

PRECISION GAGE BLOCKS

Large Size Gage Block Sets

大八块
8 Piece Sets



Inch

Size	Grade 0 Order No.	Grade AS-1 Order No.	Grade AS-2 Order No.
5", 6", 7", 8", 10", 12", 16", 20"	630-8100	630-8101	630-8102

Metric

Size	Grade 0 Order No.	Grade 1 Order No.	Grade 2 Order No.
125, 150, 175, 200, 250, 300, 400, 500mm	630-8000	630-8001	630-8002
25, 50, 75, 100, 125, 150, 175, 200mm	630-8200	630-8201	630-8202

• Gage Block Clamps : NO. 631-2270

New Measuring Tools Setting Masters

千分尺卡尺校对套装



MHC NO.:

612-9200 10 pcs inch Grade 0 steel gage blocks size :

.0625", .100", .125", .200", .250", .300",
.500", 1.000" & 2.000"
1 Optical Flat: 1" Dia x .5125" Thickness,
.000004", Flatness, .00002" Parallel

612-9204 11pcs metric Grade 0 steel gage blocks size:

2.5, 5.1, 7.7, 10.3, 12.9, 15.0, 17.6,
20.2, 22.8, 25mm
1pcs Optical Flat: 30mm Dia. Thickness;
12.0mm Optical Flats

Precision Gage Block

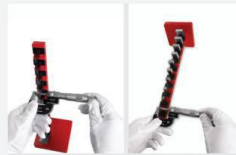
块规

- Higher degree of accuracy when used at temperature of 68° F (20°C).
- Individual serial numbers on each block regardless of grade.
- A complete certificate of calibration traceable to the N.I.S.T. showing the deviation of each block
- All sets are supplied in deluxe fitted wood case.
- All sets meet or exceed Fed.Spec. ASME B89.1.9-2002
- Mirror polished surfaces provide superior wringing characteristics.

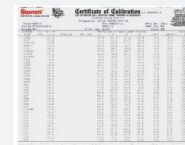
Nominal Size	Tolerances (in millionths of an inch)			
	0	AS-1	AS-2	Economy
Thru .050	+/-6	+/-12	+/-24	+/-50
Thru .400	+/-5	+/-8	+/-18	+/-50
Thru 1"	+/-6	+/-12	+/-24	+/-50
Thru 2"	+/-8	+/-16	+/-32	+/-50
Thru 3"	+/-10	+/-20	+/-40	+/-50
Thru 4"	+/-12	+/-24	+/-48	+/-50

Nominal Size	Tolerances (in millionths of an inch)		
	0	AS-1	AS-2
Thru 6"	+/-16	+/-32	+/-64
Thru 8"	+/-20	+/-40	+/-80
Thru 10"	+/-24	+/-48	+/-104
Thru 12"	+/-28	+/-56	+/-112
Thru 16"	+/-36	+/-72	+/-144
Thru 20"	+/-44	+/-88	+/-176

- New setting Masters are quick easy and extremely accurate. Each comes with a certificate of calibration and a aluminum case. Save time and money by calibrating your own measuring tools.



- A certificate shows individual deviation of each block.
- Gage blocks traceable to the NIST.
- Each block is serialized.
- With Fitted wooden case.
- Optical flats are .0005" thickness accuracy.
- 12-Piece feature 2 optical flats with .0125" step for checking spindle at half revolution.
- 10-Piece sets & 12-Piece sets feature different blocks combination for precision checking of different ranges.



鉴定证书



检验证书

Micrometer Checking Sets

千分尺校对用块规和平晶



Micrometer Checking Sets

Piece/Set	MHC NO.		Standard			specifications
	Steel	Ceramic	ISO/DIN/JIS	ASM	BS	
11	9100-9166	9100-9322	--	K 00 0 1	--	Size: .105, .210, .315, .420, .500, .605, .710, .815, .920, 1.00 1 Optical Flat: 1" Dia x .5125" Thickness, .000004", Flatness, .00002" Parallel
	9100-9167	9100-9323	--	K 00 0 1	--	
12	9100-9159	9100-9324	--	K 00 0 1	--	Size: .105, .210, .315, .420, .500, .605, .710, .815, .920, 1.00 2 Optical Flat: 1" Dia x .5125" Thickness, .000004", Flatness, .00002" Parallel
	9100-9160	9100-9325	--	K 00 0 1	--	
9	9100-9153	9100-9330	--	K 00 0 1	--	Size: .0625, .100, .125, .200, .250, .300, .500, 1.000 & 2.00
	9100-9154	9100-9331	--	K 00 0 1	--	
10	9100-9156	9100-9334	--	K 00 0 1	--	Size: .0625, .100, .125, .200, .250, .300, .500, 1.000 & 2.00 1 Optical Flat: 1" Dia x .5125" Thickness, .000004", Flatness, .00002" Parallel
	9100-9157	9100-9335	--	K 00 0 1	--	
11	9100-9162	9100-9337	--	K 00 0 1	--	Size: .0625, .100, .125, .200, .250, .300, .500, 1.000 & 2.00 2 Optical Flat: 1" Dia x .5125" Thickness, .000004", Flatness, .00002" Parallel
	9100-9163	9100-9338	--	K 00 0 1	--	
8	9100-9168	9100-9326	--	0 1	--	Size: 1, 2, 3, 4, 5, 6, 7, 8"
	9100-9169	9100-9327	--	0 1	--	

