



DORSEY DIAL BORE GAGE

MODEL DBL-248
RANGE .250-.500

ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME
1		.0001 INDICATOR	9	285	SCREW	16	904	COVER SCREW
2	120	INDICATOR SPRING	10	1043	HANDLE	17	912	EXTENSION NUT
3	110	INDICATOR CONTACT	11	908	TRANSFER	18	909-1	RANGE EXTENSION
4	103	INDICATOR HOUSING	12	901	GAGING HEAD	19	909-2	RANGE EXTENSION
5	305	SCREW	13	905	GAGING PIN	20	909-3	RANGE EXTENSION
6	911	ADAPTER	14	906	RETAINER	21	903	SPRING
7	907	PLUNGER ROD	15	902	CENTRALIZER	22	913	SCREW
8	910	EXTENSION TUBE						

DISASSEMBLY

1. LOOSEN TWO (2) SCREWS (DET. 5) AND REMOVE INDICATOR HOUSING (DET. 4) FROM ADAPTER (DET. 6). REMOVE DIAL INDICATOR (DET. 1) FROM INDICATOR HOUSING (DET. 4).
2. LOOSEN LOCKNUT (DET. 17) AND REMOVE RANGE EXTENSION (DET. 18, 19 OR 20) FROM GAGING HEAD (DET. 12).
3. LOOSEN GAGING HEAD (DET. 12) FROM HOUSING ASSEMBLY (DET. 8). REMOVE PLUNGER ROD (DET. 7).
4. LOOSEN SCREW (DET. 22) AND REMOVE SPRING (DET. 21).
5. LOOSEN COVER SCREW (DET. 16) AND REMOVE CENTRALIZER (DET. 15) FROM GAGING HEAD (DET. 12).
6. REMOVE RETAINER (DET. 14), GAGING PIN (DET. 13) AND GAGING TRANSFER (DET. 11) FROM GAGING HEAD (DET. 12).

SETTING

1. INSERT APPROPRIATE RANGE EXTENSION (DET. 18, 19 OR 20) INTO GAGING HEAD (DET. 12) AND ADJUST RANGE EXTENSION TO THE APPROXIMATE DESIRED DIAMETER.
2. INSERT GAGE INTO REFERENCE MASTER (MASTER RING GAGE 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. 17).
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-248 Range .250-.500

ASSEMBLY

1. INSERT GAGING TRANSFER (DET. 11), GAGING PIN (DET. 13) AND RETAINER (DET. 14) INTO GAGING HEAD (DET. 12).
2. PLACE CENTRALIZER (DET. 15) ON GAGING HEAD (DET. 12) AND HOLD WITH COVER SCREW (DET. 16).
3. INSERT PLUNGER ROD (DET. 7) INTO GAGING HEAD (DET. 12). PLACE HOUSING ASSEMBLY (DET. 8) OVER PLUNGER ROD (DET. 7) AND FASTEN TO GAGING HEAD (DET. 12).
4. INSERT SPRING (DET. 21) AND LOCK IN PLACE WITH SCREW (DET. 22).
5. INSERT DIAL INDICATOR (DET. 1) INTO INDICATOR HOUSING (DET. 4) AND PLACE ONTO ADAPTER (DET. 6). LOCK IN PLACE WITH TWO (2) SCREWS (DET. 5) INSURING PROPER CONTACT OF INDICATOR WITH PLUNGER ROD (DET. 7).
6. THREAD LOCK NUT (DET. 17) ONTO RANGE EXTENSION (DET. 18, 19 OR 20) AND ASSEMBLE EXTENSION TO GAGING HEAD (DET. 12).