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**DORSEY DIAL BORE GAGE**  
 MODEL DBL-600  
 RANGE: 6.00-13.00

ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME
1		.0001 INDICATOR	9	1402	CENTRALIZER	16	1417	ADAPTER
2	120	INDICATOR SPRING	10	1430	GAGING PIN	17	1414-1	RANGE EXTENSION
3	110	INDICATOR CONTACT	11	1422	RETAINER	18	1414-2	RANGE EXTENSION
4	103	INDICATOR HOUSING	12	1120	TRANSFER	19	1414-3	RANGE EXTENSION
5	305	SCREW	13	1410	GAGING HEAD	20	1313	EXTENSION NUT
6	1445	GAGING BODY	14	1450	SPRING	21	1360	WRENCH
7	1447	PLUNGER ROD	15	1455	DOWEL	22	1315	GAGING CONTACT
8	295	SCREW						

## 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.20) WITH WRENCH (DET.21) AND REMOVE RANGE EXTENSION (DET.17, 18 OR 19) AND ADAPTERS (DET.16) FROM GAGING HEAD (DET.13).
3. LOOSEN TWO (2) SCREWS (DET.8) AND DISENGAGE HOUSING ASSEMBLY (DET.6). REMOVE PLUNGER ROD (DET.7).
4. REMOVE CENTRALIZER (DET.9) FROM GAGING HEAD (DET.13).
5. REMOVE RETAINER (DET.11), GAGING PIN (DET.10) AND GAGING TRANSFER (DET.12) FROM GAGING HEAD (DET.13).

## SETTING

1. INSERT APPROPRIATE RANGE EXTENSION (DET.17, 18 OR 19) AND ADAPTERS (DET.16) INTO GAGING HEAD (DET.13) 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.20).
3. ROCK GAGE FORWARD AND BACK IN REFERENCE MASTER TO INSURE ZERO READING. ADJUST BEZEL TO ZERO IF NECESSARY.
4. REPEAT STEP NO. 3.

## Instructions for Dorsey dial bore gage Model DBL-600 Range 6.00-13.00

## ASSEMBLY

1. INSERT GAGING TRANSFER (DET.12), GAGING PIN (DET.10) AND RETAINER (DET.11) INTO GAGING HEAD (DET.13).
2. PLACE CENTRALIZER (DET.9) OVER GAGING HEAD (DET.13).
3. INSERT PLUNGER ROD (DET.7) INTO GAGING HEAD (DET.13). PLACE HOUSING ASSEMBLY (DET.6) OVER PLUNGER ROD (DET.7) ONTO GAGING HEAD (DET.13) AND LOCK IN PLACE WITH TWO (2) SCREWS (DET.8).
4. 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).
5. THREAD LOCKNUT (DET.20) ONTO RANGE EXTENSION (DET.17, 18 OR 19) AND ASSEMBLE EXTENSION TO ADAPTERS (DET.16) AND GAGING HEAD (DET.13).