

DORSEY STANDARD BORE GAGES

sales@willrich.com

STYLE 1 - All sizes utilize the same dial unit housing for extreme versatility.

Size 1
.63" - 1.00"
16mm - 25.4mm

Size 2
1.00"-1.53"
25.4 - 38.9mm

Size 3
1.50"-2.16"
38.1 - 54.8mm

Size 4
2.12"-3.13"
54.0 - 79.5mm

Size 5
3.09"-6.13"
78.5 - 156mm

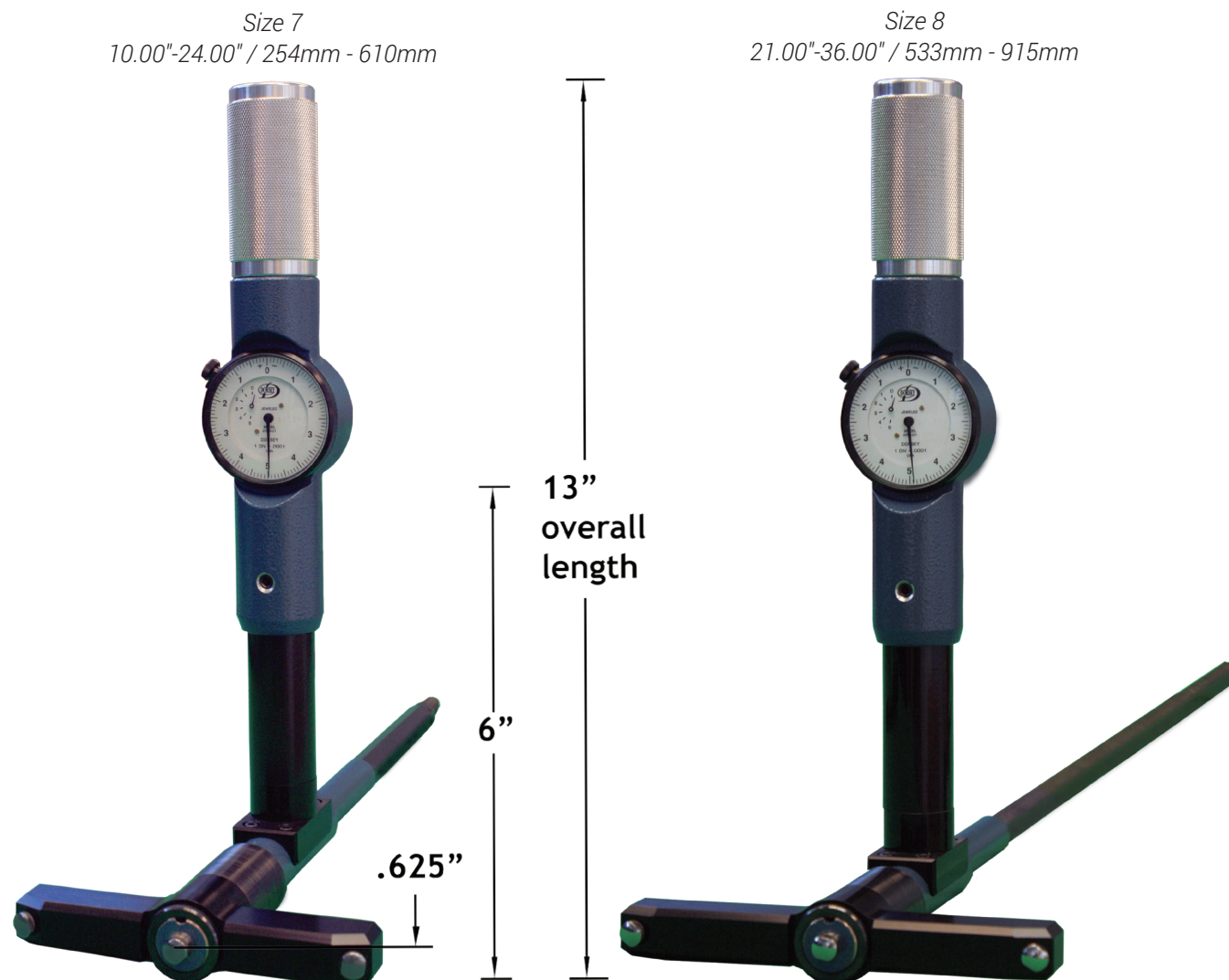
Size 6
6.00"-12.13"
152.5 - 308.0mm



A TIME PROVEN DESIGN EXPANDED TO MEASURE LARGE BORE SIZES

Style 1- Both models utilize the same robust 1" heavy duty dial unit housing with a choice of various resolutions and spindle travel in both inch or metric readings.

- ✓ Both the #7 and #8 bore gages measure .625" from the bottom of a blind bore.
- ✓ The standard gaging depth is 6" but can be supplied with depth extensions to 144".
