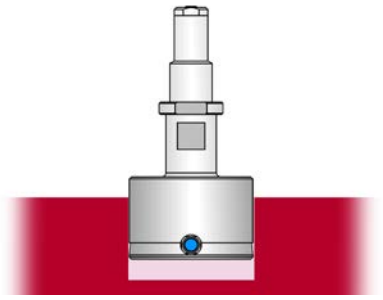
# Marameter 844 D

## Indicating plug gage

### FEATURES

- Measuring head has a hard, stainless cylinder guide and carbide tipped anvils
- The carbide expanding pin transfers radial movement to indicating instrument
- Constant measuring force as a result of built-in spring, eliminating user influence
- Extensive modular system is composed of measuring head, holder, depth extension, right angle attachments and depth stops



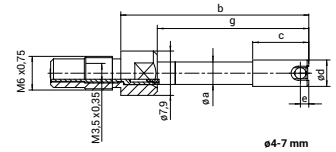


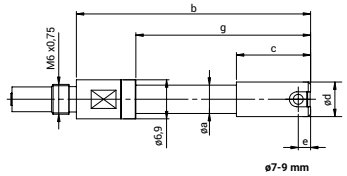
**Application:**
**Standard model**

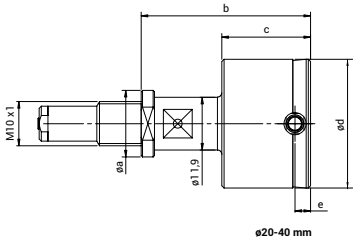
- For rapid testing of diameter, roundness and conicity of bores
- Especially suitable for testing batches with tight tolerance zones 10 µm and more
- Rocking in the bore is not required to determine diameter
- Ideal for use in conjunction with digital display units and for subsequent processing of measured values

### TECHNICAL DATA

| Order no. | Type | Measuring range | Measuring span | Manufacturing tolerance | Linearity deviation fe | Repeatability $f_w$ | a | b | c | e | g | Connection thread |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | mm | mm | mm / mm | | µm | mm | mm | mm | mm | mm | |
| **4484007** | 844 D | 2- <3 | 0.15 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | | 21.5 | 15 | 1.5 | 15 | M6 x 0.75 / M3.5x0.35 |
| **4484008** | 844 D | 3–4 | 0.2 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | | 33.5 | 24 | 1.5 | 24 | M6 x 0.75 / M3.5x0.35 |
| **4484009** | 844 D | >4–7 | 0.2 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | 4 | 33.5 | 10 | 1.5 | 27 | M6 x 0.75 / M3.5x0.35 |
| **4484010** | 844 D | >7–9 | 0.2 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | 6.9 | 47 | 15 | 2.5 | 35 | M6 x 0.75 |
| **4484011** | 844 D | >9–12 | 0.2 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | 7.9 | 47 | 15 | 2.5 | 47 | M6 x 0.75 |
| **4484012** | 844 D | >12–13 | 0.2 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | 7.9 | 47 | 15 | 2.5 | 47 | M6 x 0.75 |
| **4484013** | 844 D | >13–16 | 0.2 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | 11.9 | 47 | 15 | 2.5 | 47 | M6 x 0.75 |
| **4484014** | 844 D | >16–20 | 0.2 | –0.015 / –0.025 | 1 %, min. 1 µm | 1 | 15 | 37.3 | 15 | 2.5 | | M10x1 |
| **4484015** | 844 D | >20–30 | 0.2 | –0.02 / –0.03 | 1 %, min. 1 µm | 1 | 15 | 38.2 | 20 | 3.5 | | M10x1 |
| **4484016** | 844 D | >30–40 | 0.2 | –0.02 / –0.03 | 1 %, min. 1 µm | 1 | 15 | 38.2 | 20 | 3.5 | | M10x1 |
| **4484017** | 844 D | >40–60 | 0.2 | –0.02 / –0.03 | 1 %, min. 1 µm | 1 | 15 | 38.2 | 28 | 3.5 | | M10x1 |
| **4484018** | 844 D | >60–80 | 0.2 | –0.025 / –0.035 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484019** | 844 D | >80–100 | 0.2 | –0.025 / –0.035 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484020** | 844 D | >100–110 | 0.2 | –0.025 / –0.035 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484021** | 844 D | >110–120 | 0.2 | –0.025 / –0.035 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484022** | 844 D | >120–130 | 0.2 | –0.025 / –0.035 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484023** | 844 D | >130–140 | 0.2 | –0.035 / –0.045 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484024** | 844 D | >140–150 | 0.2 | –0.035 / –0.045 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484025** | 844 D | >150–160 | 0.2 | –0.035 / –0.045 | 1 %, min. 1 µm | 1 | 17.9 | 38.8 | 33 | 4 | | M10x1 |
| **4484026** | 844 D | >160–170 | 0.2 | –0.035 / –0.045 | 1 %, min. 1 µm | 1 | 17.9 | 39 | 40 | 4 | | M10x1 |
| **4484027** | 844 D | >170–180 | 0.2 | –0.035 / –0.045 | 1 %, min. 1 µm | 1 | 17.9 | 39 | 40 | 4 | | M10x1 |
| **4484028** | 844 D | >180–190 | 0.2 | –0.035 / –0.045 | 1 %, min. 1 µm | 1 | 17.9 | 39 | 40 | 4 | | M10x1 |
| **4484029** | 844 D | >190–200 | 0.2 | –0.035 / –0.045 | 1 %, min. 1 µm | 1 | 17.9 | 39 | 40 | 4 | | M10x1 |



# **Marameter** | 844 D indicating plug gage system

## Indicating measurement in highest precision

Plug gages of the 844 D family are 2-point indicating gages, combined with a precisely ground guide cylinder, which centers itself exactly in bores. This means that no reversal point needs to be determined by rocking. The measured value is displayed reliably, precisely and immediately.

