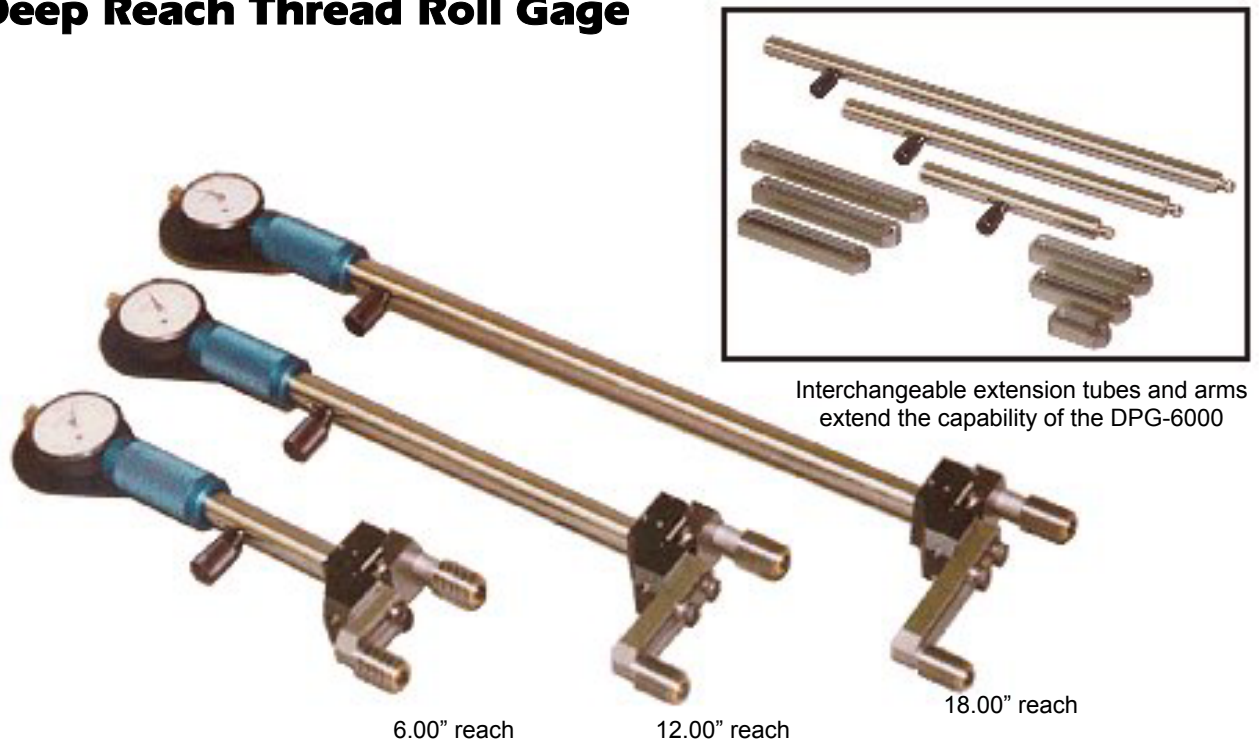


DPG-6000 Deep Reach Thread Roll Gage



The DPG-6000 thread roll gage measures the functional pitch diameter of threads. The design of the gage allows it to be inserted into deep bores for accurate inspection of thread diameters.

The DPG-6000 gage uses standard Gagemaker thread rolls. Thread rolls are available in most ANSI thread forms including; UN, ACME, Stub ACME, M series metric, and Buttress. Special thread forms are available and quoted upon request.

The reach of the gage is variable with interchangeable extension tubes. Standard tubes are available in 6", 8", 12", 18" and 24" lengths.

The diameter range of the DPG-6000 is 3.00" to 9.600" with interchangeable extension arms.