- ✓ Besides these large bore gages, we also offer two companion bore gage setting masters that are set to size with gage block combinations. Setmaster # DBM-12000 (12"-24") and # DBM-24000 (20" to 36") are adjustable, more convenient to handle, and less expensive than a library of traditional large rings.



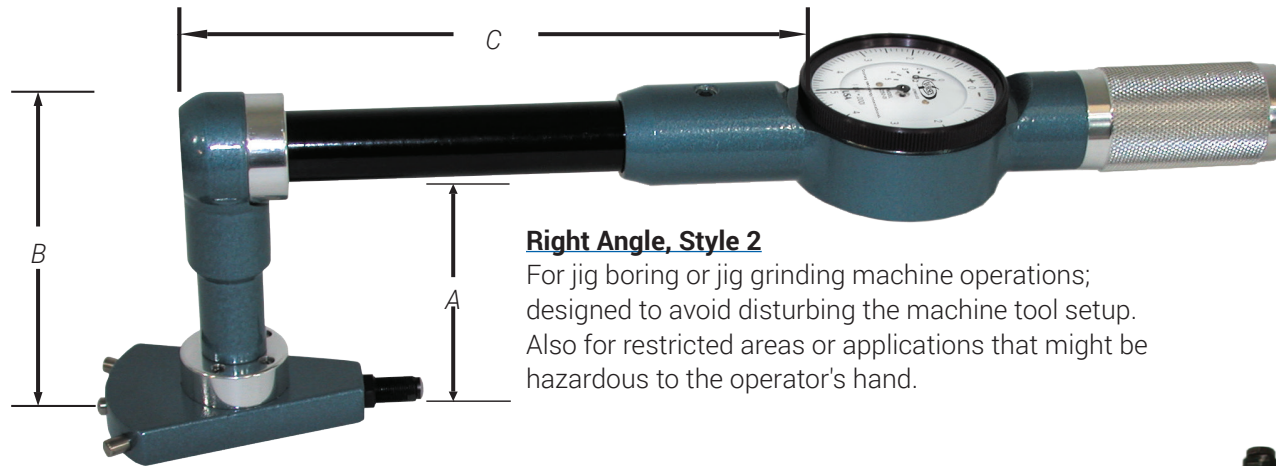
OPTIONAL: BORE GAGE DEPTH EXTENSIONS

4" DEPTH EXTENSION
5" DEPTH EXTENSION
6" DEPTH EXTENSION
8" DEPTH EXTENSION
10" DEPTH EXTENSION
12" DEPTH EXTENSION
14" DEPTH EXTENSION
16" DEPTH EXTENSION
24" DEPTH EXTENSION
30" DEPTH EXTENSION
36" DEPTH EXTENSION
Other Lengths Available
37-72"
72-144"

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There are 5 optional styles that are designed especially for applications where space restrictions or gaging positions are not suitable for the use of the Style 1.