Micrometer Checking Sets

Piece/Set	MHC NO.		Standard			specifications
	Steel	Ceramic	ISO/DIN/JIS	ASM	BS	
14	9100-9170	9100-9350	0	--	--	Size: 2.5, 5.1, 7.7, 10.3, 12.9, 15.0, 17.6, 20.2, 22.8, 25, 50, 75, 100mm 1pcs Optical Flat: 30mm Dia. Thickness; 12.0mm Optical Flats
	9100-9179	9100-9351	1	--	--	
11	9100-9171	9100-9356	0	--	--	Size: 2.5, 5.1, 7.7, 10.3, 12.9, 15.0, 17.6, 20.2, 22.8, 25mm 1pcs Optical Flat: 30mm Dia. Thickness; 12.0mm Optical Flats
	9100-9172	9100-9357	1	--	--	
10	9100-9173	9100-9358	2	--	--	Size: 1.00, 1.25, 1.50, 2.3, 3.5, 10, 15, 20mm 1pcs Optical Flat: 30mm Dia. Thickness; 12.0mm Optical Flats
	9100-9177	9100-9352	0	--	--	
8	9100-9178	9100-9353	1	--	--	Size: 25, 50, 75, 100, 125, 150, 175, 200mm
	9100-9174	9100-9365	0	--	--	
	9100-9175	9100-9366	1	--	--	
	9100-9176	9100-9367	2	--	--	

PRECISION GAGE BLOCKS

Rectangular Gage Block Sets
套装矩形块规



36pcs Grade	Steel Order No.	Solid Carbide Order No.	Ceramic Order No.
0	630-4100	125-0362	631-0362
AS-1	630-4103	125-0363	631-0363
AS-2	630-4104	125-0364	631-0364
Economy	630-4105	125-0365	631-0365



81pcs Grade	Steel Order No.	Solid Carbide Order No.	Ceramic Order No.
0	630-4110	125-0812	631-0812
AS-1	630-4113	125-0813	631-0813
AS-2	630-4114	125-0814	631-0814
Economy	630-4115	125-0815	631-0815

36 Piece Sets

Blocks Included in each Set
1 Blocks: 0.050"
9 Blocks: 0.1001"-0.1009" by 0.0001" steps
9 Blocks: 0.101"-0.109" by 0.001" steps
9 Blocks: 0.110"-0.190" by 0.010" steps
5 Blocks: 0.100"-0.500" by 0.100" steps
3 Blocks: 1, 2, 4"

81 Piece Sets

Blocks Included in each Set
9 Blocks: 0.1001"-0.1009" by 0.0001 steps
49 Blocks: 0.101"-0.149" by 0.001" steps
19 Blocks: 0.050"-0.950" by 0.050" steps
4 Blocks: 1.000"-4.000" by 1.000" steps



36 Piece Sets

Blocks Included in each Set
1 Blocks: 0.050"
9 Blocks: 0.1001"-0.1009" by 0.0001" steps
9 Blocks: 0.101"-0.109" by 0.001" steps
9 Blocks: 0.110"-0.190" by 0.010" steps
5 Blocks: 0.100"-0.500" by 0.100" steps
3 Blocks: 1, 2, 4"



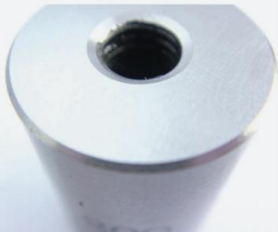
- Each block clearly marked for size
- Hardened and lapped
- 4 connecting screws included, make any length desired.
- Complete in fitted case.
- Thread HRC58-60

Set Included:

9 Pieces: .101-.109" by .001"
15 Pieces: .050-.190" by .010"
9 Pieces: .200-1.000" by .100"
1 Piece: .0625"
1 Piece: .125"
1 Piece: 1.000"

81 Piece Sets

Blocks Included in each Set
9 Blocks: 0.1001"-0.1009" by 0.0001 steps
49 Blocks: 0.101"-0.149" by 0.001" steps
19 Blocks: 0.050"-0.950" by 0.050" steps
4 Blocks: 1.000"-4.000" by 1.000" steps



Square Gage Block Sets
套装方块规



Grade	36 PCS Order No.	81 PCS Order No.	Carbide	
			36 PCS Order No.	81 PCS Order No.
0	630-4126	630-4120	125-0366	125-0816
AS-1	630-4127	630-4123	125-0367	125-0817
AS-2		630-4124	125-0368	125-0818
Economy	630-4128	630-4125	125-0369	125-0819

36 Pieces Space Block Sets
36件间距规



Dia.	Accuracy	I.D.	Order No.
3/4"	+/- .0001"	1/4"-28 thread	630-4050
3/4	+/- .0001"	M6 thread	630-4051
3/4	+/- .00005"	1/4"-28 thread	630-4055



