

Countersink Chamfer Gages

HOLE CHAMFER MEASUREMENT

PART IDENTIFICATION



1. Dedicated Dial Gauge
※ Can not be removed or replaced.
2. Limit Markers
3. Pointer
4. Short Hand
5. Bezel
6. Gauge Mount
7. Meas. Head
8. Ref. Surface
9. Meas. Taper

CHAMFER GAGE is a precision instrument designed specifically to measure the top (major) diameter of a chamfer, countersink, center drill, or tapered hole.

Merely press the spring loaded, conically ground, precision 3-blade Gaging Plunger into the chamfer.

SAFETY

PLEASE OBSERVE

Always follow the procedures specified below in order to prevent harm to yourself or others, and to prevent damage to property.

CAUTION: Indicates risk of **personal injury** or **property damage** if not followed.

- Measurement Head and Measurement Taper are hardened steel and sensitive to corrosion. Please keep well protected with rust inhibitor when not in use.

Only use with the dedicated Dial Gauge. Use of any other gauge will cause reading error. Do not remove Dial Gauge, or loosen the holding screw. Loosening screw will cause reading inaccuracy.

Use care when contacting Measuring Head to workpiece and avoid impact; there is risk of damage to Measurement Taper.

Instrument is designed for measuring the ID chamfer max. diameter.

Use for any other purpose may cause accident or injury.

APPLICATIONS & FEATURES

The chamfer diameter (max diameter) for a range of chamfer angles can be measured.

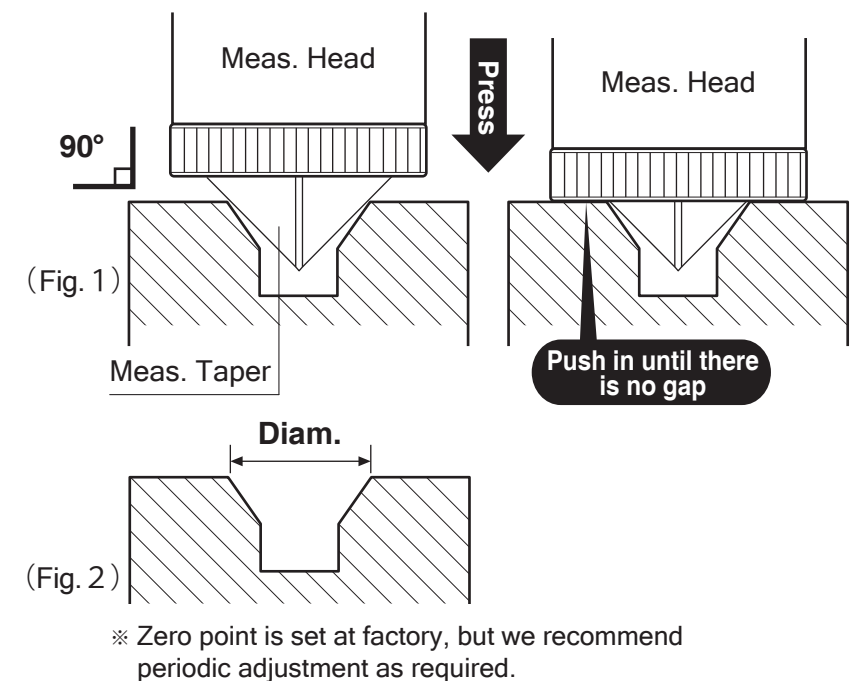
Dedicated Dial Gauge for direct reading of measurement.

		Angle range	Diameter range	Accuracy
Metric	ID Electronic	0-90D	0-25mm	Â± 0.01mm
Metric	ID Electronic	0-127D	0-25mm	Â± 0.02mm
Metric	ID Electronic	0-90D	20-40mm	Â± 0.01mm
Metric	ID Electronic	0-127D	20-40mm	Â± 0.01mm

		Angle range	Diameter range	Accuracy
Inch	ID Mechanical	0-90D	0"-1"	Â± 0.001"
Inch	ID Mechanical	0-90D	1"-2"	Â± 0.001"
Inch	ID Mechanical	0-127D	0"-1"	Â± 0.002"
Inch	ID Mechanical	0-127D	1"-2"	Â± 0.002"
Inch	ID Electronic	0-90D	0"-1"	Â± 0.0005"
Inch	ID Electronic	0-90D	1"-2"	Â± 0.0005"
Inch	ID Electronic	0-127D	0"-1"	Â± 0.0009"
Inch	ID Electronic	0-127D	1"-2"	Â± 0.0009"

MEASUREMENT

- Hold the Measurement Head perpendicular to the workpiece and slowly push in until there is no gap between the workpiece and the Measurement Head Reference Surface. (Fig. 1)
- The Dial Gauge will indicate the maximum diameter of the chamfer. (Fig. 2)



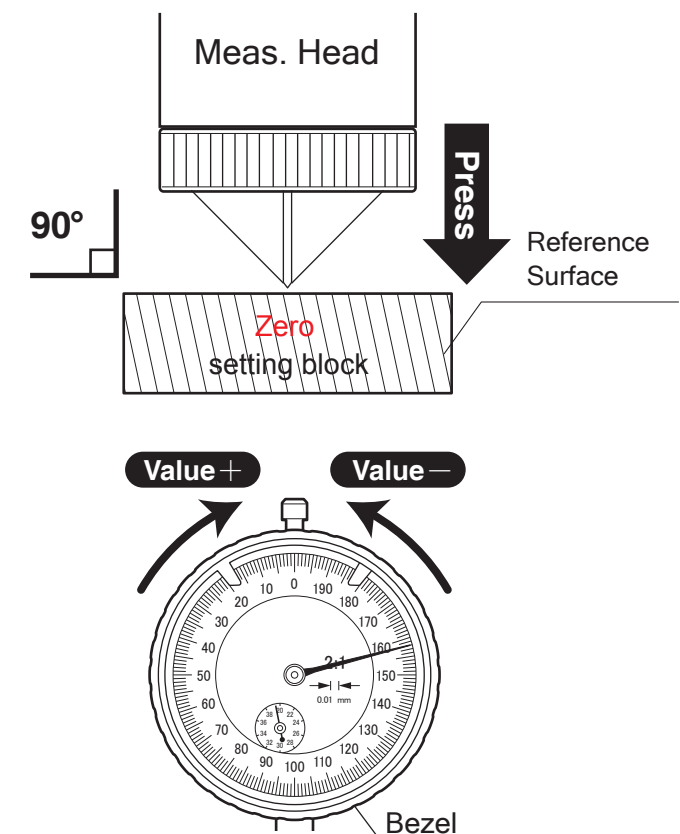
ZERO ADJUSTMENT

Setting **Zero** Point on Flat Reference Surface

- Place the Measurement Head perpendicular to the block slowly push in until there is no gap.
- The number printed on the side of the Dedicated Gauge is the Reference Value used for zero adjustment.

Adjust the reading to match the Reference Value by rotating the Bezel of the Dedicated Gauge. When the Gauge Reading matches the Reference Value, the zero adjustment is complete

※ Repeat the measurement several times to confirm that the value is stable.



AFTER USE CARE, STORAGE

Clean outside surfaces regularly using a cloth to remove any dirt or contamination. After use, place in a rust preventive bag or use a corrosion inhibiting oil for protection.