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Mahr | Precision gages

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# Mahr Inc. Product line update

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Product manager – Precision gages

October 30<sup>th</sup> 2024

# Your presenter



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If you have any questions during the presentation – use the question feature and I will respond to your question after the webinar by email.

A solid red vertical bar is located on the far left side of the slide.

# Agenda

**1** What is a plug gage and where to use it?

**2** Mahr plug gages

**3** Product changes and consolidations

**4** Marameter 844 D plug gages

**5** Marameter 844 D plug gages to Dimetron assembly

**6** How to quote new and replacements

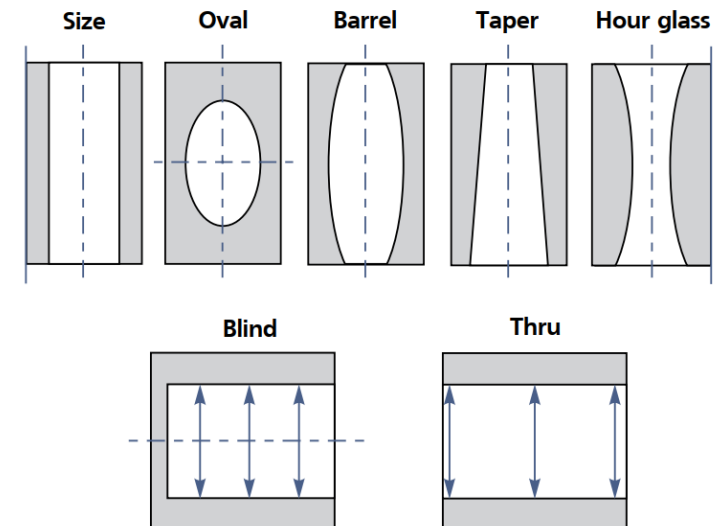
A decorative graphic on the right side of the slide, composed of a grid of small grey dots that form a wavy, ribbon-like shape extending from the bottom left towards the top right.

# What is a plug gage and where to use it?

Plug gages are gaging instruments that determine whether the dimension of a part is smaller or larger than predetermined standards.

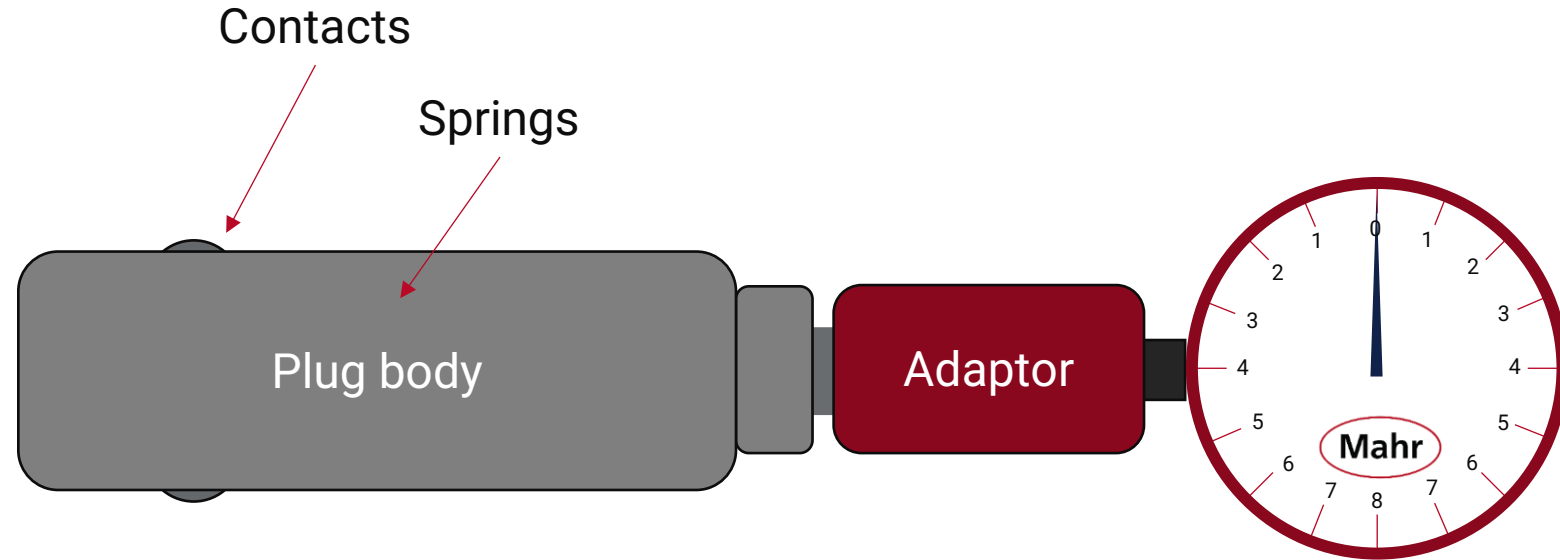
- External standards, i.e. masters
- Tends to be faster and more accurate than measuring hand tools
- Generally, more dedicated to the task

- Tight tolerances
- High accuracy
- High volume parts
- Shop environment
- Little operator skill
- Know part variation
- Low cost to operate
- Portable



# What makes up a plug gage?

- Plug body - Hardened steel cylinder
- Two-point mechanical transfer mechanism
- An adaptor – connection between plug and readout
- A display instrument that relates the transfer motion to diameter
- Setting master



Transfer rod provides 1:1 ratio

As the contacts are compressed the motion forces the transfer the rod back.

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**1** What is a plug gage and where to use it?