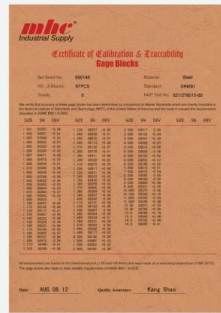
PRECISION GAGE BLOCKS

Individual Rectangular Gage Blocks

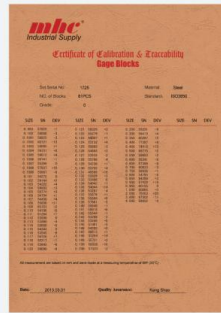
矩形块规

630-XXXX for Steel 125-XXXX for Carbide

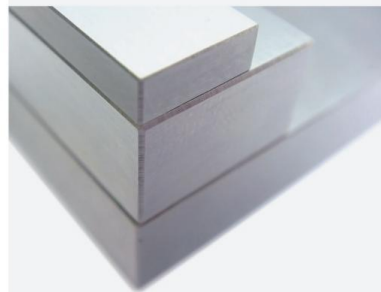
Size	Grade 0	Grade AS-1	Grade AS-2	Grade Economy	Size	Grade 0	Grade AS-1	Grade AS-2	Grade Economy
Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.
0.050"	-2305	-3305	-A305	-B305	0.140"	-2140	-3140	-A140	-B140
0.100"	-2310	-3310	-A310	-B310	0.141"	-2141	-3141	-A141	-B141
0.10005"	-2205	-3205	-A205	-B205	0.142"	-2142	-3142	-A142	-B142
0.1001"	-2001	-3001	-A001	-B001	0.143"	-2143	-3143	-A143	-B143
0.1002"	-2002	-3002	-A002	-B002	0.144"	-2144	-3144	-A144	-B144
0.1003"	-2003	-3003	-A003	-B003	0.145"	-2145	-3145	-A145	-B145
0.1004"	-2004	-3004	-A004	-B004	0.146"	-2146	-3146	-A146	-B146
0.1005"	-2005	-3005	-A005	-B005	0.147"	-2147	-3147	-A147	-B147
0.1006"	-2006	-3006	-A006	-B006	0.148"	-2148	-3148	-A148	-B148
0.1007"	-2007	-3007	-A007	-B007	0.149"	-2149	-3149	-A149	-B149
0.1008"	-2008	-3008	-A008	-B008	0.150"	-2315	-3315	-A315	-B315
0.1009"	-2009	-3009	-A009	-B009	0.160"	-2316	-3316	-A316	-B316
0.1010"	-2101	-3101	-A101	-B101	0.170"	-2317	-3317	-A317	-B317
0.102"	-2102	-3102	-A102	-B102	0.180"	-2318	-3318	-A318	-B318
0.103"	-2103	-3103	-A103	-B103	0.190"	-2319	-3319	-A319	-B319
0.104"	-2104	-3104	-A104	-B104	0.200"	-2320	-3320	-A320	-B320
0.105"	-2105	-3105	-A105	-B105	0.250"	-2325	-3325	-A325	-B325
0.106"	-2106	-3106	-A106	-B106	0.300"	-2330	-3330	-A330	-B330
0.107"	-2107	-3107	-A107	-B107	0.350"	-2335	-3335	-A335	-B335
0.108"	-2108	-3108	-A108	-B108	0.400"	-2340	-3340	-A340	-B340
0.109"	-2109	-3109	-A109	-B109	0.420"	-2420	-3420	-A420	-B420
0.110"	-2110	-3110	-A110	-B110	0.450"	-2345	-3345	-A345	-B345
0.111"	-2111	-3111	-A111	-B111	0.500"	-2350	-3350	-A350	-B350
0.112"	-2112	-3112	-A112	-B112	0.550"	-2355	-3355	-A355	-B355
0.113"	-2113	-3113	-A113	-B113	0.600"	-2360	-3360	-A360	-B360
0.114"	-2114	-3114	-A114	-B114	0.605"	-2605	-3605	-A605	-B605
0.115"	-2115	-3115	-A115	-B115	0.625"	-2625	-3625	-A625	-B625
0.116"	-2116	-3116	-A116	-B116	0.650"	-2365	-3365	-A365	-B365
0.117"	-2117	-3117	-A117	-B117	0.700"	-2370	-3370	-A370	-B370
0.118"	-2118	-3118	-A118	-B118	0.710"	-2710	-3710	-A710	-B710
0.119"	-2119	-3119	-A119	-B119	0.750"	-2375	-3375	-A375	-B375
0.120"	-2120	-3120	-A120	-B120	0.800"	-2380	-3380	-A380	-B380
0.121"	-2121	-3121	-A121	-B121	0.815	-2815	-3815	-A815	-B815
0.122"	-2122	-3122	-A122	-B122	0.850"	-2385	-3385	-A385	-B385
0.123"	-2123	-3123	-A123	-B123	0.900"	-2390	-3390	-A390	-B390
0.124"	-2124	-3124	-A124	-B124	0.920"	-2920	-3920	-A920	-B920
0.125"	-2125	-3125	-A125	-B125	0.950"	-2395	-3395	-A395	-B395
0.126"	-2126	-3126	-A126	-B126	1.000"	-2100	-3100	-A100	-B100
0.127"	-2127	-3127	-A127	-B127	2.000"	-2200	-3200	-A200	-B200
0.128"	-2128	-3128	-A128	-B128	3.000"	-2300	-3300	-A300	-B300
0.129"	-2129	-3129	-A129	-B129	4.000"	-2400	-3400	-A400	-B400
0.130"	-2130	-3130	-A130	-B130	5.000"	-2500	-3500	-A500	-B500
0.131"	-2131	-3131	-A131	-B131	6.000"	-2600	-3600	-A600	-B600
0.132"	-2132	-3132	-A132	-B132	7.000"	-2700	-3700	-A700	-B700
0.133"	-2133	-3133	-A133	-B133	8.000"	-2800	-3800	-A800	-B800
0.134"	-2134	-3134	-A134	-B134	9.000"	-2901	-3901	-A901	-B901
0.135"	-2135	-3135	-A135	-B135	10.00"	-2910	-3910	-A910	-B910
0.136"	-2136	-3136	-A136	-B136	12.00"	-2912	-3912	-A912	-B912
0.137"	-2137	-3137	-A137	-B137	16.00"	-2916	-3916	-A916	-B916
0.138"	-2138	-3138	-A138	-B138	20.00"	-2921	-3921	-A921	-B921
0.139"	-2139	-3139	-A139	-B139					



