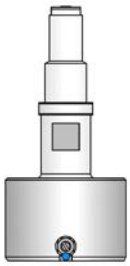
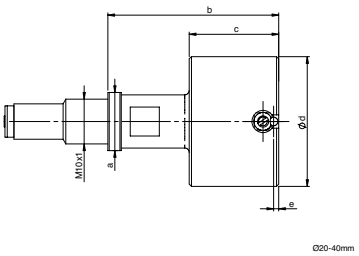
Marameter 844 DS-F

Indicating plug gage

FEATURES

- Measuring probe made of hardened, stainless guide cylinder and carbide tipped probes
- Carbide driving needle transfers radial measuring movement to the display unit
- Constant measuring force as a result of built-in spring, eliminating user influence
- Measuring head, measuring instrument holder, depth extensions, right angle attachments and depth stops form a comprehensive modular system



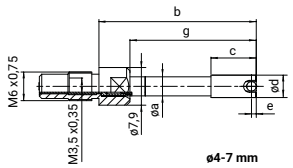


Application: Model for blind holes, with front chamfer

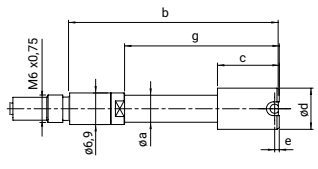
- For measuring very short bores
- For measurements close to the base of the hole
- For rapid testing of diameter, roundness and conicity of bores
- Especially suitable for testing batches with tight tolerance zones
- Rocking in the bore is not required to determine diameter
- Ideal for use in conjunction with digital display units and for subsequent processing of measured values

TECHNICAL DATA

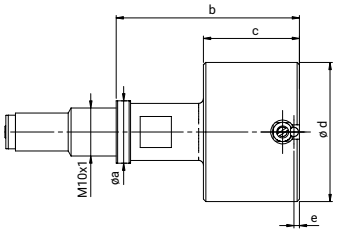
Order no.	Type	Measuring range	Measuring span	Manufacturing tolerance	Linearity deviation fe	Repeatability f_w	a	b	c	e	g	Connection thread
		mm	mm	mm / mm		µm	mm	mm	mm	mm	mm	
4484627	844 DS-F	2–2,999	0.15	–0.015 / –0.025	1.5 %, min. 1 µm	1		20.7	14,2	0.7	14,2	M6 x 0.75 / M3.5x0.35
4484628	844 DS-F	3–4	0.2	–0.015 / –0.025	1.5 %, min. 1 µm	1		33	23.5	1	23.5	M6 x 0.75 / M3.5x0.35
4484629	844 DS-F	>4–7	0.2	–0.015 / –0.025	1.5 %, min. 1 µm	1	4	33	9.5	1	26.5	M6 x 0.75 / M3.5x0.35
4484630	844 DS-F	>7–9	0.2	–0.015 / –0.025	1.5 %, min. 1 µm	1	6.9	45.5	13.5	1	33.5	M6 x 0.75
4484631	844 DS-F	>9–12	0.2	–0.015 / –0.025	1.5 %, min. 1 µm	1	7.9	45.5	13.5	1	45.5	M6 x 0.75
4484632	844 DS-F	>12–13	0.2	–0.015 / –0.025	1.5 %, min. 1 µm	1	7.9	45.5	13.5	1	45.5	M6 x 0.75
4484633	844 DS-F	>13–16	0.2	–0.015 / –0.025	1.5 %, min. 1 µm	1	11.9	45.5	13.5	1	45.5	M6 x 0.75
4484634	844 DS-F	>16–20	0.2	–0.015 / –0.025	1.5 %, min. 1 µm	1	15	35.8	13.5	1		M10x1
4484635	844 DS-F	>20–30	0.2	–0.02 / –0.03	1.5 %, min. 1 µm	1	15	38.2	20	1.2		M10x1
4484636	844 DS-F	>30–40	0.2	–0.02 / –0.03	1.5 %, min. 1 µm	1	15	38.2	20	1.2		M10x1
4484637	844 DS-F	>40–60	0.2	–0.02 / –0.03	1.5 %, min. 1 µm	1	15	38.2	28	1.2		M10x1
4484638	844 DS-F	>60–80	0.2	–0.025 / –0.035	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484639	844 DS-F	>80–100	0.2	–0.025 / –0.035	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484640	844 DS-F	>100–110	0.2	–0.025 / –0.035	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484641	844 DS-F	>110–120	0.2	–0.025 / –0.035	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484642	844 DS-F	>120–130	0.2	–0.025 / –0.035	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484643	844 DS-F	>130–140	0.2	–0.035 / –0.045	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484644	844 DS-F	>140–150	0.2	–0.035 / –0.045	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484645	844 DS-F	>150–160	0.2	–0.035 / –0.045	1.5 %, min. 1 µm	1	17.9	39	33	1.2		M10x1
4484646	844 DS-F	>160–170	0.2	–0.035 / –0.045	1.5 %, min. 1 µm	1	17.9	38.6	40	1.2		M10x1
4484647	844 DS-F	>170–180	0.2	–0.035 / –0.045	1.5 %, min. 1 µm	1	17.9	38.6	40	1.2		M10x1
4484648	844 DS-F	>180–190	0.2	–0.035 / –0.045	1.5 %, min. 1 µm	1	17.9	38.6	40	1.2		M10x1
4484649	844 DS-F	>190–200	0.2	–0.035 / –0.045	1.5 %, min. 1 µm	1	17.9	38.6	40	1.2		M10x1



ø4-7 mm



ø7-9 mm



ø20-40 mm

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:

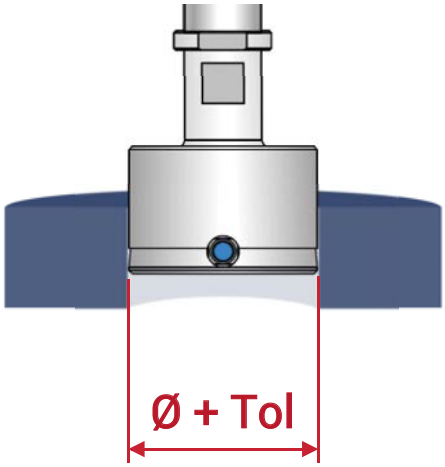
- Fast and easy to use - best performance
- No operator influence
- Self-centering - no rocking required to determine the reversal point
- Especially suitable with use of digital indicators for processing the measured values

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



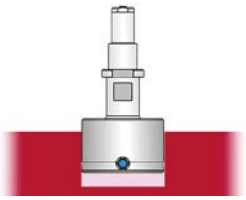
Marameter | 844 D indicating plug gage system

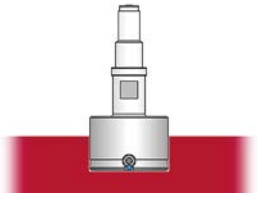
3 basic types

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

844 D

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



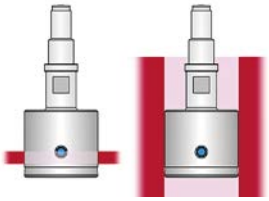


844 DS

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



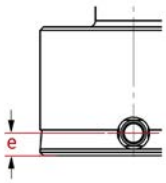
Variant R: 844 D-R / 844 DR-R / 844 DS-R
Measuring surfaces ruby-tipped: For very sensitive surfaces of non-ferrous metals and aluminum alloys



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



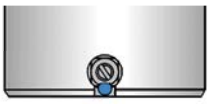
Variant M: 844 D-M / 844 DR-M / 844 DS-M
Extended measuring range: For measuring of larger tolerance fields



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

