

PRECISION SPINDLE SQUARING CHECKLIST



STEP 1:

ASSEMBLE AND ACQUIRE ALL NEEDED TOOLS. (MILLED MACHINIST BLOCK, DIAL INDICATOR, RUBBER Mallet, SPINDLE SQUARE, RACHETING WRENCH, PRY BAR, 3/16TH HEX HEAD EXTENTION, LEVELING FEET, SHIM KIT IF NEEDED)



STEP 2:

MOVE GANTRY 6 INCHES FROM FRONT CENTER

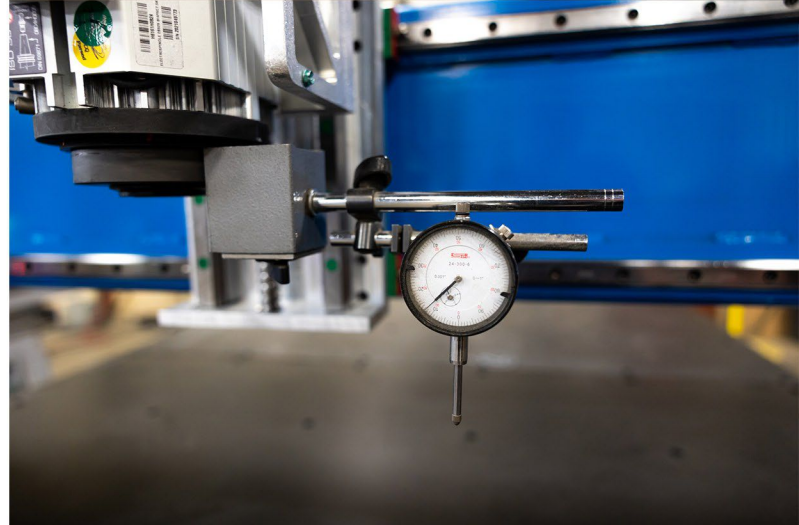
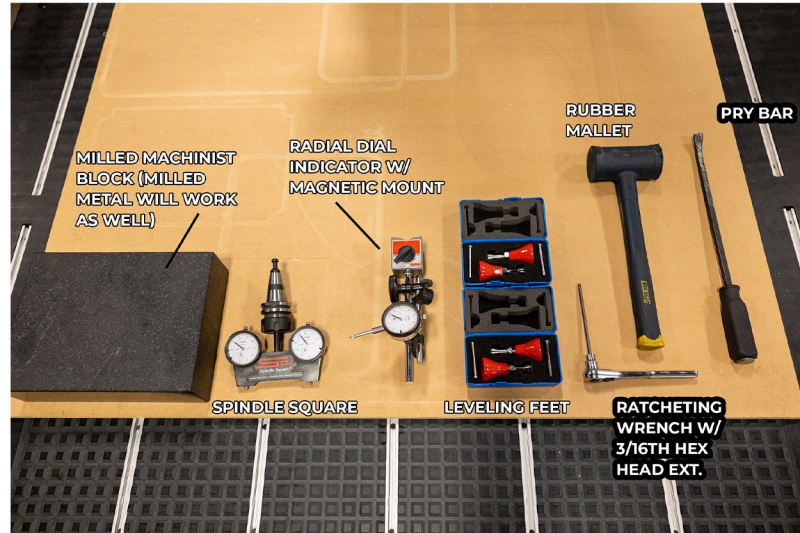
SET UP LEVELING FEET TO ROUGHLY LEVEL THE MACHINIST BLOCK (ROUGHLY BETWEEN .020" TO .030" FOR EACH CORNER).



STEP 3:

MOUNT DIAL INDICATOR TO STATIONARY PORTION OF SPINDLE.

DO A FINE LEVEL OF THE BLOCK MOVING THE INDICATOR NEEDLE FROM CORNER TO CORNER MEASURING TO MAKE SURE THERE IS NO DIFFERENCE IN HEIGHT BETWEEN EACH CORNER OF THE BLOCK.



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STEP 4:

ATTACH SPINDLE SQUARE PARALLEL TO THE Y AXIS, AND ZERO OUT EACH DIAL.



STEP 5:

THEN FLIP SQUARE AROUND 180 DEGREES, THE DIAL SHOULD BE AT ZERO."



STEP 6:

IF NOT SHIMS MUST BE PLACED BETWEEN SPINDLE PLATE AND BEARING BACKPLATE BEHIND EITHER THE TOP OR BOTTOM BOLT HOLES TO ACCOMMODATE A CHANGE IN PITCH IN THE Y AXIS"



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STEP 7:
ROTATE SPINDLE SQUARE SO THAT IT IS
PARALLEL WITH THE X AXIS. RESET ZEROS FOR
EACH GAUGES.



STEP 8:
IF THE SPINDLE IS OUT OF SQUARE ON
THE X AXIS THEN LOOSEN THE FOUR
LOWER MOUNTING BOLTS, THEN TAKE A
PRYBAR AND PRY LIGHTLY BETWEEN THE
SPACER FOR THE LINEAR RAIL AND THE
BRACKET MOUNTED TO THE SIDE OF THE
SPINDLE UNTIL THE SPINDLE IS BACK IN
SQUARE. FINALLY TIGHTEN THE BOLTS TO
LOCK IT BACK INTO POSITION."



STEP 9:
TIGHTEN BOLTS AND REPEAT STEP 7 AND 8
IF NEEDED.

