



DORSEY DIAL BORE GAGE  
 MODEL DBL-499  
 RANGE: .50-1.00

ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME	ITEM	PT. NO.	PART NAME
1		.0001 INDICATOR	9	285	SCREW	16	1016	LOCK SCREW
2	120	INDICATOR SPRING	10	1043	HANDLE	17	1013	EXTENSION NUT
3	110	INDICATOR CONTACT	11	1020	TRANSFER	18	1014-1	RANGE EXTENSION
4	103	INDICATOR HOUSING	12	1010	GAGING HEAD	19	1014-2	RANGE EXTENSION
5	305	SCREW	13	1030	GAGING PIN	20	1015	ADAPTER
6	1008	ADAPTER	14	1022	LOCKING BAR	21	1050	SPRING
7	1047	PLUNGER	15	1002	CENTRALIZER	22	207	SCREW
8	1045	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) OR (DET.19) AND ADAPTERS (DET.20) FROM GAGING HEAD (DET.12).
3. LOOSEN GAGING HEAD (DET.12) FROM HOUSING ASSEMBLY (DET.8) REMOVE PLUNGER ROD (DET.7).
4. LOOSEN COVER SCREW (DET.16) AND REMOVE CENTRALIZER (DET.15) FROM GAGING HEAD (DET.12).
5. REMOVE RETAINER (DET.14), GAGING PIN (DET.13) AND GAGING TRANSFER (DET.11) FROM GAGING HEAD (DET.12).

**SETTING**

1. INSERT APPROPRIATE RANGE EXTENSIONS (DET.18) OR (DET.19) AND ADAPTERS (DET.20) 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.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-499  
 Range .50-1.00

**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 TWO (2) SCREWS (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 NUTS (DET.17) ONTO RANGE EXTENSION (DET.18) OR (DET.19) AND ASSEMBLE EXTENSIONS TO ADAPTERS (DET.20) AND GAGING HEAD (DET.12).