英制检验证书

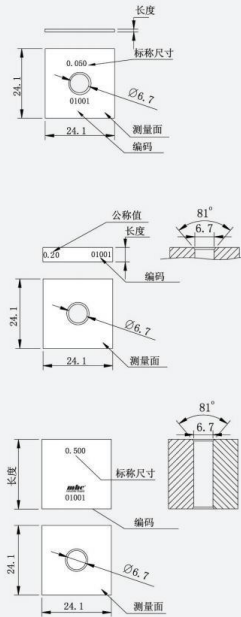


公制检验证书



Size

尺寸



Individual Square Gage Blocks

方形块规



630-XXXX for Steel

Size	Grade 0	Grade AS-1	Grade AS-2	Grade Economy	Size	Grade 0	Grade AS-1	Grade AS-2	Grade Economy
Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.	Order No.
0.100"	-7000	-6000	-C000	-5202	0.131"	-7131	-6131	-C131	-5243
0.1001"	-7001	-6001	-C001	-5204	0.132"	-7132	-6132	-C132	-5244
0.1002"	-7002	-6002	-C002	-5205	0.133"	-7133	-6133	-C133	-5245
0.1003"	-7003	-6003	-C003	-5206	0.134"	-7134	-6134	-C134	-5246
0.1004"	-7004	-6004	-C004	-5207	0.135"	-7135	-6135	-C135	-5247
0.1005"	-7005	-6005	-C005	-5208	0.136"	-7136	-6136	-C136	-5248
0.1006"	-7006	-6006	-C006	-5209	0.137"	-7137	-6137	-C137	-5249
0.1007"	-7007	-6007	-C007	-5210	0.138"	-7138	-6138	-C138	-5250
0.1008"	-7008	-6008	-C008	-5211	0.139"	-7139	-6139	-C139	-5251
0.1009"	-7009	-6009	-C009	-5212	0.140"	-7140	-6140	-C140	-5252
0.1010"	-7101	-6101	-C101	-5213	0.141"	-7141	-6141	-C141	-5253
0.102"	-7102	-6102	-C102	-5214	0.142"	-7142	-6142	-C142	-5254
0.103"	-7103	-6103	-C103	-5215	0.143"	-7143	-6143	-C143	-5255
0.104"	-7104	-6104	-C104	-5216	0.144"	-7144	-6144	-C144	-5256
0.105"	-7105	-6105	-C105	-5217	0.145"	-7145	-6145	-C145	-5257
0.106"	-7106	-6106	-C106	-5218	0.146"	-7146	-6146	-C146	-5258
0.107"	-7107	-6107	-C107	-5219	0.147"	-7147	-6147	-C147	-5259
0.108"	-7108	-6108	-C108	-5220	0.148"	-7148	-6148	-C148	-5260
0.109"	-7109	-6109	-C109	-5221	0.149"	-7149	-6149	-C149	-5261
0.110"	-7110	-6110	-C110	-5222	0.150"	-7315	-6315	-C315	-5262
0.111"	-7111	-6111	-C111	-5223	0.200"	-7320	-6320	-C320	-5267
0.112"	-7112	-6112	-C112	-5224	0.250"	-7325	-6325	-C325	-5268
0.113"	-7113	-6113	-C113	-5225	0.300"	-7330	-6330	-C330	-5269
0.114"	-7114	-6114	-C114	-5226	0.350"	-7335	-6335	-C335	-5270
0.115"	-7115	-6115	-C115	-5227	0.400"	-7340	-6340	-C340	-5271
0.116"	-7116	-6116	-C116	-5228	0.450"	-7345	-6345	-C345	-5272
0.117"	-7117	-6117	-C117	-5229	0.500"	-7350	-6350	-C350	-5273
0.118"	-7118	-6118	-C118	-5230	0.550"	-7355	-6355	-C355	-5274
0.119"	-7119	-6119	-C119	-5231	0.600"	-7360	-6360	-C360	-5275
0.120"	-7120	-6120	-C120	-5232	0.650"	-7365	-6365	-C365	-5276
0.121"	-7121	-6121	-C121	-5233	0.700"	-7370	-6370	-C370	-5277
0.122"	-7122	-6122	-C122	-5234	0.750"	-7375	-6375	-C375	-5278
0.123"	-7123	-6123	-C123	-5235	0.800"	-7380	-6380	-C380	-5279
0.124"	-7124	-6124	-C124	-5236	0.850"	-7385	-6385	-C385	-5280
0.125"	-7125	-6125	-C125	-5237	0.900"	-7390	-6390	-C390	-5281
0.126"	-7126	-6126	-C126	-5238	0.950"	-7395	-6395	-C395	-5282
0.127"	-7127	-6127	-C127	-5239	1.000"	-7100	-6100	-C100	-5283
0.128"	-7128	-6128	-C128	-5240	2.000"	-7200	-6200	-C200	-5284
0.129"	-7129	-6129	-C129	-5241	3.000"	-7300	-6300	-C300	-5285
0.130"	-7130	-6130	-C130	-5242	4.000"	-7400	-6400	-C400	-5286

