardboard packing box.

MEMO

5 Specifications

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5.3 Standard Accessories	25
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5.5 Warranty Card	25

5.1 Specifications

Code No.	515-585	515-586
Model number	CI-300C	CI-600C
Measurement range	25 mm to 300 mm	25 mm to 600 mm
Block pitch accuracy	$\pm \left(1 + \frac{L}{150} \right) \mu\text{m}$ L: Length to check (mm)	
Mass	3.9 kg	7.0 kg
Environment for operation	Temperature: 5 °C to 40 °C	
Environment for storage	Temperature: -10 °C to 60 °C	

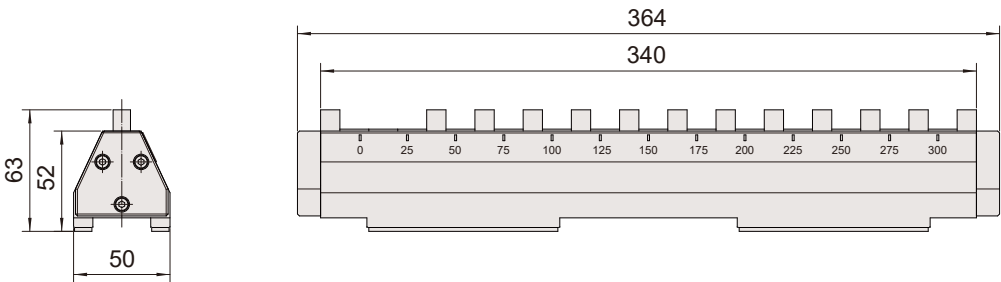
IMPORTANT

The perpendicularity between the bottom surface and the measurement surface is not specified.

5.2 External Dimensions

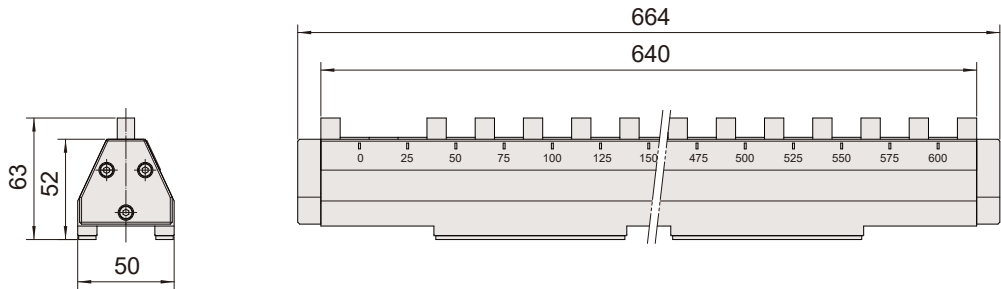
● CI-300C

Unit: mm



● CI-600C

Unit: mm



5.3 Standard Accessories

Part No.	Part name	Qty.	Remarks
613671-022	Auxiliary block	2	CERA block (10 mm)
940286	Support clamp	One pair (2 pcs.)	
602195	Collar	2	For ø8
600324	Clamp screwdriver	1	
99MBF609B	User's Manual (this document)	1	
-	Certificate of inspection	1	

5.4 Optional Accessories

Part No. / Code No.	Part name
602160	Wooden box (for CI-300C)
602163	Wooden box (for CI-600C)

5.5 Warranty Card

		Mitutoyo Corporation 20-1, Sakado 1-chome, Takatsu-ku, Kawasaki-shi, Kanagawa 213-8533, Japan Phone (044) 813-8230	
ONE YEAR WARRANTY			
Product Name		Code No.	
Serial No.		Date Purchased	
Mitutoyo Corporation conducts an own Quality management system based on the requirements of ISO 9001. This product conforms to the Mitutoyo inspection standard, and the standard (s) used for the calibration is /are traceable to the national standard (s). In the event that this product should fail within one (1) year from the original date of purchase through normal use conforming to the User's Manual provided with the product and Warning Label(s) on the product, we will repair or replace at our option, free of charge, upon its prepaid return to Mitutoyo with this WARRANTY card. ※Purchaser is requested to fill the blank above and retain the warranty card at hand. Return card only when requesting Warranty Service.  Quality Assurance Department T. Narumi Manager This warranty shall not apply if the product and consumables have been subject to fair wear and tear, abuse through misuse or improper use/handling/storage/maintenance/service/repair or through adaptation/modification by the original purchase or any third party without prior written consent of Mitutoyo or as a result of damage by an actual disaster or circumstances beyond the control of Mitutoyo. To obtain service under this warranty the product must be returned to the store/dealer you purchased from along with the warranty card. Any postage, insurance, or shipping charges incurred in returning the product for service are the responsibility of the purchaser. ※This warranty is not transferable and is only valid within the country of the original purchase. ※You may have additional rights under the laws of country of original purchase that do not allow the exclusion of implied warranties of the exclusion or limitation of certain damages. If these laws apply, Mitutoyo's limitations and exclusions may not apply to you.			

SERVICE NETWORK

*As of February 2025

Europe

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Borsigstrasse 8-10, 41469 Neuss, GERMANY
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Mitutoyo CTL Germany GmbH

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TEL: 49 (0)7423 8776-0 FAX: 49 (0)7423 8776-99

KOMEG Industrielle Messtechnik GmbH

Zum Wasserwerk 3, 66333 Völklingen, GERMANY
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Germany

Mitutoyo Deutschland GmbH

Borsigstrasse 8-10, 41469 Neuss, GERMANY
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M³ Solution Center Hamburg

Tempowerkring 9-im HIT-Technologiepark 21079
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M³ Solution Center Berlin

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M³ Solution Center Eisenach

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