Marameter 844 Dge

Plug gage holder for inductive probe

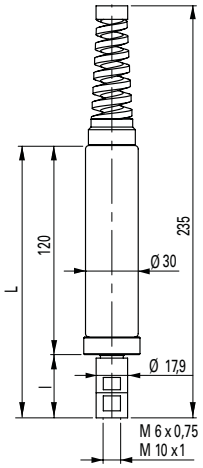
FEATURES

- The plug gage holders for inductive probes consist of a handle with cable protection on top
- Fixture (in the handle) for an inductive probe Ø 8 mm e.g. P2004-M for connection to an amplifire e.g. C1200-M
- Integrated fine adjustment for best probe setting
- Connection thread at the bottom to mount a bore gage 844 D / 844 DR / 844 DS



Applications:

- Special plug gage holders for precise measurements with inductive probes
- Mounting element in the holder for inductive probes with cylindrical shaft Ø 8 mm
- Cable socket with bend protection
- Fine adjustment attachment for the inductive probe
- Connection thread at the bottom for mounting a plug gage 844 D / 844 DR / 844 DS



TECHNICAL DATA

Order no.	Type	Dimension L	l	Connection thread
		mm	mm	
4484760	844 Dge	146	26	M6 x 0.75
4484761	844 Dge	156	36	M10x1

ACCESSORIES

Order no.	Description	Type
5312012	Compact amplifier	C 1200 M
5323010	Inductive probe, ± 2 mm	P2004 M



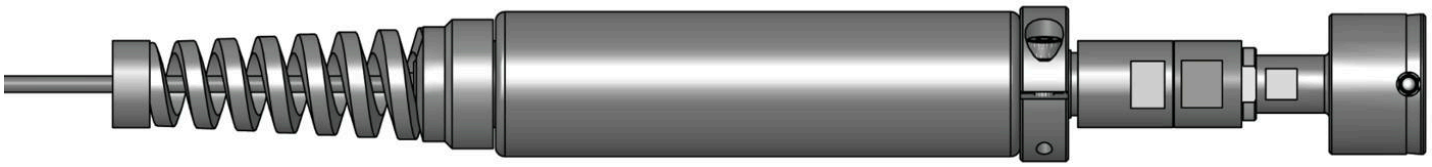
P2004 M



C 1200 M

Messgerätehalter / Plug Gage Holder

Marameter 844 Dge



Bedienungsanleitung DE

Manual EN

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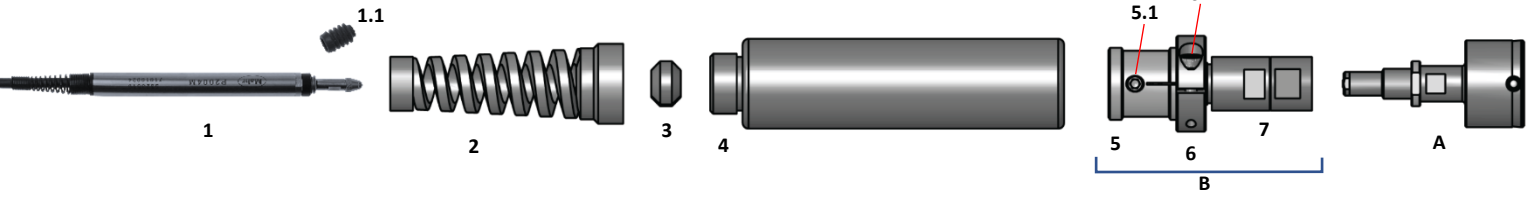
1. Bestimmungsgemäße Verwendung

Der Messgerätehalter 844 Dge hat im Handgriff eine Aufnahme für einen induktiven Längenmesstaster mit Zylinderschaft-Ø 8 mm und ein Anschlussgewinde zur Aufnahme eines Bohrungsmessdorn zur Messung von Bohrungen und das feststellen von deren Formabweichungen.
Die bestimmungsgemäße Verwendung erfordert das Beachten aller veröffentlichten Informationen zu diesem Produkt. Eine andere oder darüberhinausgehende Benutzung gilt als nicht bestimmungsgemäß. Für hieraus
entstehende Schäden haftet der Hersteller nicht. Beachten Sie die für den Einsatzbereich geltenden gesetzlichen und anderweitigen Vorschriften und Richtlinien.
Vor Inbetriebnahme des Gerätes empfehlen wir Ihnen, die Bedienungsanleitung aufmerksam zu lesen.

