

TRULOK[®]

PRECISION MEASURING INSTRUMENTS



Countersink Depth Gage Instructions

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This Countersink Depth Gage has been programmed to read the actual depth measurement and should be preset to the depth value of the supplied Trulok Setting Block.

1

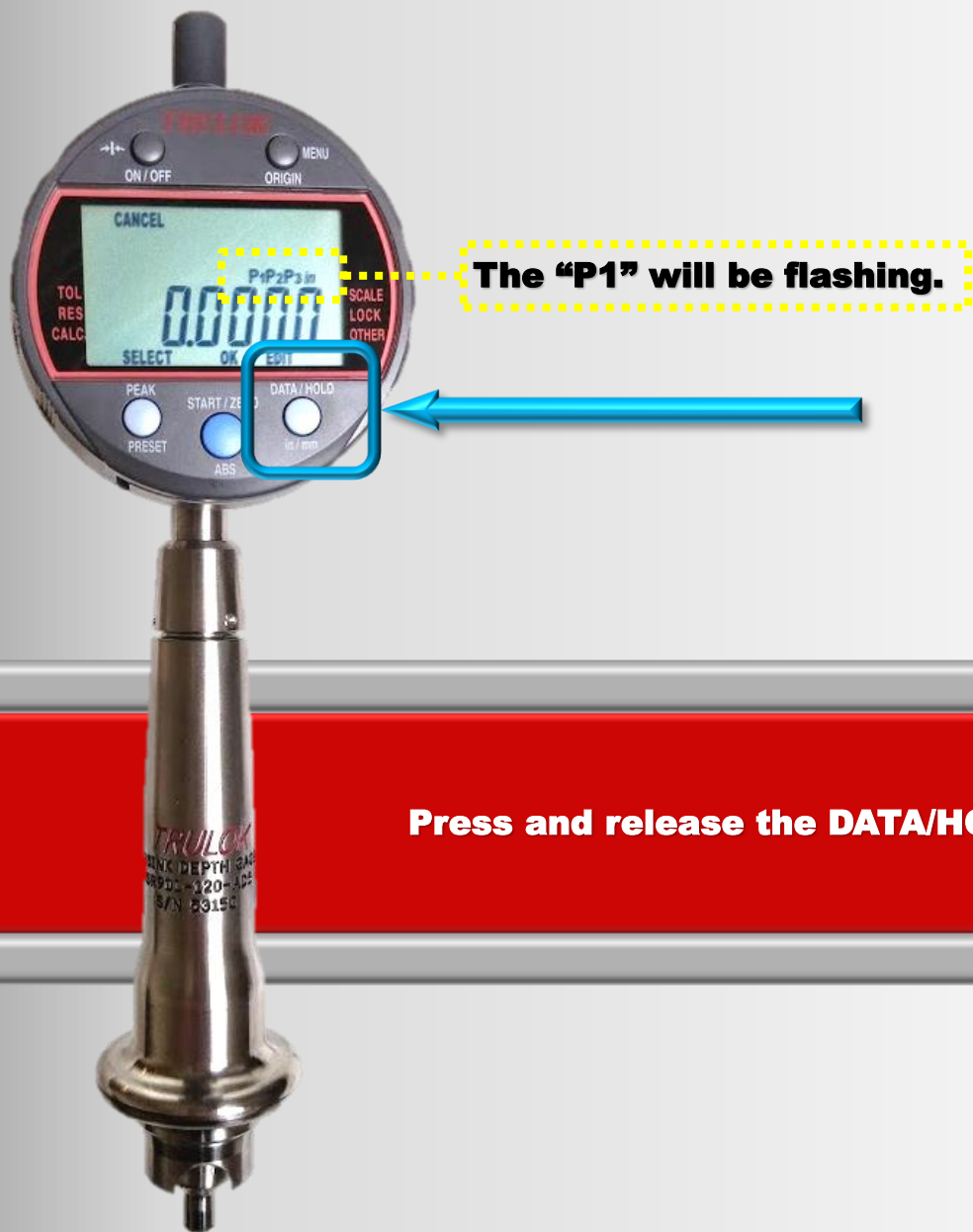
Turn the indicator on by pressing the [ON/OFF] button.

Note: The Gage used in this example is a SR901 series Gage with a radius type contact point. These instructions apply to the 903 Series and 905 Series Gages as well.