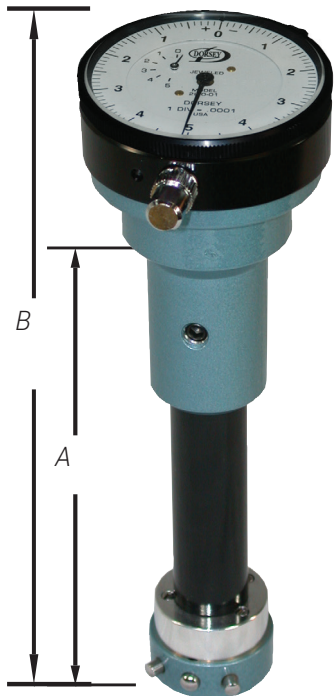


Right Angle, Style 2

For jig boring or jig grinding machine operations; designed to avoid disturbing the machine tool setup. Also for restricted areas or applications that might be hazardous to the operator's hand.

Perpendicular, Style 4

For vertical axis bores below eye level.



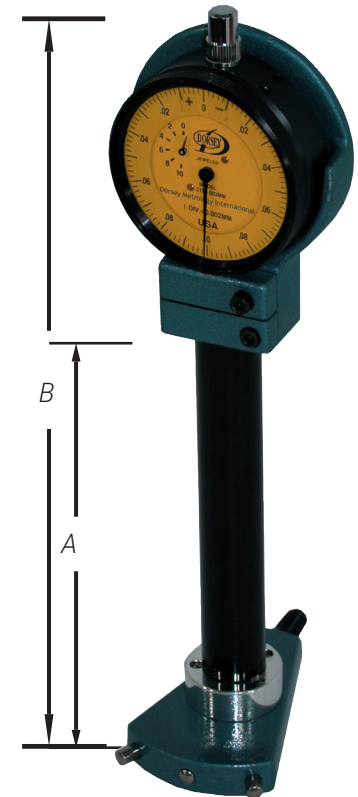
Pistol Grip, Style 5

For limited access applications.



Flush Mount, Style 7

For limited access applications.



Vertical, Style 3

For vertical axis bores at eye level; best choice for bench inspection applications.

GAGE SIZE	STANDARD STYLE 1			RIGHT ANGLE STYLE 2				VERTICAL STYLE 3			PERPENDICULAR STYLE 4			PISTOL GRIP STYLE 5			FLUSH STYLE 7
	A		B	A		B	C	A		B	A		B	A		B	B
	STD	MIN		STD	MIN			STD	MIN		STD	MIN		STD	MIN		
1	2.70"	2.70"	7.27"	-	-	-	-	-	-	-	-	-	-	-	-	-	-
2	5.00"	2.31"	8.12"	2.53"	2.35"	3.88"	6.25"	6.00"	2.31"	8.75"	6.00"	2.31"	8.13"	1.63"	1.63"	5.75"	-
3	5.00"	2.63"	10.50"	2.53"	2.35"	3.88"	6.25"	6.00"	2.63"	9.00"	6.00"	2.63"	8.13"	1.63"	1.63"	5.75"	-
4	5.00"	2.63"	10.50"	2.53"	2.35"	3.88"	6.25"	6.00"	2.63"	9.00"	6.00"	2.63"	8.13"	1.63"	1.63"	5.75"	-
5	6.00"	2.63"	11.50"	2.53"	2.35"	3.83"	6.25"	6.00"	2.63"	9.00"	6.00"	2.63"	8.13"	1.63"	1.63"	5.75"	-
6	6.00"	2.63"	12.00"	2.50"	2.50"	4.44"	6.69"	6.00"	5.50"	9.44"	6.00"	4.00"	8.13"	3.00"	3.00"	9.38"	1.50"