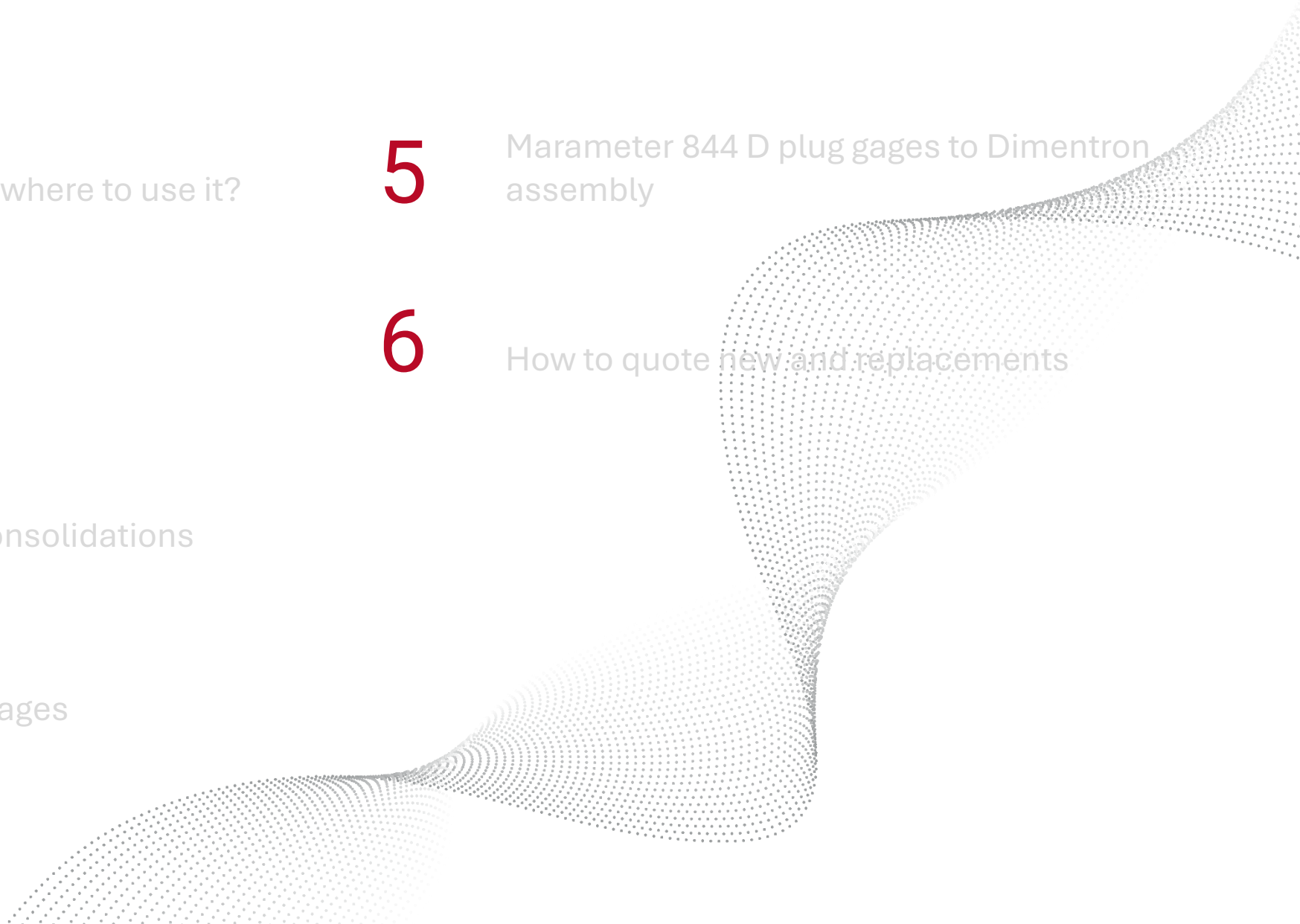
**2** Mahr plug gages

**3** Product changes and consolidations

**4** Marameter 844 D plug gages

**5** Marameter 844 D plug gages to Dimetron assembly

**6** How to quote new and replacements



# Mahr plug gages

## Dimentron

- Made in Providence
- Repairable
- Special applications
- **M12 thread**
  
- Hysterisis  $\leq 0.5\mu\text{m} / 20\mu\text{''}$
- Repeatability  $\leq 1\mu\text{m} / 20\mu\text{''}$
- Linearity  $\leq 2\%$  of measuring range



## Marameter 844 D

- Made in Germany
- Repairable
- Special applications
- **M10 or M6 thread**
  
- Hysterisis  $\leq 0.4\mu\text{m} / 16\mu\text{''}$
- Repeatability  $\leq 1\mu\text{m} / 40\mu\text{''}$
- Linearity  $\leq 1\%$  of measuring range



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**1** What is a plug gage and where to use it?

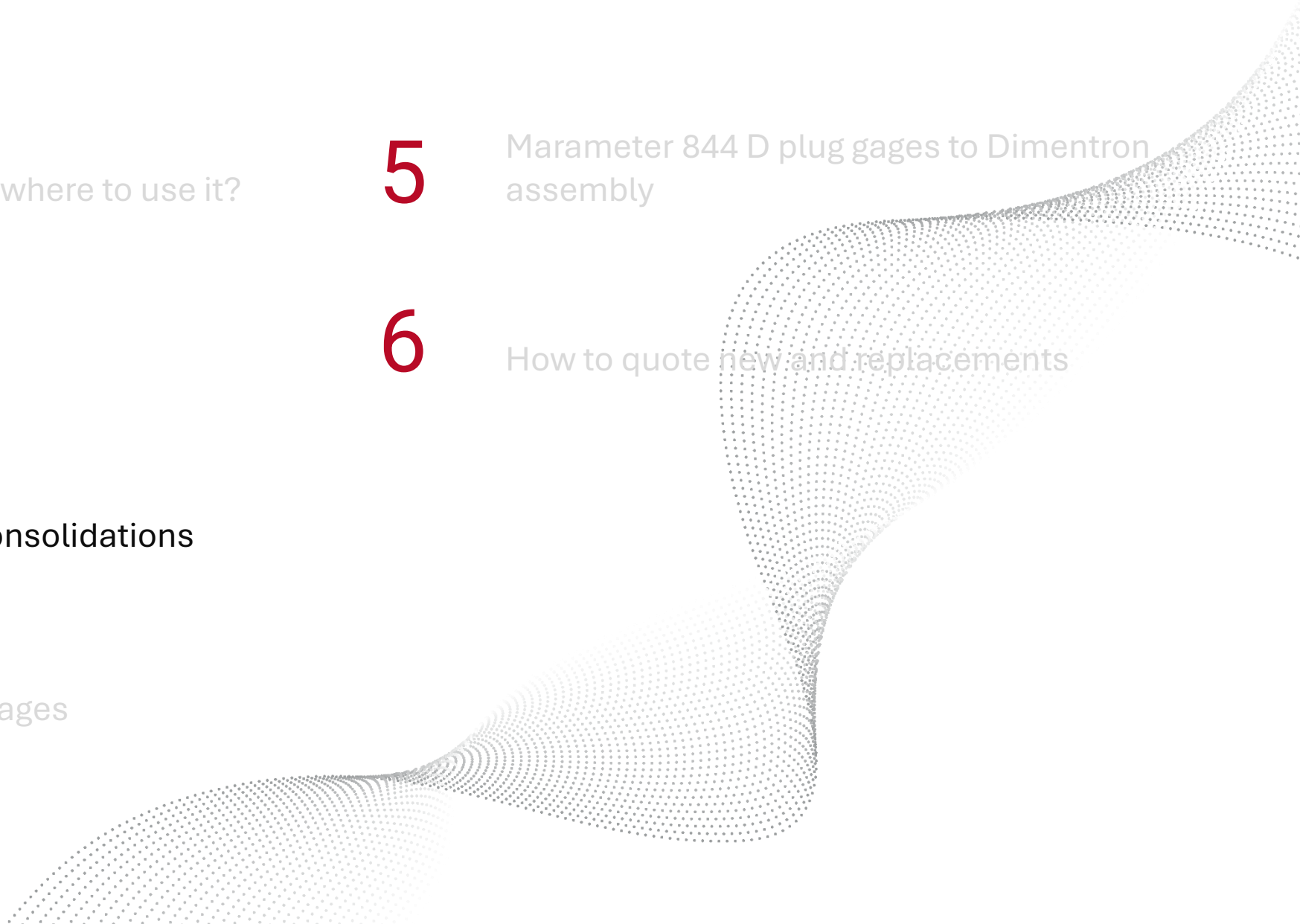
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# Product changes and consolidations

