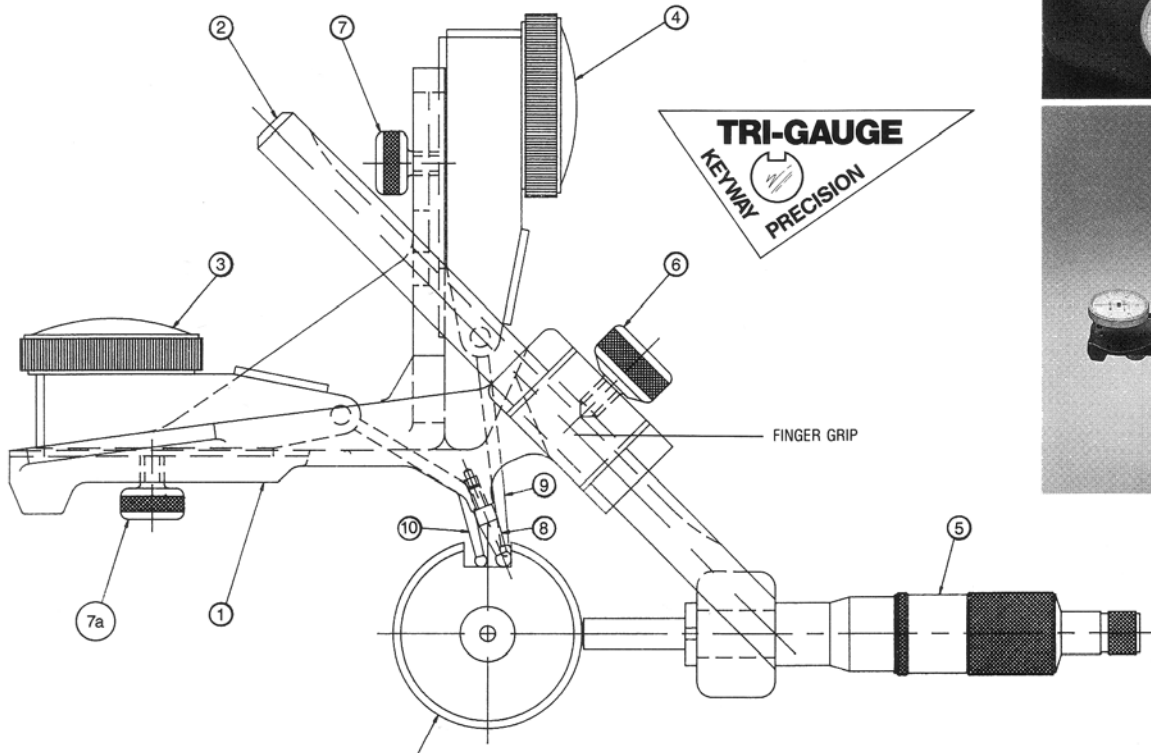
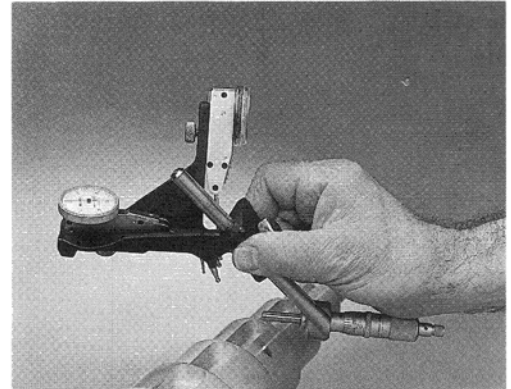
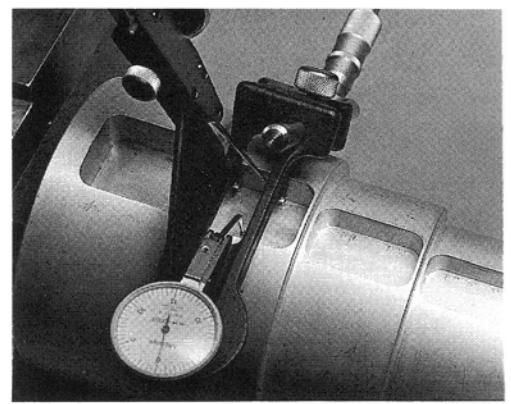


HOW TO USE THE KEYWAY TRI-GAUGE



THIS SHAFT SHOWN FOR REF. ONLY

(Note: When not handling Keyway Tri-Gauge, it can be layed down on either side. For storage of gauge, place in box provided.)



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A. To check CENTERING OF KEYWAY:

1. Loosen Clamp Screw (7a) and move Horizontal Indicator Leg (10) so Probe Tip appears to be about 1/2 the distance across the keyway from the two Stationary Points (8). (Note: Probe #10 of Horizontal Indicator can be moved up or down with fingers to achieve contact). Secure Horizontal Indicator by tightening Clamp Screw (7a).
2. Loosen Clamp Screw (6) on sliding Micrometer Bar (2). Place two Stationary Points (8) in nearest inside bottom edge of keyway. (Jiggle slightly to make sure points are seated on keyway base). Slide Micrometer Bar (2) until Micrometer is on the approximate centerline of the shaft. Secure bar by tightening Clamp Screw (6).
3. Set Micrometer to closest "0"...not to exceed one revolution. Make certain that the Horizontal Indicator Probe Tip (10) is in contact with keyway and touching at a point about 1/2 way across the keyway. Set Horizontal Indicator (3) to "0".
4. Now use Finger Grip to turn gauge 180°. Make certain two Stationary Points (8) are seated on base at inside edge of keyway. Take a reading on the Horizontal Indicator (3)...the reading should be "0". If not, turn the Micrometer in or out to get Horizontal Indicator (3) to register "0". The reading on the Micrometer tells the variation, indicating the correction to be made. Remember, each mark is .001"...the reading on the Micrometer is the total indicator reading. (Example: .008" is equal to .004" off centerline.)

B. To check PARALLELISM TO CENTERLINE OF KEYWAY:

- 1., 2., 3., Follow first three steps of "Centering" procedure (A).
4. Use Finger Grip to move gauge to opposite end of keyway. Take a reading on Horizontal Indicator (3)...the reading should be "0". If not, turn Micrometer in or out to get Horizontal Indicator to register "0". The reading on the Micrometer tells the variation, indicating the correction to be made.

C. To check PERPENDICULARITY OF KEYWAY SIDES TO CENTERLINE:

1. With gauge in position on keyway as in checking the "Centering", loosen Clamp Screw (7) of Vertical Indicator (4), and move down until Probe Tip (9) touches side of keyway about .060 (1/16) down the sidewall. (Note that indicator probe (9) can be moved in or out with fingers to achieve contact). Tighten Clamp Screw (7). Set Vertical Indicator dial and Micrometer to "0".
2. Use Finger Grip to turn gauge 180°. Make certain two Stationary Points (8) are seated in keyway base. Make certain Probe tip (9) from Vertical Indicator is touching the sidewall of the keyway. Take a reading on the Vertical Indicator (4)...the reading should be "0". If not, the reading of the Indicator tells the variations, indicating corrections have to be made.