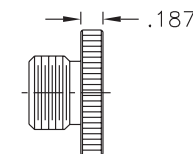
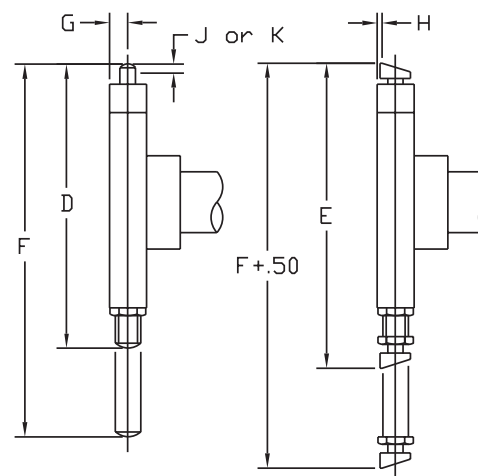
D = Standard gaging range
E = Gaging range with optional offset contacts
F = Maximum gaging range with extension adapters
G = Standard center line
H = Offset center line modification add -H to part #
J = Standard gaging plunger travel
K = Optional extended plunger travel add -K to part #

GAGE-HEAD DIMENSIONS (ALL STYLES)

SIZE	D		E		F	G	H	J	K	RANGE EXTENSION ADAPTER PART #
	MIN	MAX	MIN	MAX						
1	.63"	1.00"	-	-	-	.100"	-	.015"	-	-
2	1.00"	1.53"	1.19"	1.69"	1.75"	.195"	.140"	.025"	.050"	DS-B0-85929
3	1.50"	2.16"	1.69"	2.56"	3.13"	.224"	.156"	.025"	.050"	DS-B0-85934
4	2.12"	3.13"	2.56"	3.56"	4.00"	.224"	.032"	.025"	.075"	DS-B0-85942
5	3.09"	6.13"	3.50"	6.44"	8.00"	.224"	.032"	.025"	.075"	DS-B0-85952
6	6.00"	12.13"	6.44"	12.63"	24.00"	.312"	.032"	.030"	.100"	DS-B0-85966

BORE GAGE EXTENSION HOUSING #3, 4 & 5

EXTENSION HOUSING ASSEMBLY	
PART #	DESCRIPTION
DX2-81005-03	3" "A" LENGTH EXTENSION
DX2-81005-04	4" "A" LENGTH EXTENSION
DX2-81005-05	5" "A" LENGTH EXTENSION
DX2-81005-06	6" "A" LENGTH EXTENSION
DX2-81005-08	8" "A" LENGTH EXTENSION
DX2-81005-10	10" "A" LENGTH EXTENSION
DX2-81005-12	12" "A" LENGTH EXTENSION
DX2-81005-14	14" "A" LENGTH EXTENSION
DX2-81005-16	16" "A" LENGTH EXTENSION
DX2-81005-18	18" "A" LENGTH EXTENSION
DX2-81005-24	24" "A" LENGTH EXTENSION
DX2-81005-30	30" "A" LENGTH EXTENSION
DX2-81005-36	36" "A" LENGTH EXTENSION
Other Lengths Available	
37-71"	
72-144"	



BORE GAGE DUST CAP

- ✓ Replaces standard handle.
- ✓ Minimize overall length ("B" dimension).

SIZE	REDUCES "B" DIM. BY	PART #
2-6	2.06"	DS-B0-84725
6 Heavy Duty	2.81"	DS-B0-84731

MODELS 2,3,4,5

FEATURES:

- ✓ Industry's most popular dial bore gage now available in an easy-to-use combination kit.
- ✓ Standard with jeweled shock proof indicator movement.
- ✓ Available with a wide variety of indicators including .00005" or 0.001mm.
- ✓ Replaces separate dial bore gages covering the same ranges as models # 2, 3, 4, and 5.
- ✓ Considerable cost savings.
- ✓ Convenient carrying case.
- ✓ Ideal for small shops or short production runs.
- ✓ Interchangeable gage heads and range extensions to cover diameters from 1.000" to 8.000" or 25.4mm to 203.2mm.