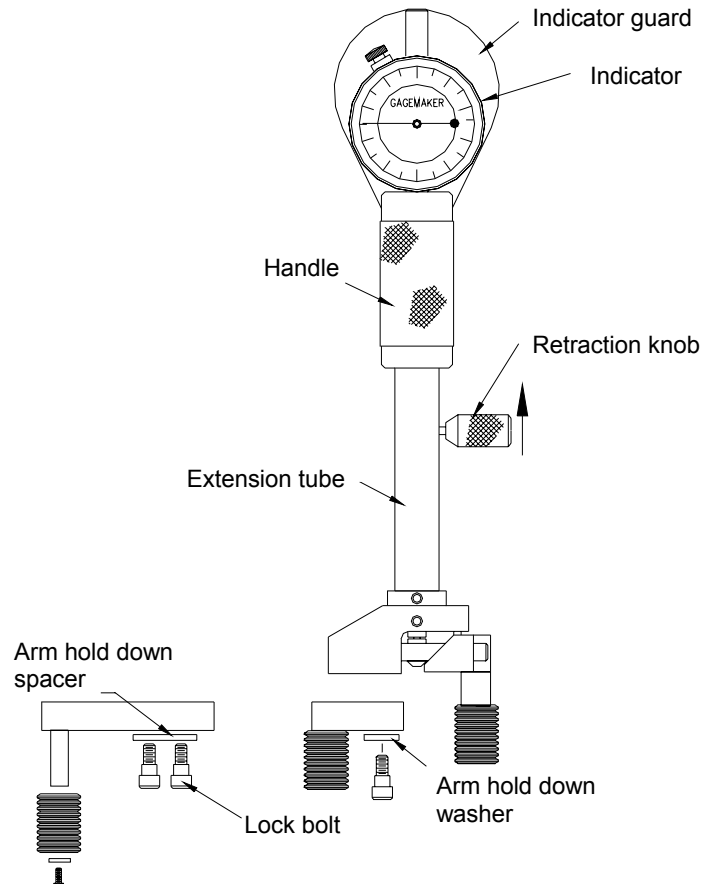
Gagemaker manufactures a complete line of thread inspection products. Our extensive knowledge of threads and gage design provides industry some of the most reliable thread gauging alternatives at the most economical prices.



Setup

The following diagrams and procedures describe the setup and operation of the DPG-6000 roll gage.

1. Locate and attach the proper extension arm for the diameter of thread to be inspected (refer to parts list).
2. Run the TD-WIN software program to obtain the required thread inspection information.
3. Select and attach the proper thread rolls for the thread. Refer to the TD-WIN printout for thread roll model number.
4. Set up gage blocks to the prescribed setting dimension outlined on the TD-WIN printout. The gage block stack should incorporate the use of extension ears for internal setting purposes.
5. Insert the assembled gage between the ears of the gage block stack as shown in Fig. 2. Sweep the gage to locate the smallest indicator reading. Zero and lock the indicator bezel.
6. Remove the gage from the gage blocks and insert the gage assembly into the threaded part. Sweeping the gage from side to side seats the thread rolls.
7. Use the fixed roll as the pivot and sweep to locate the largest indicator reading.



Sweep to locate the gage in the threads.

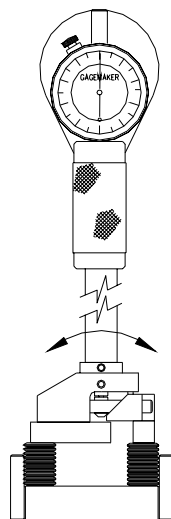


Fig. 1 Setting the gage

Rock the gage front to back to locate the smallest reading.

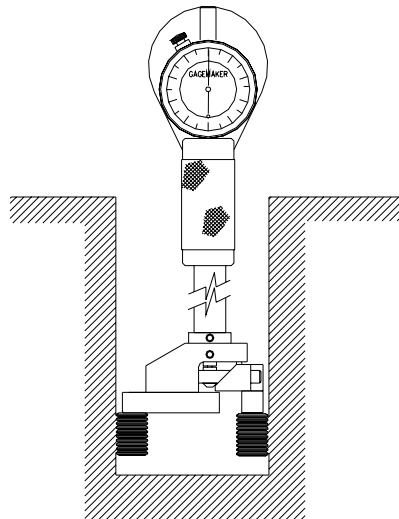


Fig. 2 Inspecting the thread

