

## INSTRUCTIONS FOR #80818 "WIGGLER" CENTER FINDER SET

1. Insert and secure the 3/8" dia. shank end of the wiggler body into the chuck or 3/8" collet of the milling machine spindle. Mount the workpiece on the milling machine table or in the milling vise\*.
2. Insert the 5/16" dia. ball end of the contact probe into the chuck of the wiggler body. Lightly tighten the knurled nut of the chuck so that the probe can't fall out, but is still free to move. Align the shaft of the contact probe vertically so that it will run approximately true.
3. Turn on the machine. Notice how the probe wiggles as it rotates.
4. *Slowly* rotate the milling table lead screw in the proper direction to bring the surface being located into contact with the rotating probe. Initially, contact with the probe will be intermittent, but as the surface moves into greater contact with the probe and into better alignment with the center of the spindle, the wiggling will decrease.
5. Then, just as the surface of the workpiece moves into perfect alignment with the spindle and the wiggling stops, the probe will suddenly swing over to the side. From this exact point, continue moving the workpiece for one-half the diameter of the contact probe\*\*. The surface of the workpiece will now be located directly under the center of the spindle and the indicator knob on the machine lead screw may be reset to read "zero."

\*The Wiggler Center Finder Set may also be used to locate the faces of the vise jaws themselves. The vise should first be set "square" to the table movement with the help of a dial indicator and clamp mounted in the spindle using the included holder.

\*\*The needle point shaft supplied in the kit may be used to directly locate punch marks or scribed lines. This extra movement would then be unnecessary.

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