PART #	DESCRIPTION
DS-B1-K2345	WITH .0001" GRAD DIAL INDICATOR
DS-B1-K2345M	WITH 0.002mm GRAD DIAL INDICATOR



EXTRA LENGTH BORE GAGE EXTENSIONS:

Bore gage extension housings with gaging depths up to 36" are normally manufactured from stainless steel tubing. See the price list for ordering data for each model. Bore gages with extra length extensions beyond 36" are now standard in carbon fiber. Most long bore gages are normally produced from stainless steel tubing up to 72" depths. Traditionally, beyond this length, the #4, #5 and #6 bore gages are constructed using segmented steel tubing. All extra length bore gage tubing are now provided with carbon fiber extensions that are lighter weight, more thermally stable, and structurally stronger.



#6 Dorsey/Standard bore gage with 5' steel extension housing. The Weight is 7¾ lbs/3.52kg (less range extensions).

Available in Carbon Fiber



#4 Dorsey/Standard bore gage with 4' carbon fiber extension housing. The weight is 2½ lbs/1.13kg (less range extensions).

Maximum Recommended Gaging Depths

GAGE SIZE	INCH DEPTH
SIZE #2	60" maximum
SIZE #3	72" maximum
SIZE #4	96" maximum
SIZE #5	144" maximum
SIZE #6	144" maximum



#6 Dorsey/Standard bore gage with 4' carbon fiber extension housing. The weight is 4 lbs/1.8kg (less range extensions).

	DS-	B1- MB- (for modular)	1 Style	2 Indicator	1 Contacts
GAGE SIZE	INDICATOR GRADUATION	HIGH AMPLIFICATION INDICATOR	PART NUMBER	TRADITIONAL INDICATOR	TRADITIONAL PART NUMBER
.63" - 1.00"	.00005 ^s	DS-214-005	DS-B1-10101		
	.0001 ^{ts}	DS-219-01	DS-B1-11101		
	.0001"	DS-2150-01	DS-B1-12101		
	.00025"	DS-21100-025	DS-B1-10111		
	.0005"	DS-21100-05	DS-B1-14101		
	NONE	LESS INDICATING UNIT	DS-B1-15101		
	0.005mm	DS-2125-005mm	DS-B1-17101		
	0.002mm	DS-2110-002mm	DS-B1-18101		
	0.002mm ^s	DS-2102-002mm	DS-B1-19101		
	0.001mm ^s	DS-2101-001mm	DS-B1-10121		
16 - 25.4mm	.0001" / .002mm ^s	S2LM	DS-B1-12101M		
	.00005" / 0.001mm	DIGITAL	DS-B5-10101		
1.00 - 1.53"	.00005 ^s	DS-214-005	DS-B1-10102		
	.0001 ^{ts}	DS-219-01	DS-B1-11102		
	.0001"	DS-2150-01	DS-B1-12102	DS-2DM025-01	DS-B2-12102
	.00025"	DS-21100-025	DS-B1-10112		
	.0005"	DS-21100-05	DS-B1-14102	DS-2DM050-05	DS-B2-14102
	NONE	LESS INDICATING UNIT	DS-B1-15102		
	0.005mm	DS-2125-005mm	DS-B1-17102	DS-2DM012-005mm	DS-B2-17102
	0.002mm	DS-2110-002mm	DS-B1-18102	DS-2DM005-002mm	DS-B2-18102
	0.002mm ^s	DS-2102-002mm	DS-B1-19102		
	0.001mm ^s	DS-2101-001mm	DS-B1-10122		
25.4 - 38.9mm	.0001" / .002mm ^s	S2LM	DS-B1-12102M		
	.00005" / 0.001mm	DIGITAL	DS-B5-10102		