GAGE BLOCK SETS

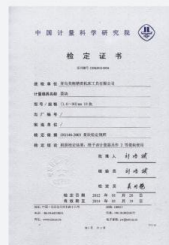
Metric Gage Block Sets

公制套装块规



Piece/Set	Nominal Sizes (mm)	Steps(mm)	No. Of Blocks	Grade	Steel Order No.	Solid Carbide	Ceramic Order No.
112	1.005	—	1	0	630-1120	125-5120	631-1120
	1.001-1.009	0.001	9	1	630-1121	125-5121	631-1121
	1.01-1.49	0.01	49	2	630-1122	125-5122	631-1122
	0.5-24.5	0.5	49	3	630-1123		
	25-100	25	4				
103	1.005	—	1	0	630-1030	125-5030	631-1030
	1.01-1.49	0.01	49	1	630-1031	125-5031	631-1031
	0.5-24.5	0.5	49	2	630-1032	125-5032	631-1032
	25-100	25	4	3	630-1033		
88	1.005	—	1	0	630-0880	125-4880	631-0880
	1.001-1.009	0.001	9	1	630-0881	125-4881	631-0881
	1.01-1.49	0.01	49	2	630-0882	125-4882	631-0882
	0.5-9.5	0.5	19	3	630-0883		
	10-100	10	10				
87	1.001-1.009	0.001	9	0	630-0870	125-4870	631-0870
	1.01-1.49	0.01	49	1	630-0871	125-4871	631-0871
	0.5-9.5	0.5	19	2	630-0872	125-4872	631-0872
	10-100	10	10	3	630-0873		
83	1.005	—	1	0	630-0830	125-4830	631-0830
	1.01-1.49	0.01	49	1	630-0831	125-4831	631-0831
	1.6-1.9	0.1	4	2	630-0832	125-4832	631-0832
	0.5-9.5	0.5	19	3	630-0833		
	10-100	10	10				
76	1.005	—	1	0	630-0760	125-4760	631-0760
	1.01-1.49	0.01	49	1	630-0761	125-4761	631-0761
	0.5-9.5	0.1	19	2	630-0762	125-4762	631-0762
	10-50	10	5				
	75-100	25	2				
47	1.005	—	1	0	630-0474	125-4474	631-0470
	1.01-1.09	0.01	9	1	630-0475	125-4475	631-0471
	1.1-1.9	0.1	9	2	630-0476	125-4476	631-0472
	1-24	1	24	3	630-0477		
	25-100	25	4				

- Metric Gage Blocks meet GGG-G-15, DIN, & JIS Specifications asresupplied as indicated in the table.



检定证书



检定证书

Planer&Shaper Gage

量块支架

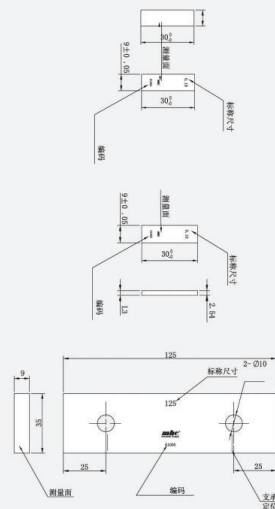


Order NO.600-0049

- Max.Range 1/4-6-1/4"with extension rod.
- Makes setting of planer and shaper tools easy.
- Set gage with micrometer, surface gage or caliper and bring cutting tool in contact with it.
- Gives the operator a reliable starting point,thus eliminating trial cuts.Also use in conjunction with dial indicator to level large plate for planing,etc.

