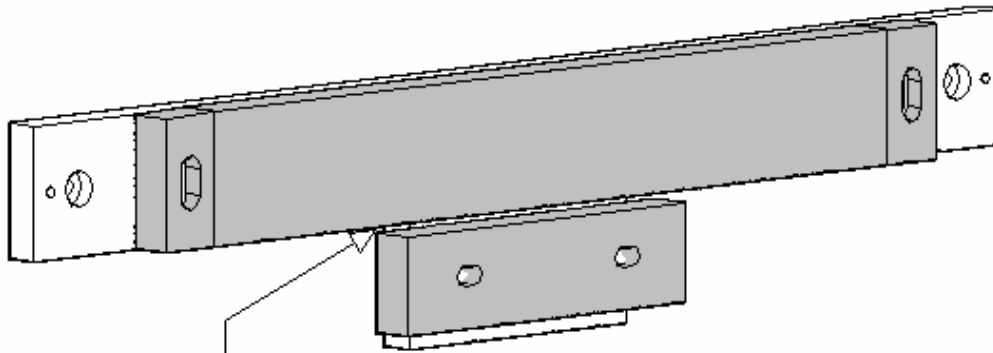


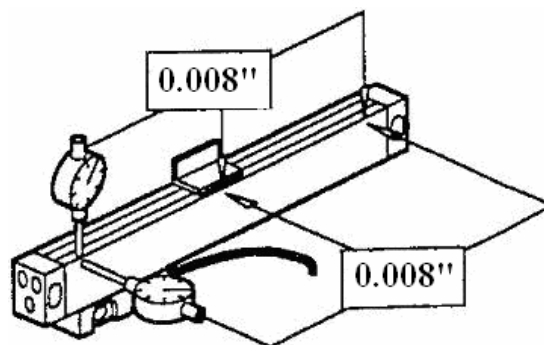
**** (ENGLISH SCREWS ARE SUPPLIED IN THE HARDWARE KIT TO MOUNT THE READER HEAD. THE METRIC SCREWS ARE NOT NECESSARY.) ****

SPACING



For M Series scales, the spacing between the scale and the reader head **MUST** be 0.040 inches (1mm) \pm 0.02 inches (0.5mm)

ALIGN THE SIDES OF THE SCALE by indicating the ends and the center.

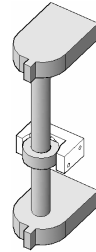




1) Mounting of Quill Stop bracket:

The quill stop on the machine has to be in good condition and shouldn't have too much play in it. If it has too much play it may have to be replaced.

Mount Quill Stop bracket onto front of quill stop with 1/4-20 SHCS and taper nut making sure that it seats properly and it is tight.

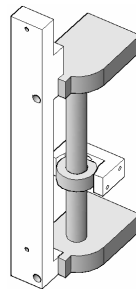


2) Mounting of Scale Backer Bar:

Hold Scale Backer Bar tightly into the two notches and flush to the bottom one.

Use a transfer punch to locate the two mounting hole locations. You will need to drill and tap these for 10-32 SHCS.

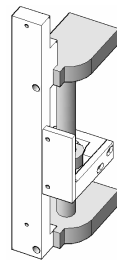
NOTE: Take extra care not to drill too deep or you could damage the power down feed.



3) Mount scale onto the Scale Backer Bar square and parallel per scale manual specifications.

Mounting of Reader head bracket

Bolt Reader head bracket to the Quill Stop bracket with 8-32 SHCS. To adjust this bracket in and out the slots, side to side you will need to shim between the two.

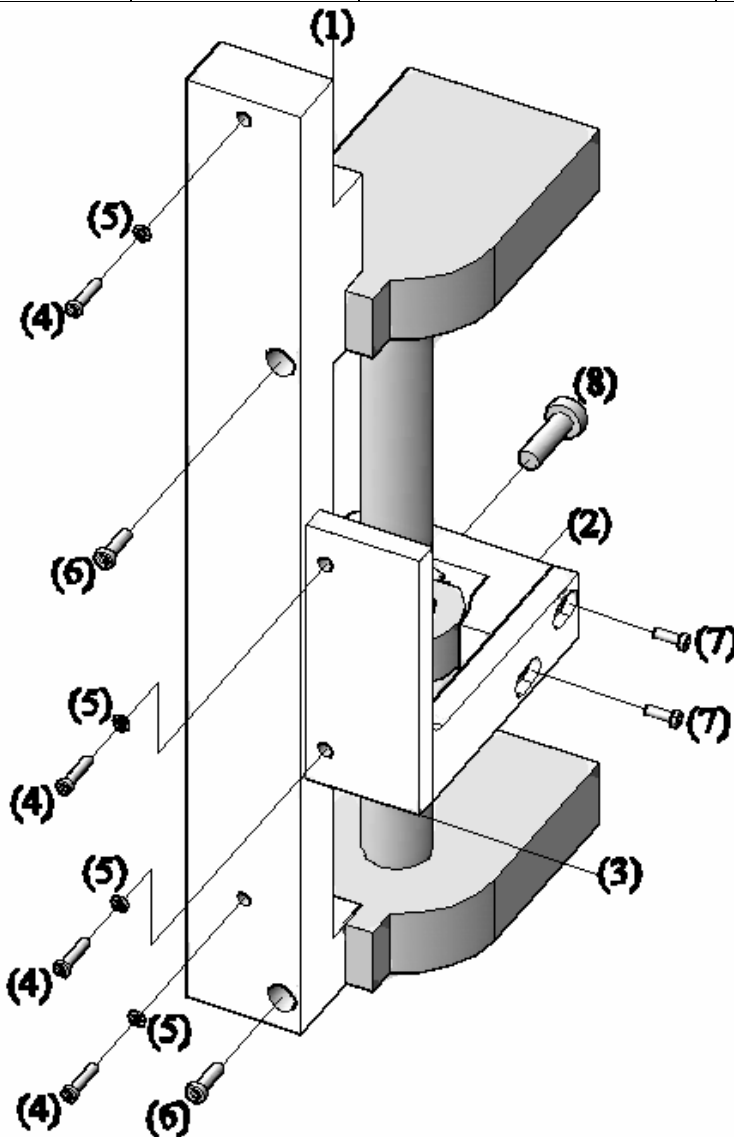


4) Mount scale reader head per scale manual specifications.

5) Tie up cables properly so that they won't get caught on anything and check for scale over travel before putting machine into service.

PARTS LIST

Code #	Quantity	Size	Description
1	1	-	SCALE BACKER BAR
2	1	-	QUILL STOP BRACKET
3	1	-	READER HEAD BRACKET
4	4	8/32 x 1	S.H.C.S.
5	4	M4	WASHERS
6	2	10/32 x 1	S.H.C.S.
7	2	8/32 x 1/2	S.H.C.S.
8	1	1/4-20 x 5/8	S.H.C.S.
9	2	1/4-20	TAPER NUTS



Recommended Tools

7/64 Hex Key	9/64 Hex Key
5/32 Hex Key	3/16 Hex Key
1/4 Hex Key	Screwdrivers
Wire Snips	Power Drill
No. 7 Drill	1/4-20 Tap
No. 29 Drill	8-32 Tap
No. 21 Drill	10-32 Tap
F Drill	5/16-18 Tap
Indicator with Base	6mm Hex Key
3mm Hex Key	1.5mm Hex Key

TROUBLESHOOTING: Scale does not count. Verify spacing and alignment.