GAGE SIZE	INDICATOR GRADUATION	HIGH AMPLIFICATION INDICATOR	PART NUMBER	TRADITIONAL INDICATOR	TRADITIONAL PART NUMBER
1.50 - 2.16" 3 38.1 - 54.8mm	.00005 ^s	DS-214-005	DS-B1-10103		
	.0001 ^{ts}	DS-219-01	DS-B1-11103		
	.0001"	DS-2150-01	DS-B1-12103	DS-2DM025-01	DS-B2-12103
	.00025 ^s	DS-21100-025	DS-B1-10113		
	.0005 ^s	DS-21100-05	DS-B1-14103	DS-2DM050-05	DS-B2-14103
	NONE	LESS INDICATING UNIT	DS-B1-15103		
	0.005mm	DS-2125-005mm	DS-B1-17103	DS-2DM012-005mm	DS-B2-17103
	0.002mm	DS-2110-002mm	DS-B1-18103	DS-2DM005-002mm	DS-B2-18103
	0.002mm ^s	DS-2102-002mm	DS-B1-19103		
	0.001mm ^s	DS-2101-001mm	DS-B1-10123		
	.0001" / .002mm ^s	S2LM	DS-B1-12103M		
	.00005 ^s / 0.001mm	DIGITAL	DS-B5-10103		
2.12 - 3.13" 4 54.0 - 79.5mm	.00005 ^s	DS-214-005	DS-B1-10104		
	.0001 ^{ts}	DS-219-01	DS-B1-11104		
	.0001"	DS-2150-01	DS-B1-12104	DS-2DM025-01	DS-B2-12104
	.00025 ^s	DS-21100-025	DS-B1-10114		
	.0005 ^s	DS-21100-05	DS-B1-14104	DS-2DM050-05	DS-B2-14104
	NONE	LESS INDICATING UNIT	DS-B1-15104		
	0.005mm	DS-2125-005mm	DS-B1-17104	DS-2DM012-005mm	DS-B2-17104
	0.002mm	DS-2110-002mm	DS-B1-18104	DS-2DM005-002mm	DS-B2-18104
	0.002mm ^s	DS-2102-002mm	DS-B1-19104		
	0.001mm ^s	DS-2101-001mm	DS-B1-10124		
	.0001" / .002mm ^s	S2LM	DS-B1-12104M		
	.00005 ^s / 0.001mm	DIGITAL	DS-B5-10104		
3.09 - 6.13" 5 78.5 - 156mm	.00005 ^s	DS-214-005	DS-B1-10105		
	.0001 ^{ts}	DS-219-01	DS-B1-11105		
	.0001"	DS-2150-01	DS-B1-12105	DS-2DM025-01	DS-B2-12105
	.00025 ^s	DS-21100-025	DS-B1-10115		
	.0005 ^s	DS-21100-05	DS-B1-14105	DS-2DM050-05	DS-B2-14105
	NONE	LESS INDICATING UNIT	DS-B1-15105		
	0.005mm	DS-2125-005mm	DS-B1-17105	DS-2DM012-005mm	DS-B2-17105
	0.002mm	DS-2110-002mm	DS-B1-18105	DS-2DM005-002mm	DS-B2-18105
	0.002mm ^s	DS-2102-002mm	DS-B1-19105		
	0.001mm ^s	DS-2101-001mm	DS-B1-10125		
	.0001" / .002mm ^s	S2LM	DS-B1-12105M		
	.00005 ^s / 0.001mm	DIGITAL	DS-B5-10105		

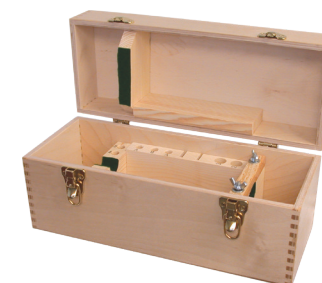
^s = single revolution indicator.