Size

尺寸



Piece/Set	Nominal Sizes (mm)	Steps(mm)	No. Of Blocks	Grade	Steel Order No.	Solid Carbide	Ceramic Order No.
47	1.005	—	1	0	630-0470	125-4470	631-0474
	1.01-1.20	0.01	20	1	630-0471	125-4471	631-0475
	1.3-1.9	0.1	7	2	630-0472	125-4472	631-0476
	1-9	1	9	3	630-0473		
	10-100	10	10				
46	1.001-1.009	0.001	9	0	630-0460	125-4460	631-0460
	1.01-1.09	0.01	9	1	630-0461	125-4461	631-0461
	1.1-1.9	0.1	9	2	630-0462	125-4462	631-0462
	1-9	1	9	3	630-0463		
	10-100	10	10				
38	1.005	—	1	0	630-0380	125-4380	631-0380
	1.01-1.09	0.01	9	1	630-0381	125-4381	631-0381
	1.1-1.9	0.1	9	2	630-0382	125-4382	631-0382
	1-9	1	9	3	630-0383		
	10-100	10	10				
32	1.005	—	1	0	630-0320	125-4320	631-0320
	1.01-1.09	0.01	9	1	630-0321	125-4321	631-0321
	1.1-1.9	0.1	9	2	630-0322	125-4322	631-0322
	1-9	1	9	3	630-0323		
	10-30	10	3				
18	0.991-0.999	0.001	9	0	630-0180		
	1.001-1.009	0.001	9	1	630-0181		
			2	2	630-0182		
			3	3	630-0183		
			4	0	630-0130		631-0130
13	2.5-12.9	2.6	5	0	630-0130		631-0131
	15-22.8	2.6	4	1	630-0131		
	25.0-100.0	25					
	25, 50, 75	25		0	630-8300		
	80, 105, 130	25		1	630-8301		
12	155, 180, 205, 300	25		2	630-8302		
		25					
	10, 20, 41.2, 51.2, 81.2, 101.2, 121.5, 121.8, 125, 175, 250	2.6		0	630-0110		
		2.6		1	630-0111		
10	2.5-12.9	2.6	5	0	630-0100		
	15-22.8	2.6	4	1	630-0101		631-0101
	25	25	1	2	630-0102		631-0102
			3	3	630-0103		
			0	0	630-0090		
9	1.001-1.009	0.001	9	0	630-0090		
			1	1	630-0091		
			2	2	630-0092		
			3	3	630-0093		
			0	0	630-0080		631-0080
8	10, 20, 41.2, 51.2, 81.2, 101.2, 121.5, 121.8	2.6		1	630-0081		631-0081



GAGE BLOCK ACCESSORIES

Rectangular Gage Block Accessories

矩形块规附件

14 pcs Set
Order No. 631-2914



27 pcs Set
Order No. 631-2927



Description	Qty.	Order No.	
Base Block: Gage Block mounting surface lapped flat & parallel with base Base Size: 4x2-3/4x1-3/8", Accuracy: +/- .0002" Height.	1	631-2802	*
Scriber Point: Used for scribing lines, (1.950" Long), Accuracy: Flatness per 2"=.00002".	1	631-2500	*
Center Point: Used for locating centers, (2.0000" Overall Length), Accuracy: Concentricity=+/- .0004".	1	631-2600	*
Points: Used for Checking graduations, (2.050" Long), Accuracy: Concentricity=+/- .0002".	Pair	631-2601	*
Cylindrical Jaws: Used for inside & outside measurements & setting instruments' Accuracy .100"Radius, 1.580" Length, Accuracy: Radius +/- .00003", Pair +/- .00004"	Pair	631-2311	**
.200"Radius, 1.965" Length, Accuracy: Radius +/- .00003", Pair +/- .00004"	Pair	631-2312	**
.250"Radius, 2.366" Length, Accuracy: Radius +/- .00003", Pair +/- .00004"	Pair	631-2313	**
.500"Radius, 2.945" Length, Accuracy: Radius +/- .00003", Pair +/- .00004"	Pair	631-2314	**
.750"Radius, 4.920" Length, Accuracy: Radius +/- .00003", Pair +/- .00004"	Pair	631-2315	*
Flat Jaw: Two Sizes Lapped & Accurately Flat, Parallel & to Size. 0.75" Height, 6" Long, Accuracy, Parallelism = .00004"	Pair	631-2320	*
Jaw with Reference Jaw Lines: Used for spacing blocks within limits .394" Height, 1.970" Length .0625" Ref.Line (etched on block), Accuracy of Reference Line to Measuring Surface, +/- .0002"	Pair	631-2330	**
Jaw with Beveled Ends: .750" Height, 4" Long, Accuracy, Flatness per 2"=.00002"	Pair	631-2331	**
.750" Height, 6" Long, Accuracy, Flatness per 2"=.00002"	Pair	631-2332	**
Holders			
Holder, 2.250"/50mm Capacity, 4.175" Long, Accuracy, Flatness per 2"=.00002"	1	631-2050	**
Holder, 4.000"/100mm Capacity, 6.5" Long, Accuracy, Flatness per 2"=.00002"	1	631-2100	*
Holder, 6.000"/150mm Capacity, 8.5" Long, Accuracy, Flatness per 2"=.00002"	1	631-2150	**
Holder, 10.000"/250mm Capacity, 12" Long, Accuracy, Flatness per 2"=.00002"	1	631-2220	*
Holder, 16.000"/400mm Capacity, Accuracy, Accuracy, Flatness per 2"=.00002"	1	631-2240	*
Accessories Sets			
14-pc Rectangular Gage Block Accessory Set with Wooden Case	Included all ****	631-2914	
27-pc Rectangular Gage Block Accessory Set with Wooden Case	Included all ****, ****	631-2927	

Special Features:

- Base block: Mounting surface lapped flat and parallel with base. Holds blocks with extreme accuracy for scribing & measuring.
- Width of jaws: .315" on Scriber point for scribing lines 1.950" long & .750" height 6" long jaws with beveled ends.
- Accessories made with gage block accuracy.

