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DORSEY DIAL BORE GAGE
 MODEL DBL-998
 RANGE: 1.00-1.50

ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME
1		.0001 INDICATOR	8	1150	SPRING	15	1122	RETAINER
2	120	INDICATOR SPRING	9	240	SCREW	16	1114-1	RANGE EXTENSION
3	110	INDICATOR CONTACT	10	260	SCREW	17	1114-2	RANGE EXTENSION
4	103	INDICATOR HOUSING	11	1102	CENTRALIZER	18	1114-3	RANGE EXTENSION
5	305	SCREW	12	1110	GAGING HEAD	19	1113	EXTENSION NUT
6	1145	HOUSING ASSEMBLY	13	1120	TRANSFER	20	1160	WRENCH
7	1147	PLUNGER ROD	14	1130	GAGING PIN			

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-998
 Range 1.00 - 1.50

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).