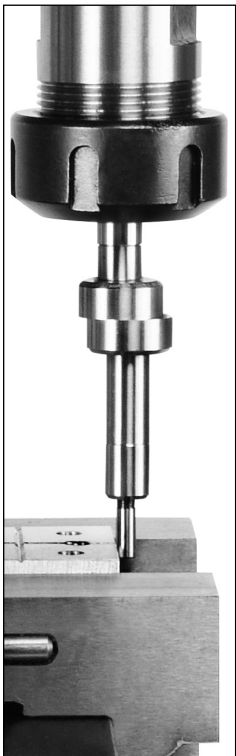


INSTRUCTIONS FOR USE

#84749 COMBO EDGE FINDER



An edge finder is used to visually locate the machined edge of a workpiece. The edge finder is comprised of a shank with a floating tip retained by an internal spring.

- Mount 10mm diameter shank of edge finder in collet or drill chuck.
- Set spindle speed to approximately 1000 rpm.
- Slide edge finder tip (bottom half of edge finder) off-center.
- Turn spindle on. Raise the knee or lower the quill to bring the edge finder tip adjacent to the workpiece. Be sure to avoid any burrs on the workpiece.
- SLOWLY move along the X-axis or Y-axis to make contact between the edge finder tip and the edge of the workpiece.
- Continue to slowly advance the workpiece toward the edge finder tip. The two disks will start to appear concentric. As soon as the tip jumps sideways, STOP feed (or you will damage the edge finder).
- The spindle is now positioned at an offset, which is half the tip diameter away from the edge of the workpiece (diameter = 4mm / .1575").
- Lower the workpiece or raise the quill until the tip of the edge finder is above the workpiece.
- Now advance the table 1/2 tip diameter (2mm / .0785") farther to bring the spindle directly over the edge of the part. Set the DRO or handwheel to zero.

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