



"Your Automotive Measuring People"

Instructions for the Use of Graduated Brake Drum Gages #6456/6472/6478

1. To measure score depth, place the gage in the drum at the score, and with the fixed finger held against one side, bring the movable finger into contact with the drum at the score on the opposite side, at the point of greatest diameter.
2. Unscored surfaces are measured in the same manner with the additional caution that the anvils must be kept parallel to the drum mounting face without the help of a score line.
3. To take the actual measurement, lock the thumbscrew in place. The measurement is read off the scale in line with the machined edge of the sliding finger. The English scale is graduated in $1/32$ " increments, which is 0.031". Hence, an allowance of .060, .090 and .120 over nominal would correspond to 2, 3 or 4 graduations beyond the nominal drum diameter.
4. If the graduation on the movable finger indicates a measurement greater than the limit over standard, the brake drum is disqualified for further safe use and should not be machined. An undersized brake drum should be replaced with a new brake drum which meets the original equipment manufacturer's specifications.