## Dimentron / 844 D Plug Gages

- Dimentron and the 844 D are successful fixed plug gaging products
  - High performance, fast and easy to use, can be used with many different digital readout options
  - They represent a duplicate product line
- The 844 D has been updated with improved offering, better deliveries, more standard options and at pricing to allow Mahr to be more competitive
- **Going forward the 844 D is the plug gage for all plug gage applications.**



# Product changes and consolidations



## Product Consolidation

- Mahr Inc. has adaptors to use new 844 D plugs in existing Dimentron holders.
- Mahr Inc. can supply “special” Dimentron style plugs.
- Spare parts – levers, Vee Rods, contacts for Dimentron will be maintained.

Standard .250” Plug Gage



\$745



\$585

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# Marameter 844 D bore gages

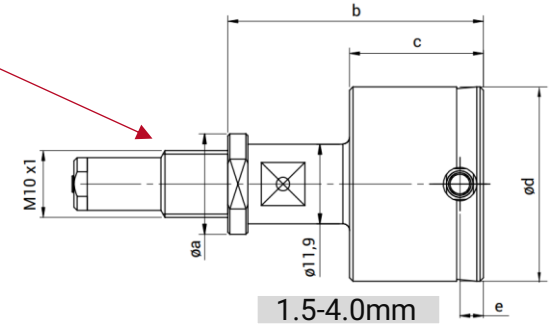
## 3 basic types

- 844 D
  - For blind bores



Measuring range: 200 $\mu$ m / 0.0078"

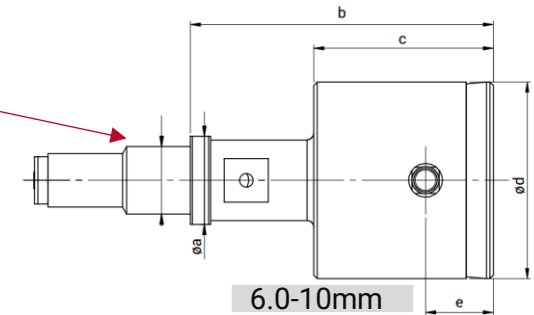
M10 x 1.0  
M6 x 0.75



- 844 DR
  - For thru bores



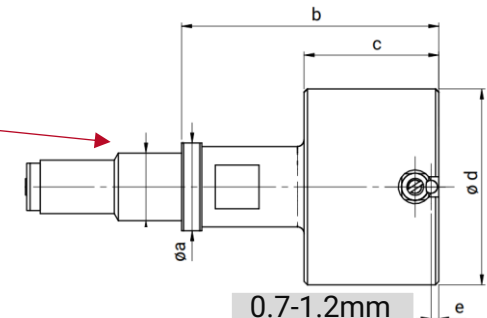
M10 x 1.0  
M6 x 0.75



- 844 DS
  - For super blind bores



M10 x 1.0  
M6 x 0.75



# Marameter 844 D bore gages

- 844 D-C / 844 DR-C / 844 DS-C

**Chrome plated contacts:** for soft, porous materials such as aluminum.

- 844 D-R / 844 DR-R / 844 DS-R

**Ruby contacts:** for when part marring must be prevented.

- 844 D-D / 844 DR-D

**Diamond contacts:** for abrasive material or extreme high usage applications.

- 844 D-FD / 844 DR-FD

**Different front contact centerline "e":** reducing the guide plug body to measure closer, or at a defined position.

- 844 D-M / 844 DR-M / 844 DS-M

**Extended measuring range:** for measuring large tolerances,  $600\mu\text{m} / 0.024\mu\text{"}.$

- 844 D-HR / 844 DR-HR / 844 DS-HR

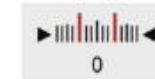
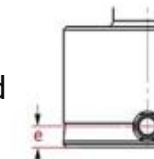
**High Resolution for tight tolerances:** for measuring bores with tight tolerances, less than  $10\mu\text{m}.$  minimum body clearance.

- 844 DS-F

**Only with front chamfer:** for measuring very short blind bores.

- 844 D-3 / 844 DR-3

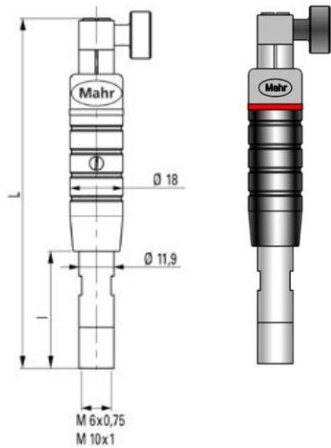
**3-point contacts (3 x 120°):** for fast measurement of interrupted diameters and detection of form error in polygons.