Zur Grundausstattung des Messgerätehalter für Induktivtaster 844 Dge gehört:

- Messgerätehalter für Induktivtaster 844 Dge (ohne Induktivtaster)
- Innensechskantschlüssel, Maulschlüssel
- Bedienungsanleitung

2. Beschreibung



1 Induktivtaster* mit zylindischem Schaft-Ø 8 mm
2 Kabel-Knickschutz
3 Kabelklemmelement für Zugentlastung
4 Handgriff
5 Aufnahme mit Klemmschraube 5.1 für Induktivtaster
6 Klemmring mit Klemmschraube 6.1 für Feinjustierung
7 Feinjustier-Element zur Einstellung der Tasterposition
A Bohrungsmessdorn
B Aufnahmeelement für Taster und Bohrungsmessdorn

* Hinweis: Um eine bestmögliche Wiederholgenauigkeit bei der Messung zu erreichen wird für die Verwendung im Halter 844 Dge empfohlen den Faltenbalg 1.1 zu entnehmen.

3. Montage des Induktivtaster

3.1 Messgerätehalter demontieren (Baugruppen 2, 3, 4 und B)
3.2 Bohrungsmessdorn A in Aufnahmeelement B handfest einschrauben
3.3 Induktivtaster* (1) durch Kabelknickschutz (2), Kabelklemmung (3) und Handgriff (4) führen
3.4 Induktivtaster* (1) in Tasteraufnahme (5) einführen, bis am Anzeigegerät (nicht dargestellt) eine Messwertänderung sichtbar ist
3.5 Induktivtaster über Klemmschraube (5.1) mit Innensechskantschlüssel - durch gefühlvolles anziehen – befestigen
3.6 Die Elemente 2, 3, 4 und B verschrauben
► Den Kabel-Knickschutz (2) NOCH NICHT fest anziehen!

4. Vorbereitung zur Messung

4.1 Messmittel in Einstellnormal einführen, z. B. Einstellring.
4.2 Schraube 6.2 leicht lösen, durch Drehen der Feinjustierung (7) kann auf den den idealen Messbereich, nahe des elektronischen Nullpunktes des Induktivtasters, positioniert werden
4.3 Klemmschraube (7) klemmen, Kabel-Knickschutz (2) anziehen ⇨ damit wird das Kabel durch Kabelklemmelement (3) gegen Herausziehen gesichert
4.4 Das Gerät ist nun einsatzbereit

EN

1. Permitted use

The plug gage holder 844 Dge is with a fixture in the handle for an inductive probe Diameter 8 mm, with connection thread at the bottom for mounting a plug gage, ideal for measuring bores and determine their ovalities.
Permitted use is subject to compliance with all published information relating to this product. Any other use is not in accordance with the permitted use. The manufacturer accepts no liability for damages resulting from improper use. All statutory and other regulations and guidelines applicable to the area of use must be observed.
In order to achieve the best use of this measuring instrument it is most important that you read these operating instruction first.

Basically the plug gage holder for inductive probe 844 Dge consists of:

- Plug gage holder for inductive probe 844 Dge (without inductive probe)
- Hexagon key, Spanner
- Operating Instruction

2. Description

1 Inductive probe* with zylindrical shaft diameter 8 mm
2 Cable bend protection
3 Cable clamp element for strain relief
4 Handle
5 Holder with clamping screw 5.1 for inductive probe
6 Clamping ring with clamping screw 6.1 for fine adjustment
7 Fine adjustment element for setting the probe position
A Bore gage
B Mounting device for mounting inductive probe and bore gauge

* Please note: In order to achieve the best possible repeatability for the measurement it is recommended to remove the bellows 1.1 for use in the 844 Dge holder remove the bellows 1.1.

3. Mounting the inductive probe

3.1 Dismantle the plug gage holder (assemblies 2, 3, 4, and B)
3.2 Screw bore gauge A into mounting element B hand-tight
3.3 Guide inductive probe* (1) through cable kink protection (2), cable clamp (3) and handle (4)
3.4 Insert inductive probe* (1) into probe holder (5) until a change in measured value appears on the display unit (not shown)
3.5 Fasten inductive probe via clamping screw (5.1) with Allen key - by tightening it sensitively
3.6 Screw together elements 2, 3, 4 and B
► Do NOT tighten the cable bend protection (2) YET!