The adjustment to a respective nominal dimension is achieved with setting rings.

**Benefits:**

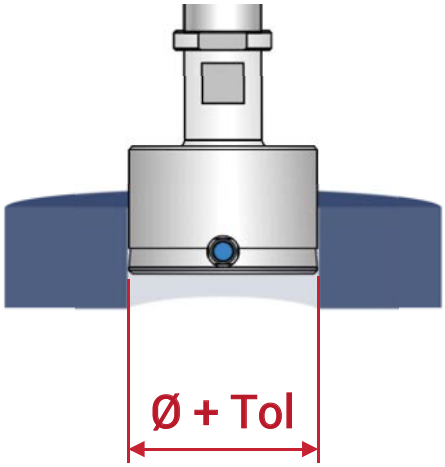
- Fast and easy to use - best performance
- No operator influence
- Self-centering - no rocking required to determine the reversal point
- Especially suitable with use of digital indicators for processing the measured values

**The following must be indicated with each order**

- Order number
- Bore diameter
- Bore tolerance (ISO or numerical value spec.)

**Examples**

| | |
|---|---|
| 1 x 4484016 | 844 D indicating plug gage<br>Nominal bore size Ø 34.5 mm<br>Bore tolerance H8 |
| 1 x 4484048 | 844 DR indicating plug gage<br>Nominal bore size Ø 74.55 mm<br>Bore tolerance +0.05 / -0.03 |




## Modular system

By combining with a wide range of accessories (indicators, holders, extensions and right angle attachment), the indicating plug gage becomes a high precision measuring instrument, adapted to the measuring task.

**Samples of application configurations**



**Standard configuration**
- Comparator
- Holder 844 Dg
- Plug gage



**Configuration for defined measuring depth**
- Comparator
- Holder 844 Dg
- Extension 844 Dv
- Depth stop 844 Dt-3
- Plug gage

**Configuration for sideways measuring in defined measuring depth**
- Comparator
- Holder 844 Dg
- Angle attachment 844 Dw
- Plug gage
- Stop ring 844 Dt-R



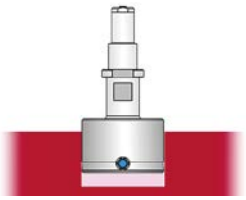
# **Marameter** | 844 D indicating plug gage system

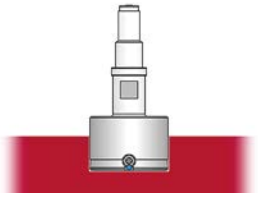
## 3 basic types

Guide cylinder hard chrome-plated, measuring surfaces made of carbide

**844 D**

Standard version for general applications
- For quick inspection of precise bores



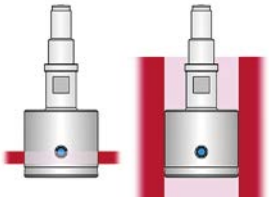


**844 DS**

Version for blind holes
- For measurements close to the base of the hole

**844 DR**

Version for through holes and thin-walled holes (metal sheet)
- With extended guide cylinder



## Variants

**Variant C: 844 D-C / 844 DR-C / 844 DS-C**
Measuring surfaces hard-chrome plated: For sensitive surfaces of non-ferrous metals and aluminum alloys



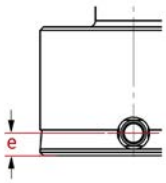
**Variant R: 844 D-R / 844 DR-R / 844 DS-R**
Measuring surfaces ruby-tipped: For very sensitive surfaces of non-ferrous metals and aluminum alloys



**Variant D: 844 D-D / 844 DR-D**
Measuring surfaces diamond-tipped: For very sensitive surfaces of soft non-ferrous metals and aluminum alloys



**Variant FD: 844 D-FD / 844 DR-FD**
Different front distance „e“: Reducing the guide cylinder to measure closer, or at a defined position, to the ground of the bore



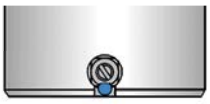

**Variant M: 844 D-M / 844 DR-M / 844 DS-M**
Extended measuring range: For measuring of larger tolerance fields




**Variant HR: 844 D-HR / 844 DR-HR / 844 DS-HR**
High resolution for very narrow bore tolerance zones < 10 µm.
More precise manufacturing tolerance of the guide cylinder for tighter gap in the bore, thus reducing axial and radial measuring influences.




**Variant F: 844 DS-F**
Only with front chamfer (no centering groove): For measuring very short blind holes



**Variant 3: 844 D-3 / 844 DR-3**
3-Point contact (3 x 120°): For fast measurement of interrupted diameters and detection of shape defects in a polygon