Size		Radius of contact	
From (mm)	To	mm	inch
2.5	3	0.4	0.016
3.1	3.4	0.6	0.024
3.4	4	0.7	0.028
4.1	4.8	0.85	0.033
4.9	5.6	1	0.039
5.7	6	1.1	0.043
6.1	20	1.2	0.047
20.1	60	1.5	0.059
60.1	500	2.5	0.098

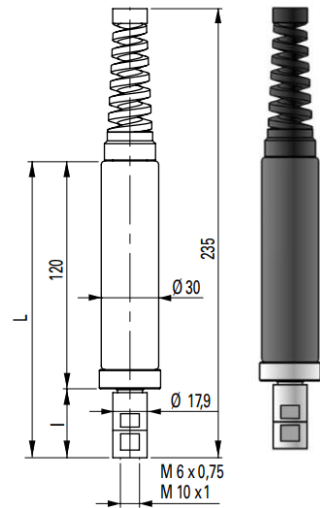
# Marameter 844 D Accessories

## HOLDERS FOR INDICATORS



Order no.	Connection thread	Dimension L	d1	d2	l
		mm	mm	mm	mm
4484750	M10 x 1	59	11.9	18	11
4484751	M10 x 1	83	11.9	18	36
4484752	M6 x 0.75	109	11.9	18	30
4484753	M10 x 1	109	11.9	18	40
4484754	M6 x 0.75	239	11.9	18	137
4484755	M10 x 1	249	11.9	18	147
4484756	M10 x 1	154	17.9	26	38
4484757	M10 x 1	244	17.9	26	128
4484758	M10 x 1	59	11.9	18	11
4484759	M10 x 1	109	11.9	18	30

## HOLDER FOR INDUCTIVE PROBES

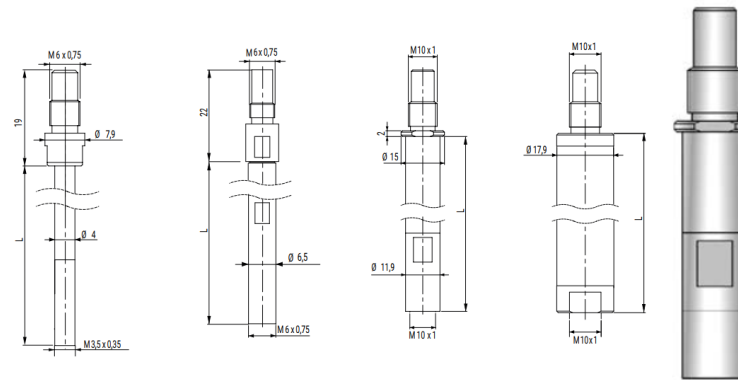


P2004 M



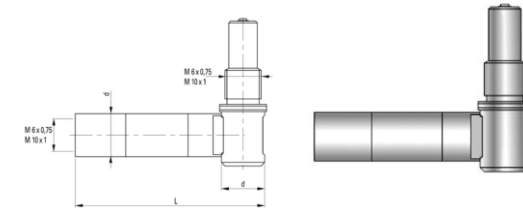
C 1200 M

## EXTENSIONS



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

## RIGHT ANGLE ADAPTOR



Order no.	Type	Dimension L	d	Connection thread
		mm	mm	
4473409	844 Kw	29	7.9	M6 x 0.75
4484790	844 Dw	53	11.9	M10x1
4484791	844 Dv	56	17.9	M10x1

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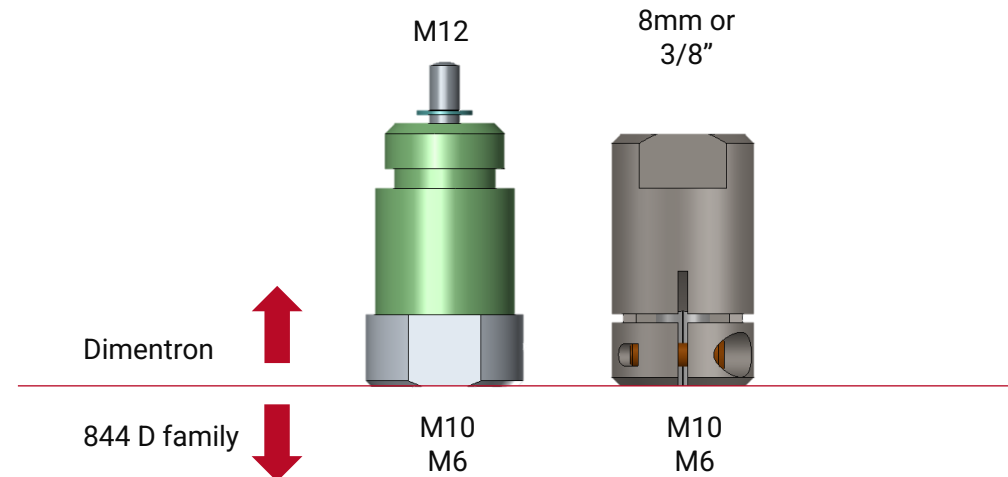
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# Marameter 844 D bore gages to Dimentron assembly

- Will my current Dimentron assembly work with 844D family plugs?
  - **Dimentron** plugs and accessories use **M12** thread
  - Marameter **844D** plugs and accessories use **M6** or **M10** thread
- Mahr has adaptors that will allow the 844D plugs to work with the existing Dimentron setup.



Part number	Description 1	Description 2
2064894	ADAPTER ASSY, 844D SERIES 10 TO EKT-1120	M10 to M12
2064893	ADAPTER ASSY, 844D SERIES 6.0 TO EKT-1120	M6 to M12
2263799	ADAPTER KIT, 844D, M10X1.0 THREAD	M10
2263800	ADAPTER KIT, 844D, M6 X .75 THREAD	M6



