Micro-Mark®
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INSTRUCTIONS FOR #82677 TRUE-INCH CONVERSION KIT FOR MINI MILLING MACHINES

1. Remove end plate from left side of milling table. Crank table all the way to the right until the lead screw becomes disengaged, then slide the table off the dovetail slide (be careful...it's heavy!) and put it on your workbench. If necessary, hold the gib in place on the dovetail slide with a piece of tape.
2. Remove the two nuts in the center of the table handwheel and remove handwheel, dial, drag springs and key from lead screw.
3. Remove the lead screw (gently tap on handwheel-end with a wood block). Reinstall the bearings if they fall out. Remove the threaded brass block from its pocket in the dovetail slide on the machine.
4. Use the above steps in the reverse order to reassemble the table assembly, substituting conversion kit parts for those that came with the machine.
5. Place the new brass block in its pocket in the dovetail slide and adjust the set screws so that they eliminate side play of the block without hindering up-and-down or front-to-back movement.
6. Remove the front rubber chip guard and turn the front handwheel to move the dovetail slide most of the way towards the column.
7. Remove the two nuts that retain the front handwheel and remove the handwheel, dial and drag spring from lead screw. Remove two screws holding indicator block, then unscrew lead screw from machine (rotate clockwise), taking the indicator block with it. Remove indicator block from lead screw.
8. Loosen the cap screw on the front of the dovetail slide and remove the threaded brass block. Replace it with the one from the conversion kit. Adjust the cap screw to eliminate front-to-back play without hindering side-to-side or up-and-down movement of the block.
9. Reassemble the indicator block, new lead screw and key. Install the lead screw through the front hole and thread into the brass block (counter-clockwise). Thread far enough to allow the collar of the lead screw to sit in its recess in the base. Install the indicator block with the "0" mark facing upward. Reassemble the remaining Y-axis components with the new dial. Reinstall the rubber chip guard.
10. Make sure the gib is positioned properly and reinstall the table. You may have to GENTLY rock the table back and forth to get it to slide on. (Note: if you cannot slide the table into the dovetail, then back off the nuts and set screws holding the gib so that the gib is loosened). Engage the lead screw of the table into the brass block and turn the handle to bring the table to mid position. Attach the end plate to the left side of the table.
11. Adjust the gibs according to the instruction manual (if necessary).
12. Please proceed to the instruction manual for the complete set up.

If you have any difficulty, you may call our technical service department at 908-464-1094 between the hours of 1 pm and 5 pm, Monday through Friday Eastern Time, for assistance.