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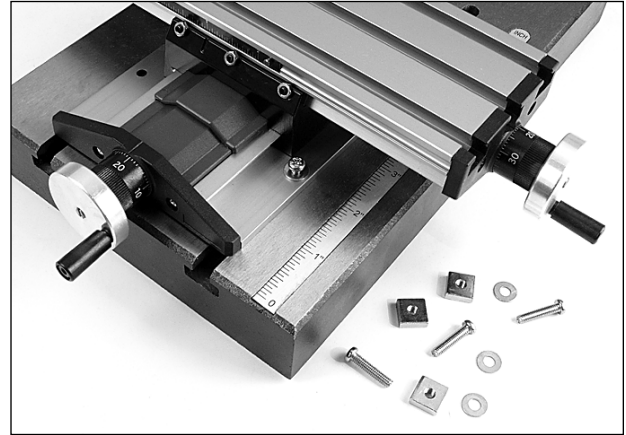
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INSTRUCTIONS FOR #82389 MICROLUX X-Y TABLE ATTACHMENT



To install X-Y Table as shown on #81631 MicroLux Drill Press, use the following hardware:

- 4 short Phillips head screws
- 4 small washers
- 2 small square nuts (in channel of base)
- 2 small hex nuts



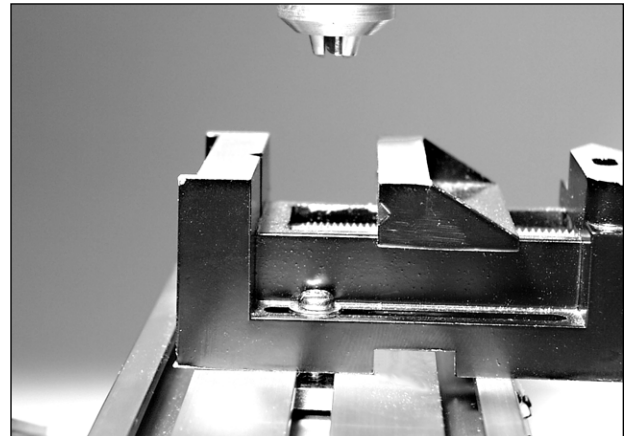
To install X-Y Table as shown on #82959 MicroLux Drill Press use the following hardware:

- 4 long Phillips head screws
- 4 small washers
- 4 large square nuts with small holes



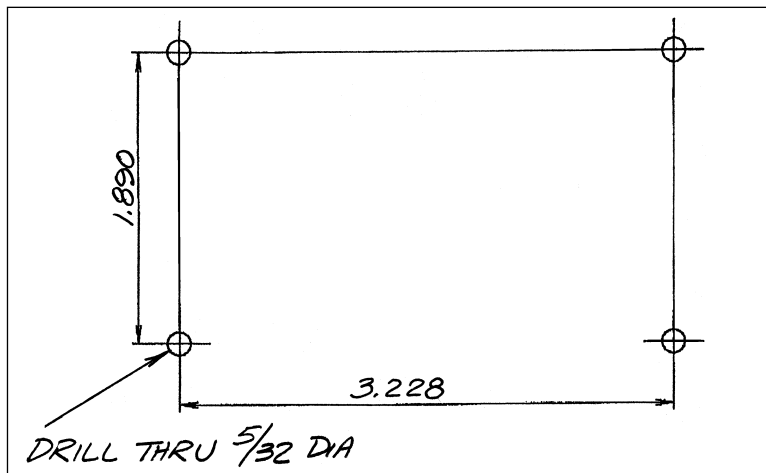
To secure workpieces to the X-Y Table use the following hardware:

- 2 threaded studs
- 2 large hex nuts
- 2 large washers
- 2 large square nuts with large holes



To install optional #15118 Vise to X-Y Table as shown use the following hardware:

