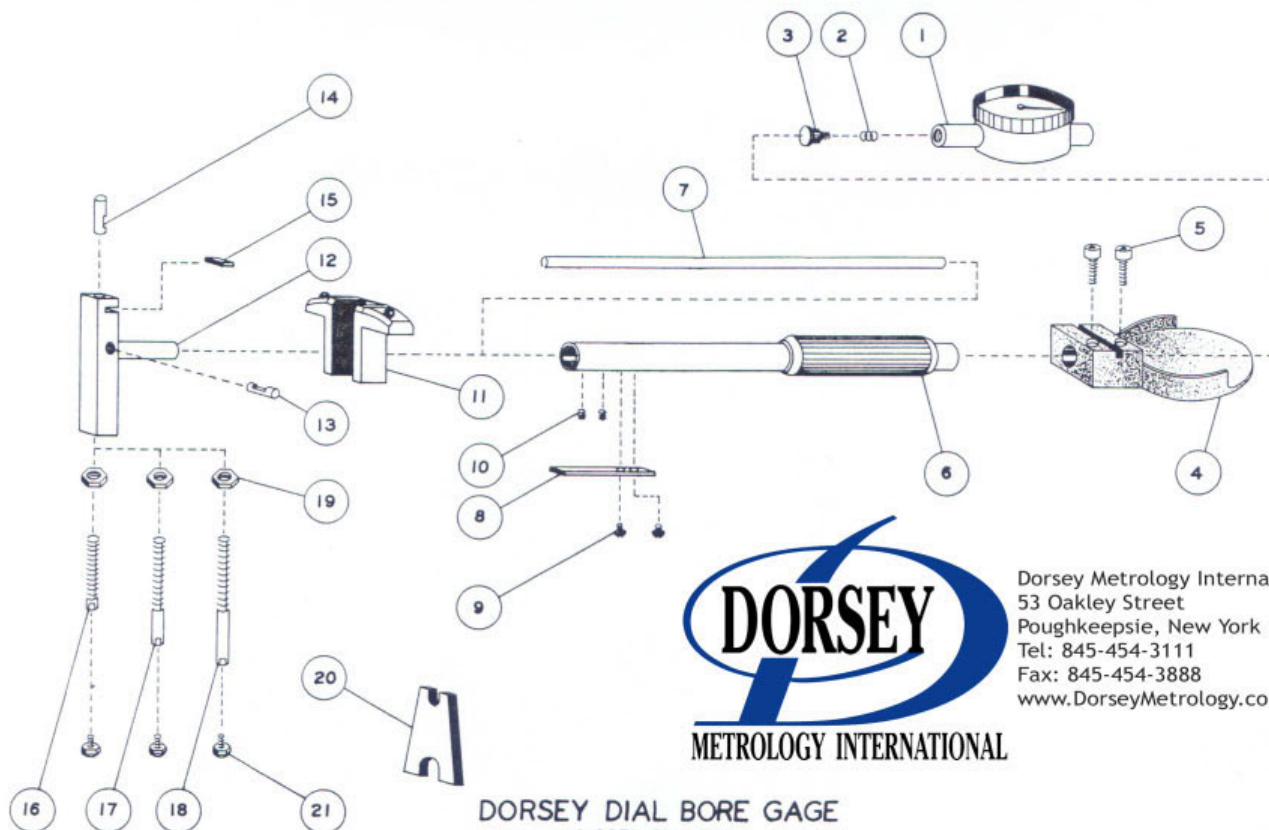




Dorsey Metrology International
53 Oakley Street
Poughkeepsie, New York 12601
Tel: 845-454-3111
Fax: 845-454-3888
www.DorseyMetrology.com

