Marameter 844 Dv

Extension for measuring depth

FEATURES

- The 844 Dv depth extension is srewed in between holder 844 Dg and plug gage 844 D / 844 DR / 844 DS (if necessary right angle attachment 844 Dw)

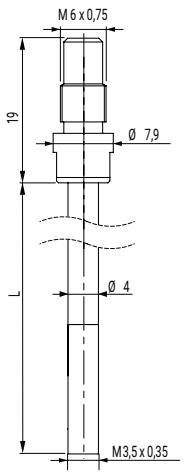


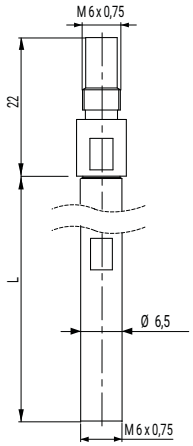
Applications:

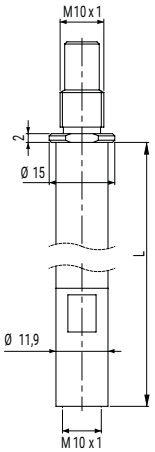
- For bore measurement at larger depths
- Practical additional function as clamping shank for depth measuring stops 844 Dt

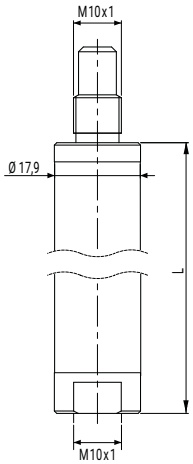
TECHNICAL DATA

Order no.	Type	Dimension L	d1	d2	Connection thread
		mm	mm	mm	
4484770	844 Dv	49	4	7.9	M6 x 0.75 / M3.5x0.35
4484771	844 Dv	99	4	7.9	M6 x 0.75 / M3.5x0.35
4484772	844 Dv	149	4	7.9	M6 x 0.75 / M3.5x0.35
4484773	844 Dv	249	4	7.9	M6 x 0.75 / M3.5x0.35
4484774	844 Dv	50	6.5	7.9	M6 x 0.75
4484775	844 Dv	100	6.5	7.9	M6 x 0.75
4484776	844 Dv	150	6.5	7.9	M6 x 0.75
4484777	844 Dv	250	6.5	7.9	M6 x 0.75
4484778	844 Dv	500	6.5	7.9	M6 x 0.75
4484779	844 Dv	48	11.9	15	M10x1
4484780	844 Dv	98	11.9	15	M10x1
4484781	844 Dv	248	11.9	15	M10x1
4484782	844 Dv	498	11.9	15	M10x1
4484783	844 Dv	750	11.9	15	M10x1
4484784	844 Dv	1000	11.9	15	M10x1
4484785	844 Dv	100	17.9		M10x1
4484786	844 Dv	250	17.9		M10x1
4484787	844 Dv	500	17.9		M10x1
4484788	844 Dv	750	17.9		M10x1
4484789	844 Dv	1000	17.9		M10x1









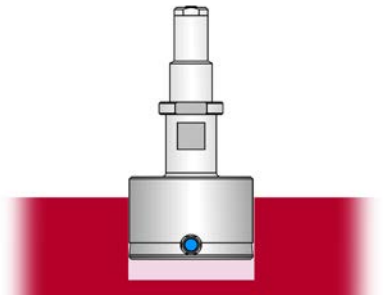
Marameter 844 D

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



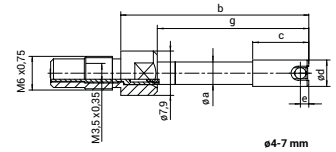


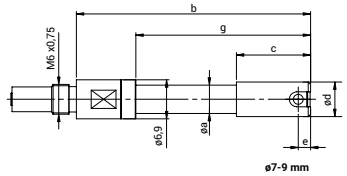
Application:
Standard model

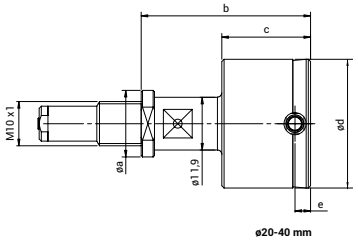
- For rapid testing of diameter, roundness and conicity of bores
- Especially suitable for testing batches with tight tolerance zones 10 µm and more
- Rocking in the bore is not required to determine diameter
- Ideal for use in conjunction with digital display units and for subsequent processing of measured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

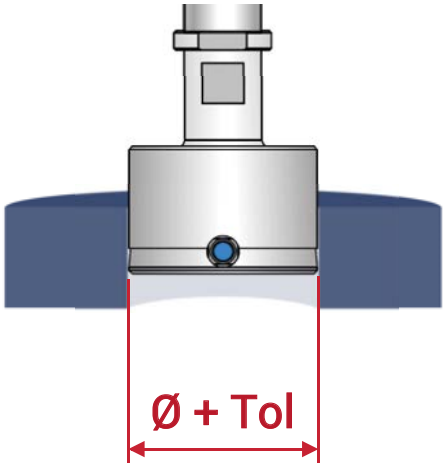
- Fast and easy to use - best performance
- No operator influence
- Self-centering - no rocking required to determine the reversal point
- Especially suitable with use of digital indicators for processing the measured values

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



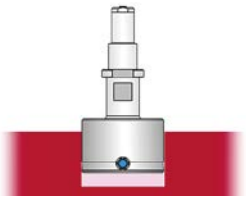
Marameter | 844 D indicating plug gage system

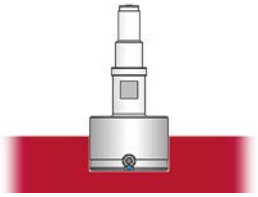
3 basic types

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

844 D

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



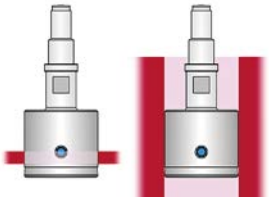


844 DS

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



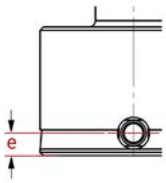
Variant R: 844 D-R / 844 DR-R / 844 DS-R
Measuring surfaces ruby-tipped: For very sensitive surfaces of non-ferrous metals and aluminum alloys



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



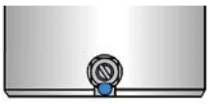
Variant M: 844 D-M / 844 DR-M / 844 DS-M
Extended measuring range: For measuring of larger tolerance fields



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