OPTIONAL CONTACT POINTS

OPTION	1	2	4	5	7	8
Gaging Contact	Steel	Carbide	Diamond	Carbide	Diamond	Offset Contact Configuration
Centralizing Contact	Steel	Steel	Steel	Carbide	Carbide	H Dimension

GAGE SIZE	INDICATOR GRADUATION	HIGH AMPLIFICATION INDICATOR	PART NUMBER	TRADITIONAL INDICATOR	TRADITIONAL PART NUMBER
6.00 - 12.13"	.00005 ^s	DS-214-005	DS-B1-10106		
	.0001 ^s	DS-219-01	DS-B1-11106		
	.0001"	DS-2150-01	DS-B1-12106	DS-2DM025-01	DS-B2-12106
	.00025"	DS-21100-025	DS-B1-10116		
	.0005"	DS-21100-05	DS-B1-14106	DS-2DM050-05	DS-B2-14106
	NONE	LESS INDICATING UNIT	DS-B1-15106		
	0.005mm	DS-2125-005mm	DS-B1-17106	DS-2DM012-005mm	DS-B2-17106
	0.002mm	DS-2110-002mm	DS-B1-18106	DS-2DM005-002mm	DS-B2-18106
	0.002mm ^s	DS-2102-002mm	DS-B1-19106		
	0.001mm ^s	DS-2101-001mm	DS-B1-10126		
	.0001" / 0.002mm ^s	S21.M	DS-B1-12106M		
	.00005" / 0.001mm	DIGITAL	DS-B5-10106		
10.00 - 24.00"	.00005 ^s	DS-214-005	DS-B1-10107		
	.0001 ^s	DS-219-01	DS-B1-11107		
	.0001"	DS-2150-01	DS-B1-12107	DS-2DM025-01	DS-B2-12107
	.00025"	DS-21100-025	DS-B1-10117		
	.0005"	DS-21100-05	DS-B1-14107	DS-2DM050-05	DS-B2-14107
	NONE	LESS INDICATING UNIT	DS-B1-15107		
	0.005mm	DS-2125-005mm	DS-B1-17107	DS-2DM012-005mm	DS-B2-17107
	0.002mm	DS-2110-002mm	DS-B1-18107	DS-2DM005-002mm	DS-B2-18107
	0.002mm ^s	DS-2102-002mm	DS-B1-19107		
	0.001mm ^s	DS-2101-001mm	DS-B1-10127		
	.0001" / .002mm ^s	S21.M	DS-B1-12107M		
	.00005" / 0.001mm	DIGITAL	DS-B5-10107		
21.00 - 36.00"	.00005 ^s	DS-214-005	DS-B1-10108		
	.0001 ^s	DS-219-01	DS-B1-11108		
	.0001"	DS-2150-01	DS-B1-12108	DS-2DM025-01	DS-B2-12108
	.00025"	DS-21100-025	DS-B1-10118		
	.0005"	DS-21100-05	DS-B1-14108	DS-2DM050-05	DS-B2-14108
	NONE	LESS INDICATING UNIT	DS-B1-15108		
	0.005mm	DS-2125-005mm	DS-B1-17108	DS-2DM012-005mm	DS-B2-17108
	0.002mm	DS-2110-002mm	DS-B1-18108	DS-2DM005-002mm	DS-B2-18108
	0.002mm ^s	DS-2102-002mm	DS-B1-19108		
	0.001mm ^s	DS-2101-001mm	DS-B1-10128		
	.0001" / .002mm ^s	S21.M	DS-B1-12108M		
	.00005" / 0.001mm	DIGITAL	DS-B5-10108		

WOODEN STORAGE BOX



DS Series bore gages are shipped in disposable shipping containers. To order a fitted wooden storage box please refer to the chart below.

PART #	GAGE SIZE
DX2-89951	1
DX2-89952	2
DX2-89953	3
DX2-89954	4
DX2-89955	5
DX2-89956	6
DX2-89957	7
DX2-89927	COMBINATION KIT

FEATURES:

- ✓ Range ext up to 36" are available. Larger than 36" available by special request.
- ✓ All models come with steel contacts but carbide and diamond contacts are also available.

^s = single revolution indicator.