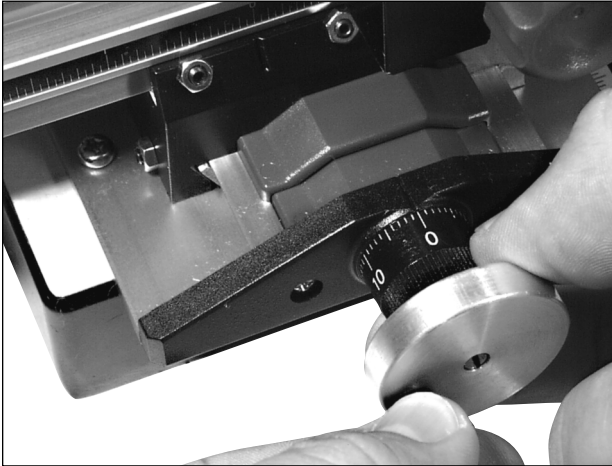
- 2 small Phillips head screws
- 2 small washers
- 2 large square nuts with small holes



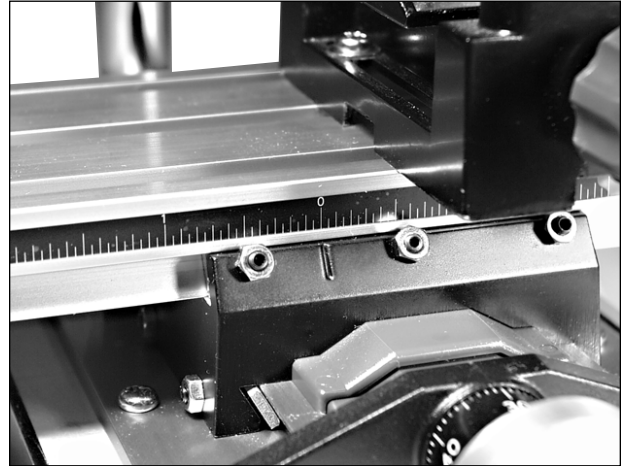
Hole layout required for mounting X-Y Table to non-MicroLux drill presses and fixtures.

(This is not a template. Hardware supplied for installation on MicroLux machines only.)

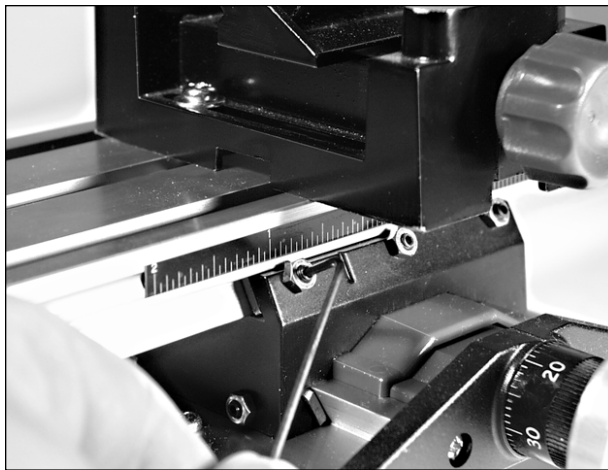
X-Y TABLE ADJUSTMENTS



The handwheel dials are zero-adjustable: hold the handwheel and turn the dial to zero.



Set the front scale by sliding it in its mounting groove. Each full revolution of the Y-direction handwheel moves the table one division (.050") on the front scale.



The gibs are pre-set at the factory. If the X-Y table develops side-play after much use, loosen lock nuts and adjust set screws with hex key provided. Do not over-tighten or table will become hard to move.

X-Y TABLE SPECIAL INSTRUCTIONS

If a handwheel is a bit hard to turn, an adjustment nut is located under the end cap at the opposite end of the threaded shaft that drives the table.

First: Back off the gib set screws alongside each slide...Loosen each lock nut, then back out each set screw one turn.

For the cross slide: Pop off the end cap. Hold the inner nut with a thin wrench of appropriate size, loosen the outer jam nut (caution: the nuts for the cross slide are left-hand...they loosen by turning to the right). Back off the inner nut just enough to make the hand wheel easier to turn, then tighten the jam nut to hold the setting. Replace the end cap.

For the longitudinal slide: Back off the lock nut slightly until the hand wheel turns easily. Replace the end cap.

Finally: Re-adjust the gibs so that the table moves with neither binding nor excessive play.

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