

Complete the text with the correct words from the table below.

**VERNIER CALLIPERS** [ˈvɜniə ˈkæləpə(r)z]

To .....<sup>1</sup> sizes to a tolerance of less than 1 mm, you need to use a .....<sup>2</sup> device which measures reliably and which can measure fractions of a millimetre, such as 1/10 or 1/20 mm.

A measuring device which fulfils this .....<sup>3</sup> is the vernier calliper. The two .....<sup>4</sup> of the vernier calliper measure much more accurately than a ruler or a tape. The vernier calliper is particularly suitable for measuring .....<sup>5</sup>.

Using the vernier, it is .....<sup>6</sup> to divide millimetres so they can be read to 1/10<sup>th</sup> or 1/20<sup>th</sup> of a millimetre.

The vernier is seen on the .....<sup>7</sup> arm of the vernier calliper. Its scale is .....<sup>8</sup> into equal parts. When the zero line on the vernier is in line with a line on the main scale, the .....<sup>9</sup> between the measuring arms is in whole millimetres. When the moving arm is moved 1/10 mm, the zero line of the vernier is in line with a line of the main scale.

By using the vernier calliper, you can measure to .....<sup>10</sup> of a millimetre. Every vernier calliper has a .....<sup>11</sup> or a retainer to fix the moveable .....<sup>12</sup> if necessary. A depth probe may be attached to the moveable head.

Vernier callipers can also be used to measure inside diameters or the .....<sup>13</sup> of a hole. Inside diameters are measured with the help of internal .....<sup>14</sup> that can be found at the top of the .....<sup>15</sup> arm and the moving arm.

1	a) <b>measure</b> b) measurement c) measuring	2	a) measure b) measured c) <b>measuring</b>	3	a) require b) <b>requirement</b> c) required
4	a) legs b) <b>arms</b> c) fingers	5	a) radiuses b) circumferences c) <b>diameters</b>	6	a) possibility b) <b>possible</b> c) impossible
7	a) move b) movement c) <b>moving</b>	8	a) <b>divided</b> b) division c) divide	9	a) space b) <b>distance</b> c) area
10	a) thousandths b) <b>tenths</b> c) hundredths	11	a) screwing lock b) screwed lock c) <b>locking screw</b>	12	a) neck b) shoulder c) <b>head</b>
13	a) <b>depth</b> b) width c) length	14	a) teeth b) lips c) <b>jaws</b>	15	a) fixing b) fix c) <b>fixed</b>