



HOW GAGE BLOCKS ARE WRUNG TOGETHER

Thoroughly clean the gaging surfaces using an approved cleaning fluid. Dry the gaging surfaces on soft tissue towel.

Everyone handling Precision Gage Blocks is proud of his or her ability to wring them together quickly and easily. Sometimes, due to haste, the blocks are not properly cleaned or are not placed in contact carefully, resulting in scratches and undo wear. The practice illustrated below is recommended when wringing Precision Gage Blocks. Note the correct method of holding the blocks in the fingers.

The gaging surface of precision blocks should not be touched more than necessary. The natural moisture of the hands contains an acid which may eventually stain the blocks, if not removed.

The gages are delivered with a coating of rust-proof grease. This should be removed for use, with a soft chamois or tissue towel, preferably using a neutral cleaning fluid. The cleaning fluid must be free from dirt, coloring matter or other special ingredients.

The blocks should be kept as dry as possible, and should re-greased with a non-acidic grease when not in use.

Figure #1 – Place Blocks Together

Place the blocks together as shown. This minimizes the danger of the corner of one block scratching the other.



The longer the blocks are left wrung together the tighter they will adhere to each other. It is best to separate all blocks at the end of each day.

Figure #2 – Slide Blocks In Circular Motion

Slide the upper block over the lower with a circular motion. If they are clean they will begin to take hold. Foreign matter can be detected readily and should be removed before it damages either block.



The handling surfaces of Hoke Blocks are especially finished to give a good “grip even when handled with oily fingers. All edges are chamfered for safe handling.

Figure #3 – Slide Upper Block Half Out

Slide the upper block half out of engagement using light pressure.





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Figure #4 – Slide Blocks Together

Slide the upper block back into full engagement under light pressure, at which point they should be wrung together ready for use. Worn or dirty blocks will not wring.



Figure #5 - Gage Blocks Wrung Together

The lapped surfaces of Precision Gage Blocks have a mirror finish, and they will adhere with surprising tenacity when wrung together.

This force which holds the blocks together is a good many times greater than the force of atmospheric pressure, and it is not magnetic. It's exact nature is not known.



ADVANTAGES OF SQUARE DESIGN

The square section of the working surfaces and the central hole are special features of Hoke Gage design that have several important advantages. The square form allows the gages to be handled easily, gives large, symmetrical working surfaces, and reduces wear by overcoming the tendency to wring the gage blocks together always in one direction. The blocks are approximately .950" square.

The hole through the block's center permits the use of internal tie rods by which rapid, compact assembling of the various attachments is made possible, and the use of outside clamps is avoided.

There is a serious risk of knocking over a stack of precision gage blocks on a cast-iron surface plate. Both are highly accurate and are almost certain to be damaged. This will mean an expensive refinishing job on the plate, and a set of gage blocks that are no longer trustworthy. Gage blocks that really "stand up" are desired.

Try a stack of Hoke gages on your surface plate. They stand firmly where you place them, and a careless touch won't knock them over easily. Each block has a broad surface area to stand on. On the other hand the narrow design of rectangle gage blocks allows them to be placed into narrow working spaces. Numerous companies utilize both set of gage blocks according to their needs.



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HOW COMBINATIONS ARE FIGURED



More than 120,000 different length combinations can be obtained utilizing a 85 piece gage block set. Most lengths may be obtained using more than one combination of blocks, so that two people using the same set may obtain the same size at the same time.

To facilitate the choice of blocks when building up a gaging length, begin by eliminating the right-hand figure of the dimension required. Then eliminate each successive figure from right to left. The gaging length "1.9504" can be set up in two ways, as shown below. Combinations so made are self-checking, using an optical flat. (see Figure #6)

Figure #6

EXAMPLE:

First block	.1004	First block	.1001
Second block	.850	Second block	.1003
Third block	1.000	Third block	.950
		Fourth block	.800
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	1.9504		1.9504