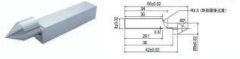
Base Block



Holder



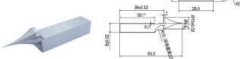
Center Point



Scriber Point



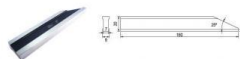
Point



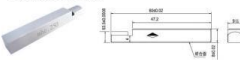
Flat Jaw



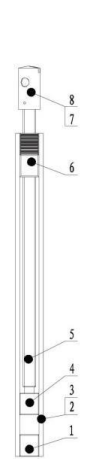
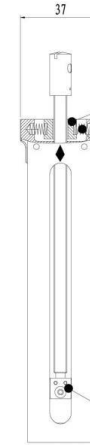
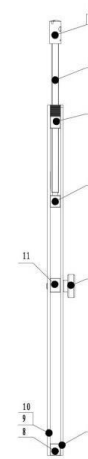
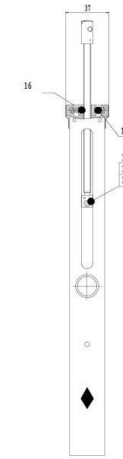
Jaw w/Beveled End



Cylindrical Jaw



Reference Jaw



序号	名称	数量
16	固定导向块	1
15	弹簧	2
14	定位销	2
13	螺钉	1
12	导向块	1
11	可拆卸夹块	1
10	定位销	2
9	主板2	1
8	固定夹板	1
7	固定销	1
6	丝杆手柄	1
5	传动螺杆	1
4	开合螺母	1对
3	活动夹块	1
2	螺栓连接	1
1	主板1	1

序号	名称	数量
13	固定导向块	1
12	弹簧	2
11	定位销	2
10	螺钉	1
9	导向块	1
8	固定销	1对
7	丝杆手柄	1
6	开合螺母	1对
5	传动螺杆	1
4	活动夹块	1
3	定位销	2
2	主板	1
1	固定夹块	1

Square Gage Block Accessories

套裝方块规

Square Gage Block accessories are made of gage block steel, hardened and finished and meet ASME B89.1.9-2002

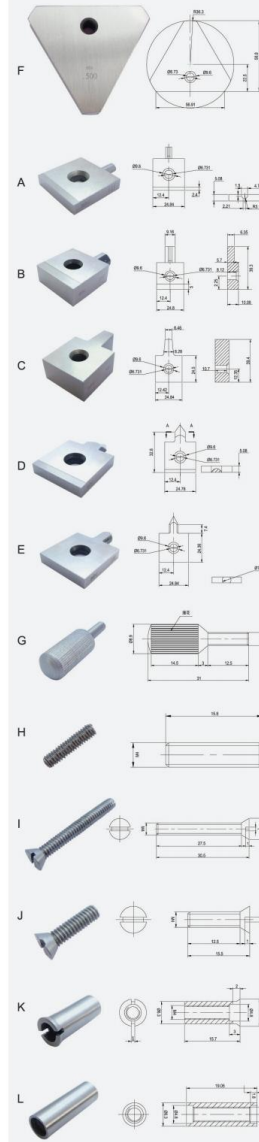
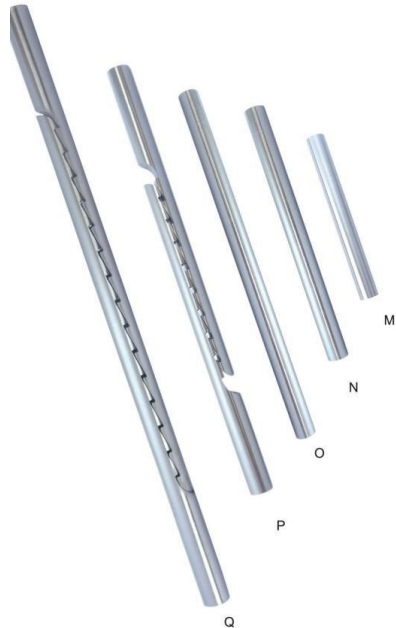
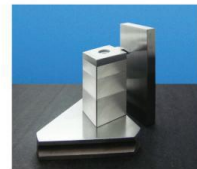
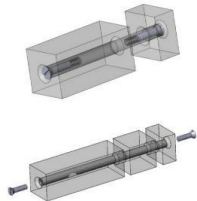
- Available individually or in a complete set.
- Quality & surface finish are unsurpassed.
- Countless numbers of gages can easily be assembled with ultimate accuracy.

