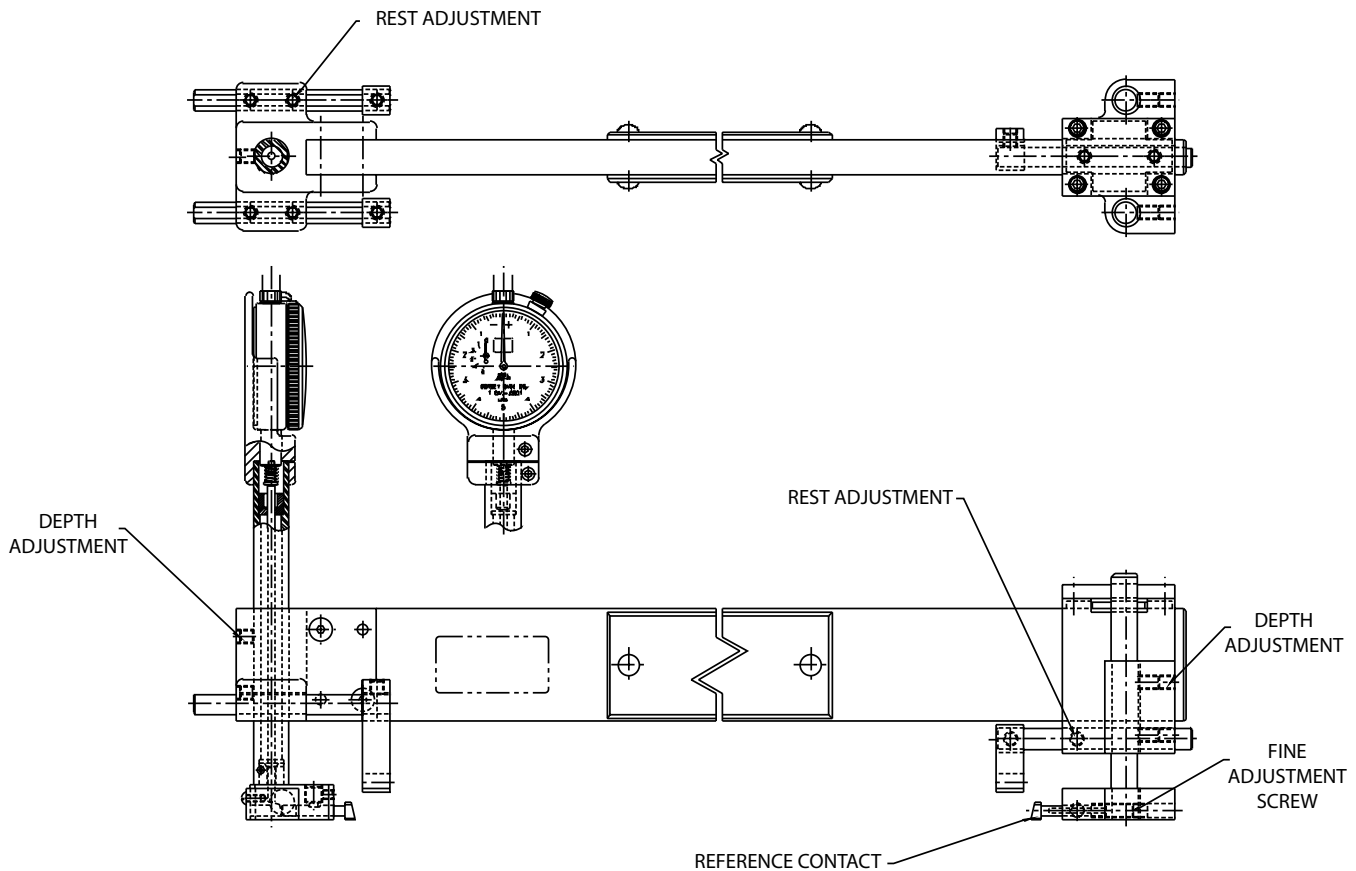


Setting Procedure for Large Diameter Gages and Masters



1. Set the rest diameter with a scale or tape measure. The rests on each end should be equidistant to the gaging contacts. Ensure that the sides of the rests are perpendicular to the surface plate.
2. On a large surface plate, set the gage rests on three gage blocks of the same height. For most applications 2" long gage blocks would be ideal. Calculate the gage block stack that should be used to set the gaging depth. If 2" gage blocks are being used, the gage block stack to be used would equal 2" less the required gaging depth, less half the contact pin or ball diameter. (For a 0.150" gaging depth on a gage with 3/16" TC ball contacts the gage block stack would equal $2.000 - 0.150 - 0.0935 = 1.7565$ ").
3. Set the stack as calculated above on the surface plate. Loosen the two set-screws that hold the 5/8" tubing on one end of the gage. Rest the contact point on the gage block stack and tighten the two set screws ensuring that the gaging head is in-line with the frame. Repeat this step on the other end of the gage.

4. On LDA (Adjustable) gages, it will be necessary to rough-set the adjustable block with a tape measure. This is accomplished by loosening the four socket head cap screws on the top of the adjustable block assembly. Slide the entire assembly along the frame to the appropriate location. Tighten the four socket head cap screws previously loosened. This step is not necessary for fixed gages.
5. Set up a gage block stack to the mean size of the diameter to be checked. Loosen the set-screw that holds the reference (static) contact in place. Back off the fine adjust screw and push the reference contact into the reference head. Gently tighten the set-screw so that there is sufficient drag on the reference contact as the fine-adjust screw is manipulated. Set the gage on the surface plate on three gage blocks of the same height. If the rests are inboard of the reference contact, as when setting up most OD applications, the rest on the reference end will sit on the gage block stack itself. Screw in the fine adjustment screw to bring the gage to zero. It is necessary to sweep the gage and maintain it at the position where the indicator changes direction to obtain a correct setting. Once the correct setting is obtained, tighten the set-screw to hold the reference contact in place. Recheck the zero position.
6. The gage is then used to set the master. On SMA (adjustable) masters, it is necessary to rough-set the adjustable block with a tape measure. Loosen the two set screws on the bottom of the block, slide the block along the rail to the appropriate location, then tighten the two screws on the bottom of the block ensuring that the cone points are engaged in the recesses on the bottom of the rail.
7. Loosen the set-screw that holds the adjustable anvil in place. Back off the fine-adjust screw and push the anvil into the block. Gently tighten the set-screw so that there is sufficient drag on the anvil shank as the fine-adjust screw is manipulated. Screw in the fine adjustment screw to bring the gage to zero. It is necessary to sweep the gage and maintain it at the position where the indicator changes direction to obtain a correct setting. Once the correct setting is obtained, tighten the set-screw to hold the adjustable anvil in place. Recheck the zero position.



Dorsey Metrology Int
53 Oakley st.
Poughkeepsie, NY 12601
Phone 845-454-3111
Fax 845-454-3888
info@dorseymetrology.com
www.dorseymetrology.com