DORSEY DIAL BORE GAGE
MODEL DBL-300
RANGE: 3.00-6.00

ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME
1		.0001 INDICATOR	8	1150	SPRING	15	1322	RETAINER
2	120	INDICATOR SPRING	9	240	SCREW	16	1314-1	RANGE EXTENSION
3	110	INDICATOR CONTACT	10	260	SCREW	17	1314-2	RANGE EXTENSION
4	103	INDICATOR HOUSING	11	1302	CENTRALIZER	18	1314-3	RANGE EXTENSION
5	305	SCREW	12	1310	GAGING HEAD	19	1313	EXTENSION NUT
6	1345	GAGING BODY	13	1120	TRANSFER	20	1360	WRENCH
7	1347	PLUNGER ROD	14	1330	GAGING PIN	21	1315	GAGING CONTACT

DISASSEMBLY

1. LOOSEN TWO (2) SCREWS (DET.5) AND REMOVE INDICATOR HOUSING (DET.4) FROM HOUSING ASSEMBLY (DET.6). REMOVE DIAL INDICATOR (DET.1) FROM INDICATOR HOUSING (DET.4).
2. LOOSEN LOCKNUT (DET.19) WITH WRENCH (DET.20) AND REMOVE RANGE EXTENSION (DET.16,17 OR 18) FROM GAGING HEAD (DET.12).
3. LOOSEN TWO (2) SCREWS (DET.9) AND REMOVE SPRING (DET.8).
4. LOOSEN TWO (2) SCREWS (DET.10) AND DISENGAGE HOUSING ASSEMBLY (DET.6). REMOVE PLUNGER ROD (DET.7).
5. REMOVE CENTRALIZER (DET.11) FROM GAGING HEAD (DET.12).
6. REMOVE RETAINER (DET.15) FROM GAGING HEAD (DET.12). REMOVE GAGING PIN (DET.14) AND GAGING TRANSFER (DET.13).

SETTING

1. INSERT APPROPRIATE RANGE EXTENSION (DET.16,17 OR 18) INTO GAGING HEAD (DET.12) AND ADJUST RANGE EXTENSION TO THE APPROXIMATE DESIRED DIAMETER.
2. INSERT GAGE INTO REFERENCE MASTER (MASTER RING GAGE, BORE GAGE SETMASTER OR GAGE BLOCK SETUP) AND ADJUST RANGE EXTENSION UNTIL DIAL INDICATOR READS ZERO AT FIRST 12 O'CLOCK POSITION. LOCK RANGE EXTENSION IN PLACE WITH LOCKNUT (DET.19).
3. ROCK GAGE FORWARD AND BACK IN REFERENCE MASTER TO INSURE ZERO READING. ADJUST INDICATOR BEZEL TO ZERO IF NECESSARY.
4. REPEAT STEP NO. 3.

Instructions for Dorsey dial bore gage Model DBL-300 Range 3.00-6.00

ASSEMBLY

1. INSERT GAGING PIN (DET.14), GAGING TRANSFER (DET.13) AND RETAINER (DET.15) INTO GAGING HEAD (DET.12).
2. PLACE CENTRALIZER (DET.11) OVER GAGING HEAD (DET.12).
3. INSERT PLUNGER ROD (DET.7) INTO GAGING HEAD (DET.12). PLACE HOUSING ASSEMBLY (DET.6) OVER PLUNGER ROD (DET.7) ONTO GAGING HEAD (DET.12) AND LOCK IN PLACE WITH TWO (2) SCREWS (DET.10).
4. INSERT SPRING (DET.8) AND LOCK IN PLACE WITH TWO (2) SCREWS (DET.9).
5. INSERT DIAL INDICATOR (DET.1) INTO INDICATOR HOUSING (DET.4) AND PLACE ONTO HOUSING ASSEMBLY (DET.6). LOCK IN PLACE WITH TWO (2) SCREWS (DET.5) INSURING PROPER CONTACT OF INDICATOR WITH PLUNGER ROD (DET.7).
6. THREAD LOCKNUT (DET.19) ONTO RANGE EXTENSION (DET.16, 17 OR 18) AND ASSEMBLE EXTENSION TO GAGING HEAD (DET.12).