25 pcs Set
Order No. 631-2000



GAGE BLOCK ACCESSORIES

Description	Qty.	Order No.
A. Half-round Jaws, .125" Radius, 1 Pair	Pair	631-2002
B. Half-round Jaws, .250" Radius, 1 Pair	Pair	631-2004
C. Straight jaws .500" thick, 1 Pair	Pair	631-2006
D. Scriber point	1	631-2008
E. Center point	1	631-2010
F. Base block	1	631-2012
G. Knurled screws, 1 Pair	Pair	631-2014
H. Studs, 1 Pair	Pair	631-2016
I. Flat head screws-long, 1 Pair	Pair	631-2018
J. Flat head screws-short, 1 Pair	Pair	631-2020
K. Slotted nuts, 1 Pair	Pair	631-2022
L. Tie rod 3/4" Long Solid	1	631-2024
M. Tie rod 1-1/2" Long Solid	1	631-2026
N. Tie rod 2-1/4" Long Solid	1	631-2028
O. Tie rod 3" Long Solid	1	631-2030
P. Tie rod 4 -1/2" Long Adjustable	1	631-2032
Q. Tie rod 6" Long Adjustable	1	631-2034
25-pc Square Gage Block Accessories with wooden case		631-2000



Specifications

Setting Device:

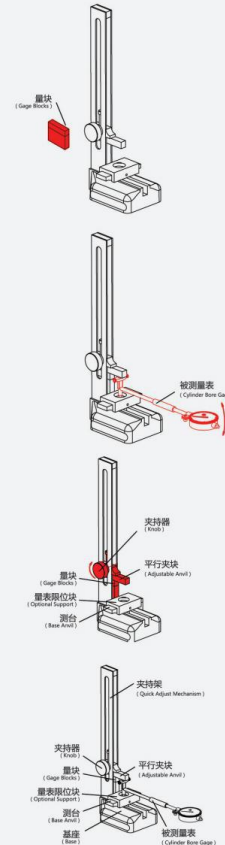
Base Anvil: 2.750" x .80"
Adjustable anvil: 2.375" x .375" (two each)
Internal capacity: 6"
Depth capacity: 1"
Centralizer capacity width: 2.625"
Quick-adjust holder for fast adjustment.

Inch/ Economy Gage Block Set Order No. 612-9103

- 36 piece
- Tolerances to $\pm 0.0005"$
- Certificate of Calibration to N.I.S.T.

Metric/ AS-2 Grade Gage Block Set Order No. 612-9118

- 33 piece
- Maximum tolerance to: $\pm 1.2\mu m$



内径量表标定仪

Please read through this owners manual carefully before using your new tool. Use your tool properly and only for its intended use.



Operating Instructions:

- For best accuracy, remove all excess preservative from the gage blocks and base anvil (A) before use.
 - After determining the desired bore size to be measured with your cylinder bore gage, choose the appropriate combination of gage blocks to match the bore dimension.
 - Insert the gage blocks into the vertical column of the Bore Gage Setting Master Kit. The column features a quick adjust (B) mechanism to facilitate rapid movement of the clamping mechanism.
 - Add an adjustable anvil (C) as shown in the photo. Loosen the quick adjust knob and lower the mechanism down on to the adjustable anvil. With fingers on either side of the quick adjust (D), compress the spring with moderate pressure. Turn the knob (D) and lock in place the complete the setup.
 - Choose the appropriate spacer/post combination on your cylinder bore gage to set the bore gage to the desired range of measurement.
 - Insert the cylinder bore gage into the Bore Gage Setting Master Kit and while rocking the bore gage up and down, determine the reversal point of the bore gage. If you are using a dial cylinder bore gage, turn the bezel of the indicator to set zero to the reversal point. If you are using an electronic cylinder bore gage, the sum of the gage blocks should be programmed into the indicator and preset to size after the reversal point is determined.
- * Care should be taken to ensure the bore gage is kept as vertical as possible and not tilted to either side while rocking the bore gage, which could result in a false reading. It is also recommended to sweep the bore at least one time after the initial setting to insure a good repeatable measurement.**
- It is recommended to keep a light coat of preservative on the gage blocks and base anvil while the gage is being stored to reduce the possibility of corrosion.

使用步骤

- 为达到较高的测量精度，在使用之前，请将量块和测台 (A) 清理干净。
- 根据被测内径量表的量程，正确选择并组合量块。
- 将组合好的量块放入夹持架中，夹持架中装有一套快速夹持器 (B) 可以快速移动并加紧。
- 装入平行夹块 (C)，松开夹持器螺母，向下移动夹持器接触到平行夹块，用两手指向下压夹持器，使其弹簧具有适当的加紧压力，然后锁紧夹持器上的螺母 (D)。
- 根据测量范围的需要，将正确的测头安装在内径量表上。
- 将被校准内径量表放入内径量表标定仪的平行夹块与测台之间，上下摇动内径量表，以确定回转点。如果被测内径量表是指针式，应该将回转点表盘指针调整成零；如果被测内径量表为电子数字显示，在回转点上将组合量块的数值预置入系统。

注意：在上下摇动内径量表时，应尽可能保持表的上下垂直摇动，否则会影响标定结果。建议最少重复标定一次以确定其标定结果的重复性。

7、建议在存放时，使用布罩将本仪器和量块罩住，以遮挡灰尘。

本内径量表标定仪可以精确标定6"以内量程的内径量表，标定误差在0.0001"以内。本设备较之环规及百分表标定方式具有简单、易操作和精度高的特点。