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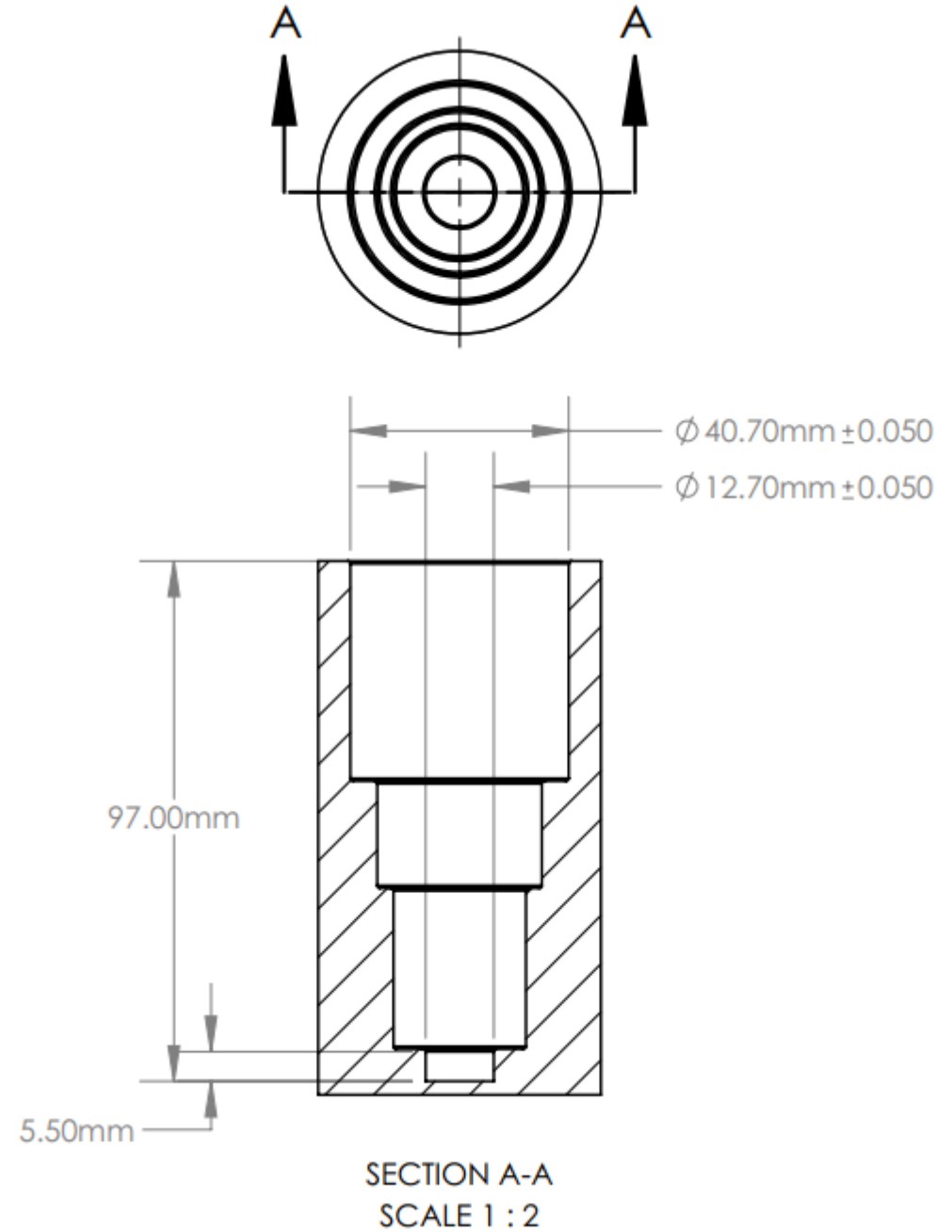
**6** How to quote new and replacements

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# Quoting plug gages

You need to know the:

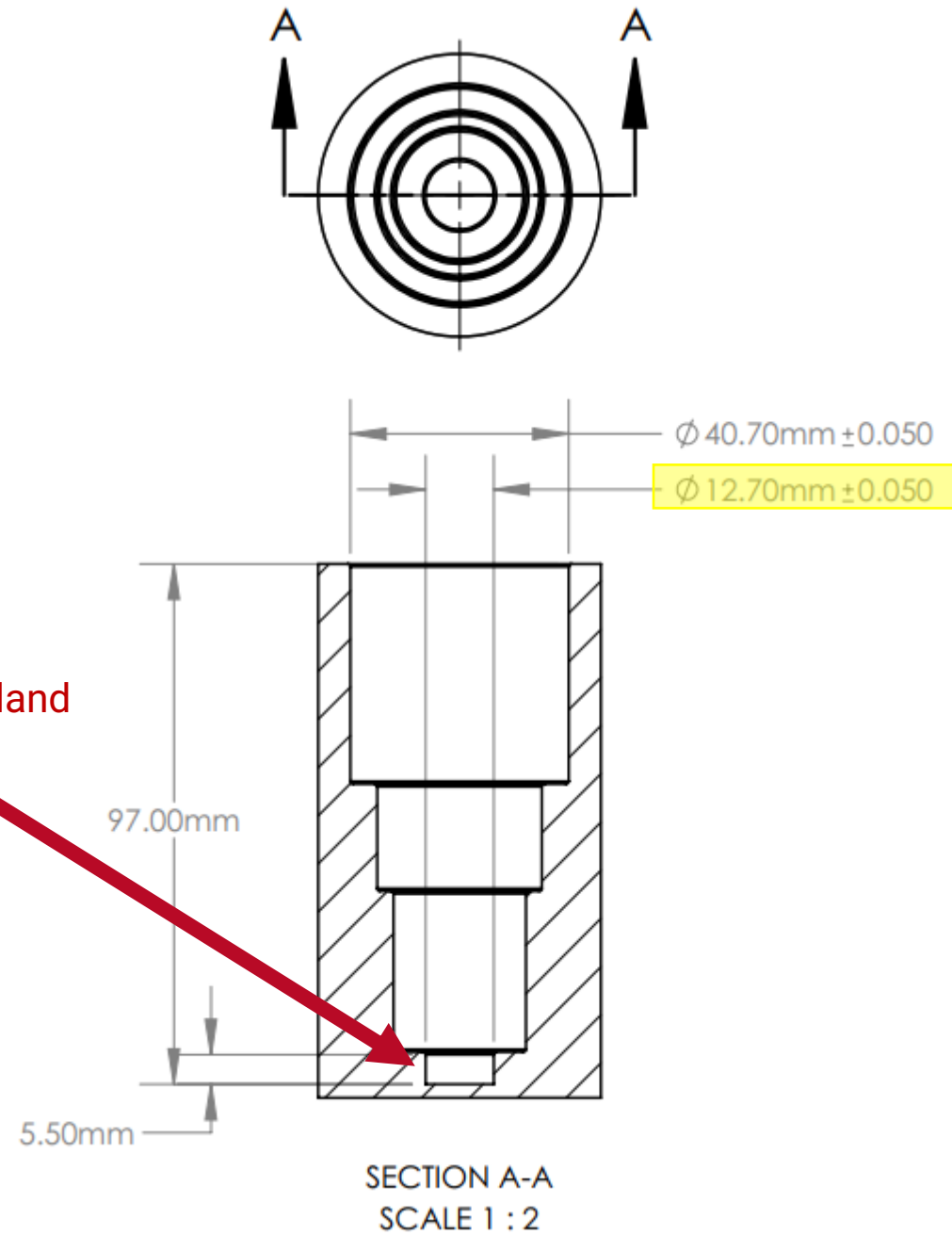
- Size
- Tolerance
- Type of the bore
- Where the measurement is to be made
- Readout



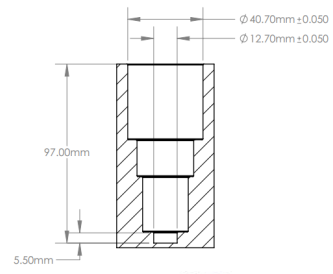
# Quoting plug gages

You need to know the:

- Size: 12.70mm
- Tolerance:  $\pm 50\mu\text{m}$
- Type of the bore: Blind
- Where the measurement is to be made: ~Middle of land
- Readout: 2000 Wi or 1086 Ri



