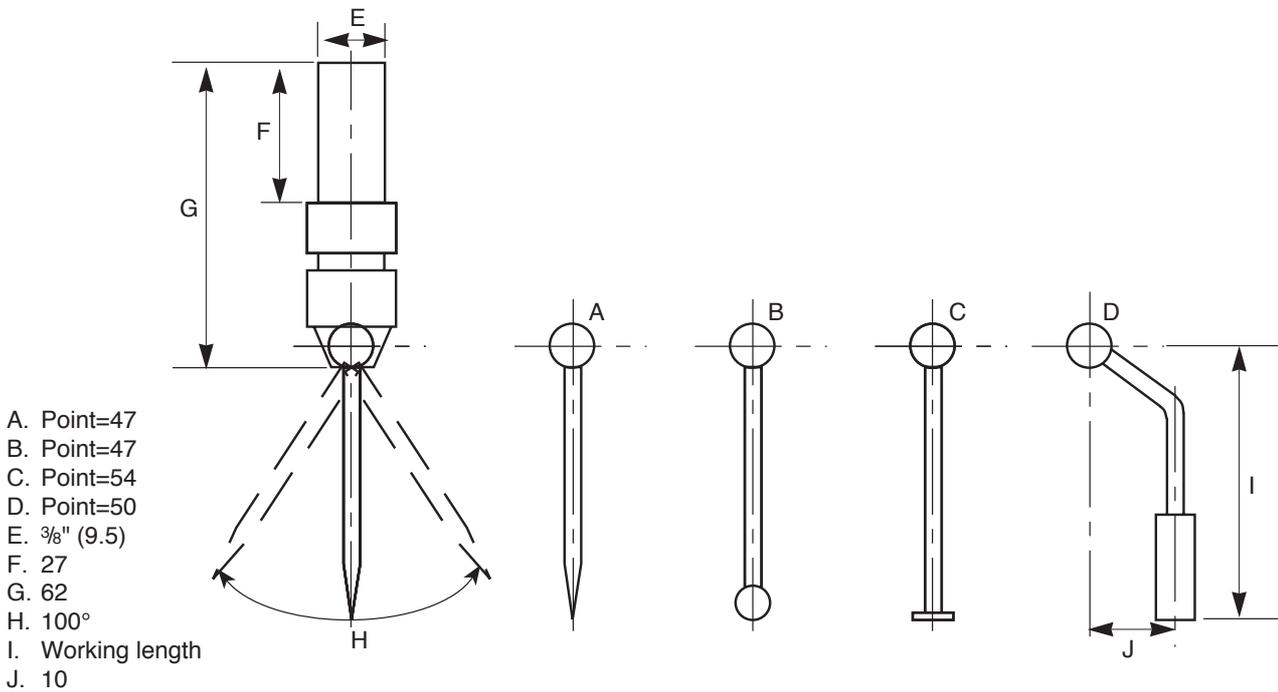




Centre Finder/Wiggler Set

Stock No. 432-564

Figure 1.



This tool is designed for use in a vertical milling machine or drilling machine.

The points are fully interchangeable and when fitted should be free to move in the holder. DO NOT OVERTIGHTEN the holder collet as this will impair the action of the tool.

Contact A

This can be used to position a spindle over a scribed line. With the spindle running at 500 - 1000 r/min. set the point to run true using a pencil, rule or other suitable object. Position the work under the centre finder and bring the contact as close to the surface as possible, without touching. Traverse the work until the spindle axis is directly overhead of the desired line or mark on the work.

Contact B and C

These can be used to locate vertical surfaces, slots or holes. With the spindle running allow the pointer to oscillate slightly (see figure 2). Traverse the table (and work) and allow the contact to touch the edge of the work or hole. The oscillations should diminish and the attachment will appear to 'run true' (see figure 3). When the contact probe reaches the measuring datum it will 'run off' along the face of the work (see figure 4). At the position shown in figure 4 the distance between the spindle centre line and the edge of the work is equal to half the contact diameter (e.g. a 0.250" point will position to 0.125").

Contact D

This can be used in conjunction with some dial indicators. The point should be clamped securely in the collet and the dial indicator clamped securely to the cylindrical section of the point. The spindle may then be rotated by hand to sweep holes or outside diameters.

Figure 2.

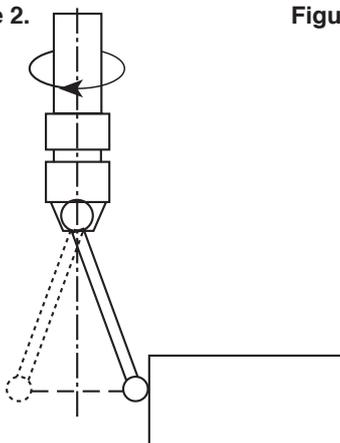


Figure 3.

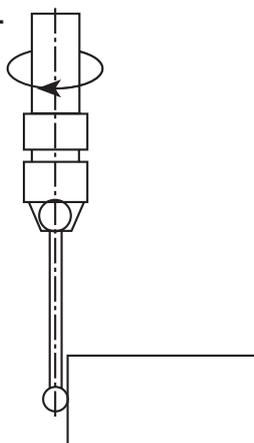


Figure 4.

