PRODUCT RANGE

55-200-018	Dial Bore Gauge 10-18mm
55-200-035	Dial Bore Gauge 18-35mm
55-200-050	Dial Bore Gauge 35-50mm
55-200-150	Dial Bore Gauge 50-150mm
55-200-007	Dial Bore Gauge 0.4″-0.7″
55-200-015	Dial Bore Gauge 0.7″-1.5″
55-200-024	Dial Bore Gauge 1.4″-2.4″
55-200-006	Dial Bore Gauge 2″-6″

Dial Bore Gauges provide a two point contact system for comparative measurement of component holes and will also detect ovality and tapers in bores. These instruments are fitted with independent spring loaded centralising mechanisms, which ensure the measurement is taken across the true diameter of the component. All instruments are supplied in boxes complete with probes and extensions as listed.

GENERAL SPECIFICATION

				Dial Indicator Specification			
Product Code	Range	Stem Length	Overall Length	Dial Dia	Grads	Reading	Travel
55-200-018	10-18mm	110mm	260mm	40mm	0.01mm	0-50	3mm
55-200-035	18-35mm	140mm	290mm	57mm	0.01mm	0-100	3mm
55-200-050	35-50mm	150mm	340mm	57mm	0.01mm	0-100	3mm
55-200-150	50-150mm	150mm	340mm	57mm	0.01mm	0-100	3mm
55-200-007	0.4″-0.7″	4-1/4″	11″	2-1/4″	0.0005″	0-25-0	1/4″
55-200-015	0.7″-1.5″	5-1/4″	12″	2-1/4″	0.0005″	0-25-0	1/4″
55-200-024	1.4″-2.4″	6″	13-1/2″	2-1/4″	0.0005″	0-25-0	1/4″
55-200-006	2″-6″	6″	13-1/2″	2-1/4″	0.0005″	0-25-0	1/4″

PROBE DETAILS

Product Code	Range	Probe Type	No. Of Probes	Probe Ranges	Shim	Add Ext
55-200-018	10-18mm	Threaded	9	10, 11, 12, 13, 14, 15, 16, 17, 18mm	0.5	N/A
55-200-035	18-35mm	Threaded	7	18-20.5, 20.5-23, 23-25.5, 25.5-28, 28-30.5, 30.5-33, 33-35mm	N/A	N/A
55-200-050	35-50mm	Threaded	3	35-40, 40-45, 45-50mm	N/A	N/A
55-200-150	50-150mm	Threaded	5	50-62, 62-74, 74-86, 86-98, 98-110mm	N/A	60mm
55-200-007	0.4"-0.7"	Threaded	9	.4, .44, .48, .52, .56, .60, .64, .68, .70"	0.02	N/A
55-200-015	0.7"-1.5"	Threaded	8	.7, .8, .9, .1.0, 1.1, 1.2, 1.3, 1.4"	N/A	N/A
55-200-024	1.4"-2.4"	Plain	6	1.4, 1.6, 1.8, 2.0, 2.2, 2.4"	.1, 0.5, .02	N/A
55-200-006	2"-6"	Plain	11	2, 2.2, 2.4, 2.6, 2.8, 3.0, 3.2, 3.4, 3.6, 3.8, 4.0"	.1, 0.5, .02	2"

SETTING PROCEDURE

Fixed Probe Type

- Remove dial indicator from protective shroud.
- Insert indicator stem into top of bore gauge .
- Position indicator into bore gauge stem with one revolution of dial gauge hand.
- Use knurled thumbscrew on split clamp to clamp indicator.
- Select probe and shim washer to get nearest to required measurement size
  Example:- Measurement size 2.750"
  Select Probe 2.6" shims 0.1 & 0.05 = 2.75
- Fit shim washers behind datum flange on probe
- Remove knurled retaining nut from bore gauge foot and insert probe with shims.
- Replace retaining nut and clamp probe positively.
- At this stage it is necessary to offer the bore gauge to a setting master at the required nominal size. This can be a ring gauge, caged gauge blocks with protruding end faces or a pre-set micrometer.
- Insert bore gauge probes into the ring gauge or between the faces of the setting master.
- Rock bore gauge in ring or between the setting master faces to achieve the reversal point of the dial indicator hand.
- If this does not coincide with the zero on the dial, re position dial gauge down bore gauge stem to achieve this position. The final setting for zero can be made by rotating dial gauge bezel so that the zero coincides exactly with the reversal point of the indicator hand.
- Re check in setting gauge.
- Finally replace protective shroud and clamp firmly to top of bore gauge stem.

Screwed Probe Type

- Remove dial indicator from protective shroud.
- Insert indicator stem into top of bore gauge.
- Position indicator into bore gauge stem with one revolution of dial gauge hand. Use knurled thumbscrew on split clamp to clamp indicator.
- Select a probe with a range which suits the required measurement size.
- Fit knurled lock nut to probe.
- Screw probe into bore gauge foot.
- Select setting master (see previous instructions)
- Insert bore gauge probes between setting master faces and adjust screwed probe to bring dial gauge hand to zero position.
- Rock bore gauge in ring or between the setting master faces to achieve the reversal point of the dial indicator hand.
- Fine adjust dial hand to zero by either adjusting screwed probe, moving dial indicator up or down in bore gauge and finally revolving bezel to obtain final zero.

SETTING PROCEDURE

- Insert pre-set bore gauge into component hole.
- Rock bore gauge in hole.
- Note reversal point of dial gauge hand.
- Add or deduct the variance from zero to the setting master nominal size, to obtain the measured diameter of the component hole.