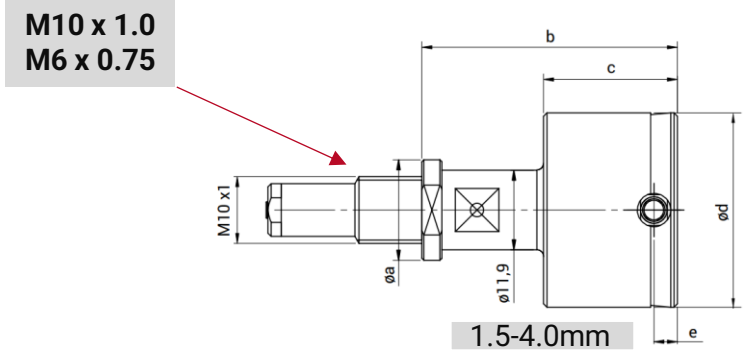
# Marameter 844 D bore gages



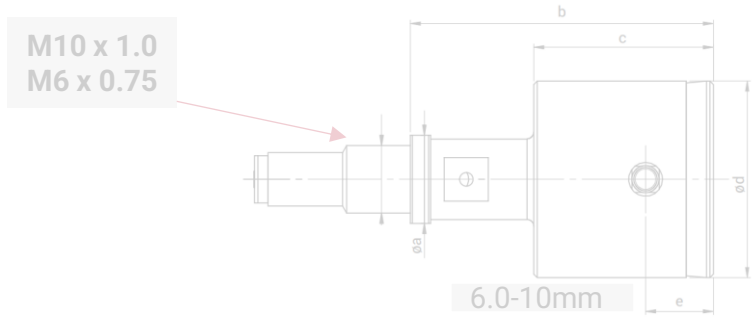
Measuring range: 0.2mm / 0.0078"

## 3 basic types

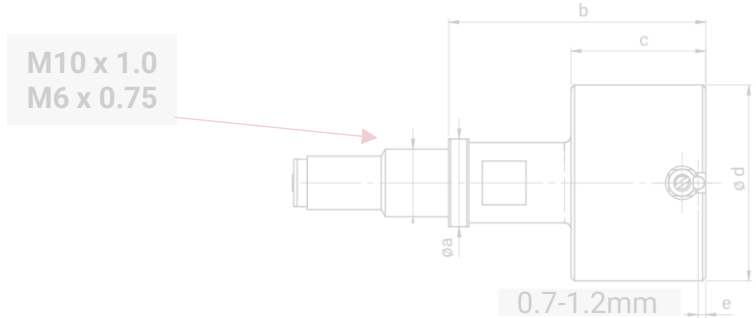
- 844 D
  - For blind bores



- 844 DR
  - For thru bores



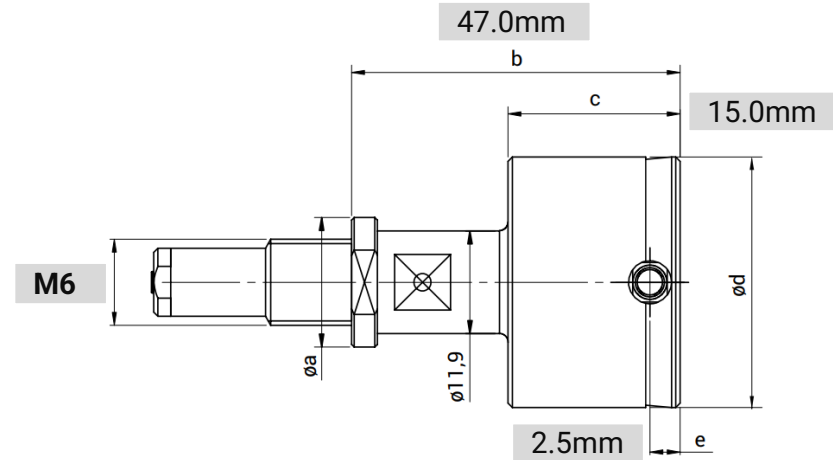
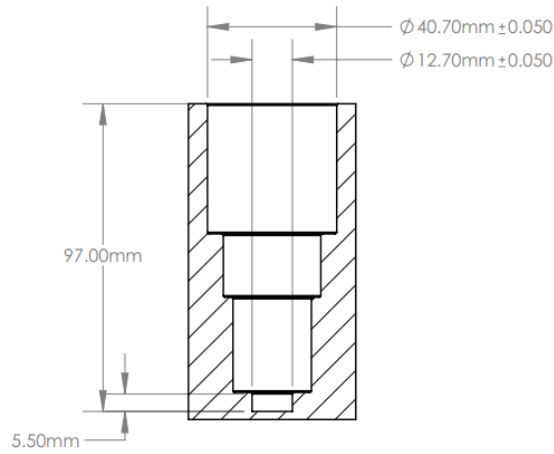
- 844 DS
  - For super blind bores



# Quoting plug gages

## 844 D

- For blind bores



### TECHNICAL DATA

Order no.	Type	Measuring range	Measuring span	Manufacturing tolerance	Linearity deviation	Repeatability $f_w$	a	b	c	e	g	Connection thread
4484007	844 D	2- <3	0.15	-0.015 / -0.025	1 %, min. 1 $\mu\text{m}$	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 $\mu\text{m}$	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 $\mu\text{m}$	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 $\mu\text{m}$	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 $\mu\text{m}$	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 $\mu\text{m}$	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 $\mu\text{m}$	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 $\mu\text{m}$	1	15	37.3	15	2.5		M10x1
4484015	844 D	>20-30	0.2	-0.02 / -0.03	1 %, min. 1 $\mu\text{m}$	1	15	38.2	20	3.5		M10x1
4484016	844 D	>30-40	0.2	-0.02 / -0.03	1 %, min. 1 $\mu\text{m}$	1	15	38.2	20	3.5		M10x1
4484017	844 D	>40-60	0.2	-0.02 / -0.03	1 %, min. 1 $\mu\text{m}$	1	15	38.2	28	3.5		M10x1

A	B	C	D	E
<b>Quick Price Look up</b>				
<b>Enter Order No. Below</b>	<b>Description</b>	<b>Description</b>	<b>DISCOUNT CODE</b>	<b>2024 LIST PRICES</b>
4484012	844 D Plug Gage >12-13 mm	for bore meas., M6x0,75	G09001	\$585.00