2

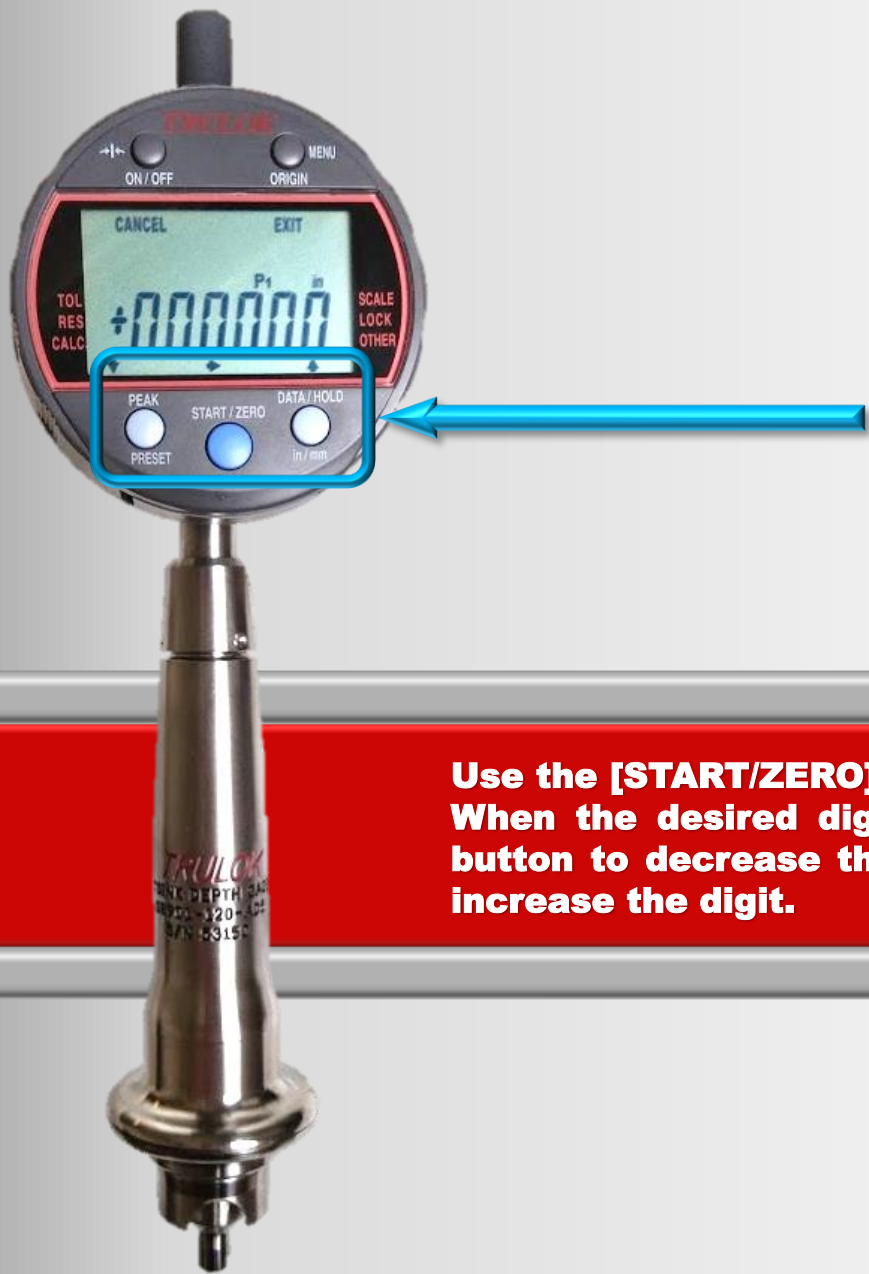
Press and release the PEAK/PRESET button



The "P1" will be flashing.

3

Press and release the DATA/HOLD button to edit the preset.



4

Use the [START/ZERO] button to move the cursor to the right. When the desired digit is flashing, use the [PEAK/PRESET] button to decrease the digit and the [DATA/HOLD] button to increase the digit.



5

Once the desired preset is entered, press the [MENU/ORIGIN] button to exit the screen.

Note: This example is set to the depth of the MDO-100-360 Calibration Set Block as shown in step #8.



6



Insert the Gage into the Master Set Block. While the gage is fully compressed into the block, press the START/ZERO/ABS button. This will set the preset.



Trulok recommends to repeat the presetting process before every use and periodically between measurements to ensure the most accurate readings.

7

Remove the gage from the block and re-insert to ensure the gage is repeating. This will complete the self-calibration process and your gage is now ready for use.

Note: If the Gage is not repeating, remove the Gage from the Block, press and release the PEAK/PRESET button, P1 will flash, and repeat step #6.



MHO-100-260
Countersink Angle: 100°
Countersink Diameter: 0.2600"
Thru Hole: .1250"
Countersink Depth: 0.0566"
Difference from Zero Preset: -0.0420"



MHO-100-360
Countersink Angle: 100°
Countersink Diameter: 0.3600"
Thru Hole: .1250"
Countersink Depth: 0.0986"
Difference from Zero Preset: 0.0000"



MHO-100-460
Countersink Angle: 100°
Countersink Diameter: 0.4600"
Thru Hole: .1250"
Countersink Depth: 0.1406"
Difference from Zero Preset: +0.0420"

8

If you have purchased the Master Setting Block Set, check the Gage on each Master Block to verify the Gage is reading the full range.

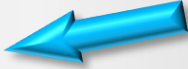


If it is preferred that the gage is “zeroed” (instead of preset) to read a deviation from the calibration block, the gage will read a **positive** number for a deeper countersink and a **negative** number for a shallower countersink.

9

Turn the indicator on by pressing the [ON/OFF] button.

Note: The Gage used in this example is a SR901 series Gage with a radius type contact point. These instructions apply to the 903 Series and 905 Series Gages as well.



10

Engage the Gage into the provided Set Block.





Note: Ensure that the bushing footprint is resting completely onto the block face.

11

While the gage is fully compressed into the Set Block, press the START/ZERO/ABS button.

The Gage is now set to zero.



NOTE: The value displayed after the gage has been “zeroed” in a setting block when it is not in the countersink will be **positive**. This is equivalent to a “deeper” countersink from the setting block depth value.

Conversely, if the plunger is fully compressed, the gage will display a **negative** value (not shown). This is equivalent to a “shallower” countersink from the setting block depth value.

12

Remove the gage from the block.

PLUNGER FULLY COMPRESSED = NEGATIVE VALUE
PLUNGER FULLY EXTENDED = POSITIVE VALUE



Trulok recommends to repeat the presetting process before every use and periodically between measurements to ensure the most accurate readings.

13

Place the Gage back onto the Set Block to ensure the gage is reading 0.0000in. This will complete the presetting process and your gage is now ready for use.

Note: If the Gage is not repeating, repeat steps 10-13.



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Countersink Depth: 0.1406"
Difference from Zero Preset: +0.0420"

14

If you have purchased the Master Calibration Block Set, check the Gage on each Master Block to verify the Gage is reading the full range.