4 Preparation for measurement

4.1 Insert measuring device into setting standard, e.g. setting ring.
4.2 Loosen screw 6.2 slightly, by turning the fine adjustment (7) can be positioned to the ideal measuring range, close to the electronic zero point of the inductive probe.
4.3 Clamp the clamping screw (7), tighten the cable bend protection (2) ⇨ thus the cable is secured against being pulled out by the cable clamping element (3)
4.4 The device is now ready for use

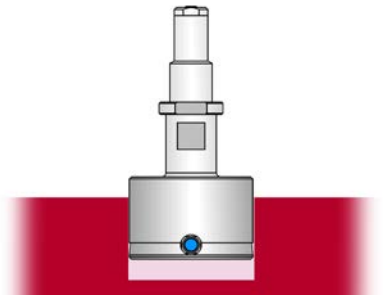
Marameter 844 D

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



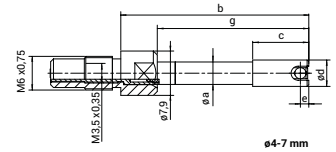


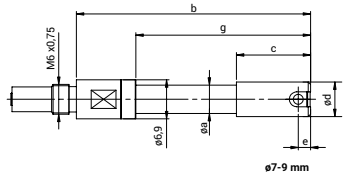
Application:
Standard model

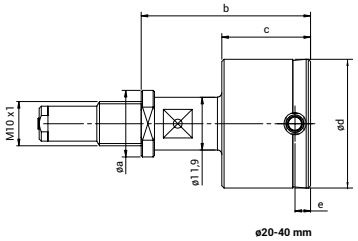
- For rapid testing of diameter, roundness and conicity of bores
- Especially suitable for testing batches with tight tolerance zones 10 µm and more
- Rocking in the bore is not required to determine diameter
- Ideal for use in conjunction with digital display units and for subsequent processing of measured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

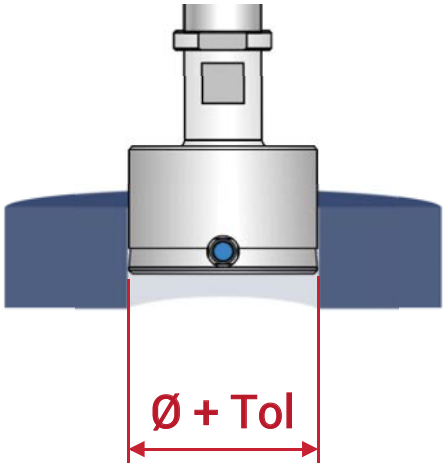
- Fast and easy to use - best performance
- No operator influence
- Self-centering - no rocking required to determine the reversal point
- Especially suitable with use of digital indicators for processing the measured values

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 Nominal bore size Ø 34.5 mm Bore tolerance H8
1 x 4484048	844 DR indicating plug gage Nominal bore size Ø 74.55 mm 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



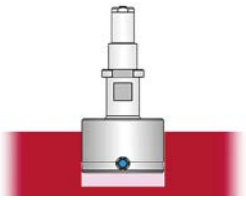
Marameter | 844 D indicating plug gage system

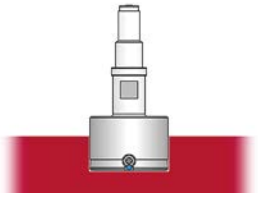
3 basic types

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

844 D

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



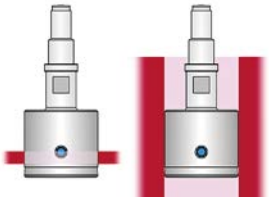


844 DS

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



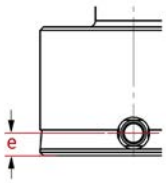
Variant R: 844 D-R / 844 DR-R / 844 DS-R
Measuring surfaces ruby-tipped: For very sensitive surfaces of non-ferrous metals and aluminum alloys



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



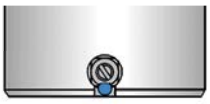
Variant M: 844 D-M / 844 DR-M / 844 DS-M
Extended measuring range: For measuring of larger tolerance fields



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