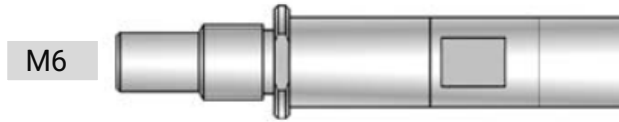
THIS LIST CONTAINS OUR 2024 PRICES WITH NO PROMOTIONS

**VALID 4/1/2024**

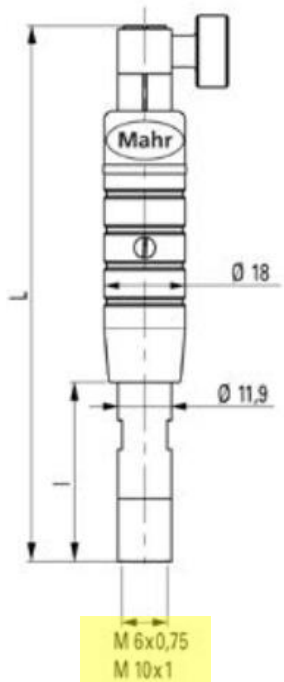
ORDER NO	DESCRIPTION_1	DESCRIPTION_2	DISCOUNT CODE	LIST PRICE
.1250 XX	MASTER RING, .1250 XX, STEEL,	1/4" THK, WITHOUT CERTIFICATION	G13001	218.00
.1560 XX	MASTER RING	WITHOUT CERTIFICATION	G13001	201.00
.1875 XX	MASTER RING, .1875 XX, STEEL,	WITHOUT CERTIFICATION	G13001	217.00
.2500 XX	MASTER RING, .2500 XX, STEEL,	1/4" WITHOUT CERTIFICATION	G13001	189.00
.2500 XXKAL	MASTER RING, .2500 XX, STEEL,	1/4" WITH CERTIFICATION	G13001	269.00
.3125 XX	MASTER RING, .3125 XX, STEEL,	5/16" WITHOUT CERTIFICATION	G13001	189.00
.3125 XXKAL	MASTER RING, .3125 XX, STEEL,	5/16" WITH CERTIFICATION	G13001	269.00
.3750 XX	MASTER RING, .375 XX, STEEL,	3/8" WITHOUT CERTIFICATION	G13001	189.00
.3750 XXKAL	MASTER RING, .375 XX, STEEL,	3/8" WITH CERTIFICATION	G13001	269.00
.4375 XX	MASTER RING, .4375 XX, STEEL,	7/16" WITHOUT CERTIFICATION	G13001	189.00
.4375 XXKAL	MASTER RING, .4375 XX, STEEL,	7/16" WITH CERTIFICATION	G13001	269.00
.5000 XX	MASTER RING, .5000 XX, STEEL,	1/2" WITHOUT CERTIFICATION	G13001	189.00
.5000 XXKAL	MASTER RING, .5000 XX, STEEL,	1/2" WITH CERTIFICATION	G13001	269.00



# Quoting plug gages



## Holders



Order no.	Connection thread	Dimension L	d1	d2	l
		mm	mm	mm	mm
4484750	M10 x 1	59	11.9	18	11
4484751	M10 x 1	83	11.9	18	36
4484752	M6 x 0.75	109	11.9	18	30
4484753	M10 x 1	109	11.9	18	40
4484754	M6 x 0.75	239	11.9	18	137
4484755	M10 x 1	249	11.9	18	147
4484756	M10 x 1	154	17.9	26	38
4484757	M10 x 1	244	17.9	26	128
4484758	M10 x 1	59	11.9	18	11
4484759	M10 x 1	109	11.9	18	30

Quick Price Look up				
Enter Order No. Below	Description	Description	DISCOUNT CODE	2024 LIST PRICES
4484752	844 Dg Holder f. measur. head	length 109 mm, M6 x 0,75	G09001	\$401.00

THIS LIST CONTAINS OUR 2024 PRICES WITH NO PROMOTIONS

**VALID 4/1/2024**

ORDER NO	DESCRIPTION_1	DESCRIPTION_2	DISCOUNT CODE	LIST PRICE
.1250 XX	MASTER RING, .1250 XX, STEEL,	1/4" THK, WITHOUT CERTIFICATION	G13001	218.00
.1560 XX	MASTER RING	WITHOUT CERTIFICATION	G13001	201.00

# Quoting plug gages

## Readout

M 10x1

### ACCESSORIES

Order no.	Description	Type
4334000	Millimess 1 µm, ± 50 µm	1003
4334102	Millimess 0.5 µm, ± 25 µm	1002
4337620	Digital indicator, 0.0005 mm, 12.5 mm	1086 R
4337624	Digital indicator, 0.0005 mm, 12.5 mm	1086 Ri
4337697	Digital indicator, 0.0001 mm, 12.5 mm	1086 R-HR
4346701	Inductive dial comparator ±1 mm	2000 Wi

1086 Ri



2000 Wi



### TECHNICAL DATA

Order no.	4337624	4337625	4337626	4337627	4337628
Type	1086 Ri				
Measuring span	mm	12.5	25	50	100
Measuring span	inch	.5"	1"	2"	4"
Resolution	mm	0.0005, 0.001, 0.002, 0.005, 0.01			
Resolution	inch	.00002", .00005", .0001", .0002", .0005"			
Error limit	mm	0.004	0.007	0.008	0.004
Error limit over 50 graduations	mm	0.002			
Measuring force	N	0.65 -0.9	0.65 -1.15	1.25 -2.7	1.8 -3.5
Standard	Factory standard				
Lifting protection cap	•				

### TECHNICAL DATA

Order no.	4346800	4346801
Type	2001 W	2001 Wi
Measuring range	mm	± 1
Measuring range	inch	± .04"
Resolution	mm	0.0001, 0.0002, 0.0005, 0.001, 0.002, 0.005, 0.01
Resolution	inch	.000005", .00001", .00002", .00005", .0001", .0002", .0005"
Error limit	µm	± (0.2 + L/2) L in mm
Measuring value hysteresis f <sub>v</sub>	µm	0.3
Repeatability f <sub>w</sub>	µm	0.1
Standard	Factory standard	
Free stroke	mm	2.5
Measuring force	N	0.9 ± 0.1 (at the electrical zero point)
Range of analog display	mm	± 0.002, ± 0.004, ± 0.01, ± 0.02, ± 0.04, ± 0.1, ± 0.2
IP protection category	IP 64	
Data interface	USB, Digimatic	Integrated Wireless, USB, Digimatic
Supply voltage	100-240 V	

We can also offer stop collar...

# Quoting plug gages

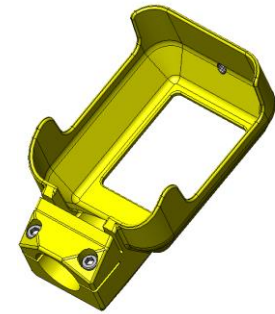
## Note:

- If customer prefers to have a protective housing for their indicator we have adaptors that will allow this

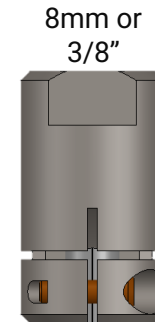
Part number	Description 1	Description 2
2263799	ADAPTER KIT, 844D, M10X1.0 THREAD	M10
2263800	ADAPTER KIT, 844D, M6 X .75 THREAD	M6



SHG-102



EHG-1172



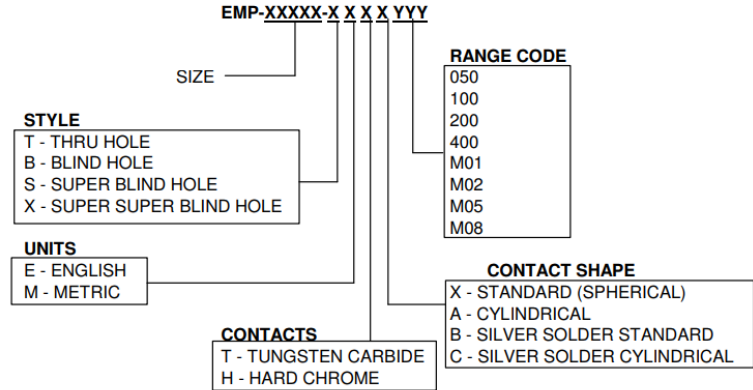
M10  
M6



# Quoting plug gages - replacement



## How Tooling is Identified



EMP – 2.25220- TETX 100

- EMP      **Dimentron plug**
- 2.25220      **Nominal size**
- T      **Thru**
- E      **English**
- T      **Tungsten Carbide**
- X      **Standard contact**
- 100      **Range code**

		Maximum Part Tolerance				
Sizes above	To and include	Metric M01 Inch 050	M02 100	M05 200	M08 400	
3.18 mm/ .1250"	3.62 mm/ .145"	±0.025 mm/ ±.0010"	±0.038 mm/ ±.0015"			
3.62 mm/ .1426"	5.52 mm/ .217"	±0.025 mm/ ±.0010"	±0.046 mm/ ±.0018"	±0.076 mm/ ±.0030"		
5.50 mm/ .2171"	7.94 mm/ .312"	±0.025 mm/ ±.0010"	±0.046 mm/ ±.0018"	±0.069 mm/ ±.0027"	±0.102 mm/ ±.0040"	
7.94 mm/ .3125"	9.5 mm/ .375"	±0.030 mm/ ±.0012"	±0.051 mm/ ±.0020"	±0.069 mm/ ±.0027"	±0.127 mm/ ±.0050"	
9.50 mm/ .3750"	12.7 mm/ .50"	±0.038 mm/ ±.0015"	±0.058 mm/ ±.0023"	±0.086 mm/ ±.0034"	±0.137 mm/ ±.0054"	
12.7 mm/ .5000"	19.05 mm/ .75"	±0.038 mm/ ±.0015"	±0.069 mm/ ±.0027"	±0.102 mm/ ±.0040"	±0.165 mm/ ±.0065"	
19.05 mm/ .750"	25.4 mm/ 1.00"	±0.038 mm/ ±.0015"	±0.076 mm/ ±.0030"	±0.127 mm/ ±.0050"	±0.180 mm/ ±.0071"	
25.4 mm/ 1.000"	38 mm/ 1.50"	±0.038 mm/ ±.0015"	±0.076 mm/ ±.0030"	±0.152 mm/ ±.0060"	±0.221 mm/ ±.0087"	
38 mm/ 1.500"	114.3 mm/ 4.5"		±0.076 mm/ ±.0030"	±0.152 mm/ ±.0060"	±0.254 mm/ ±.0100"	
114.3 mm/ 4.5"	229 mm/ 9.00"			±0.152 mm/ ±.0060"	±0.254 mm/ ±.0100"	

*Order Maxum Indicator and Accessories separately.*

# Quoting plug gages - replacement



844 DR for 2.2522" = 57.206mm

TECHNICAL DATA

EMP – 2.25220- TETX 100

- EMP      **Dimentron plug**
- 2.25220      **Nominal size**
- T          **Thru**
- E          **English**
- T          **Tungsten Carbide**
- X          **Standard contact**
- 100        **Range code**

Order no.	Type	Measuring range	Measuring span	Manufacturing tolerance	Linearity deviation	Repeatability $f_w$	a	b	c	e	g	Connection thread
		mm	mm	mm / mm		$\mu\text{m}$	mm	mm	mm	mm	mm	
4484039	844 DR	4-7	0.2	-0.015 / -0.025	1 %, min. 1 $\mu\text{m}$	1	4	38	14.5	6	31.5	M6 x 0.75 / M3.5x0.35
4484040	844 DR	>7-9	0.2	-0.015 / -0.025	1 %, min. 1 $\mu\text{m}$	1	6.9	50.5	18.5	6	38.5	M6 x 0.75
4484041	844 DR	>9-12	0.2	-0.015 / -0.025	1 %, min. 1 $\mu\text{m}$	1	7.9	54.5	22.5	10	54.5	M6 x 0.75
4484042	844 DR	>12-13	0.2	-0.015 / -0.025	1 %, min. 1 $\mu\text{m}$	1	7.9	54.5	22.5	10	54.5	M6 x 0.75
4484043	844 DR	>13-16	0.2	-0.015 / -0.025	1 %, min. 1 $\mu\text{m}$	1	11.9	54.5	22.5	10	54.5	M6 x 0.75
4484044	844 DR	>16-20	0.2	-0.015 / -0.025	1 %, min. 1 $\mu\text{m}$	1	15	44.8	22.5	10		M10x1
4484045	844 DR	>20-30	0.2	-0.02 / -0.03	1 %, min. 1 $\mu\text{m}$	1	15	44.7	27	10		M10x1
4484046	844 DR	>30-40	0.2	-0.02 / -0.03	1 %, min. 1 $\mu\text{m}$	1	15	44.7	27	10		M10x1
4484047	844 DR	>40-60	0.2	-0.02 / -0.03	1 %, min. 1 $\mu\text{m}$	1	15	44.7	28	10		M10x1



**PN# 4484047**  
**57.206mm ± 76 $\mu\text{m}$**

# Summary

- Bore gages
- Mahr bore gage family
- Product consolidation
- Marameter 844 D bore gages
- Adaptors for 844 D to work with Dimentron
- Quoting new and replacement gages





[www.mahr.com](http://www.mahr.com)

Questions?

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