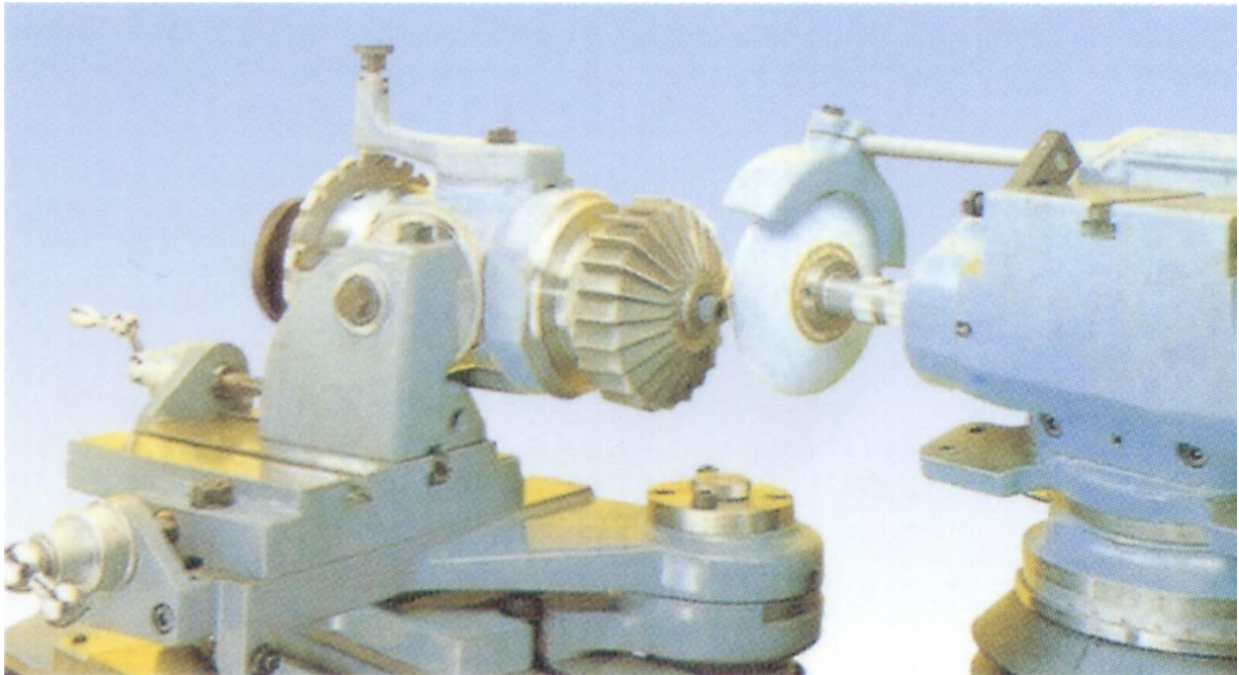


8.3 Circular Arc No. 2



1. Introduction

The device is suitable for side milling cutter, circular arc grinding, and setting the position of the side of a micrometer adjustment to eliminate the grinding error. The operating range of the radius is 0-1" (0 to 25mm) and the tool diameter is 0-12" (0 to 300mm).

2. Product Specifications

Radius to be ground	0 - 25 mm (0 - 1 in)
Maximum operating range	300 mm (11 - 3/4 in)
Spindle taper	One end ASA #5 Other end B&S #12 (or M.T. #5)
A Type	30 - 115mm (1- 3/16 – 4 - 9/16 in)
B Type	25 – 110mm (1 – 4 3/8 in)
Horizontal rotation between the centerline and the maximum diameter of Spindles centerline	160mm (6 - 5/16 in)
Spindle rotation angle (Horizontally)	90°
Spindle rotation angle (Vertical)	±30°

3. Installation

(a) The first Circular arc NO.2 the main arc placed on M-40 of workbench.



(b) Then the T-screw into the M-40 T-slot workbench.



(c) Push and insert the base of the 2nd Circular arc groove aligned.



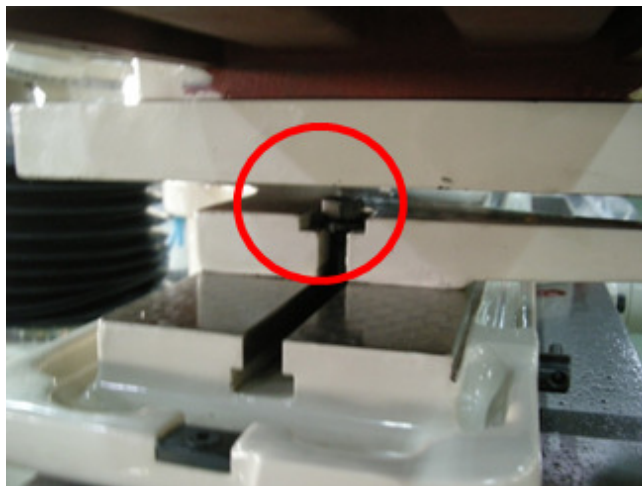
(d) Put the washers.



(e) Then tighten the fixing nut.



(f) Other side of the lock fixed in accordance with the above procedure.



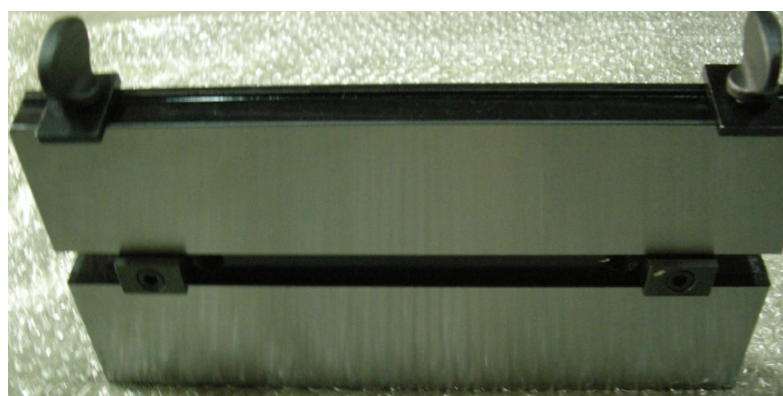
(g) Working head and Circular arc NO.2 on the do with.



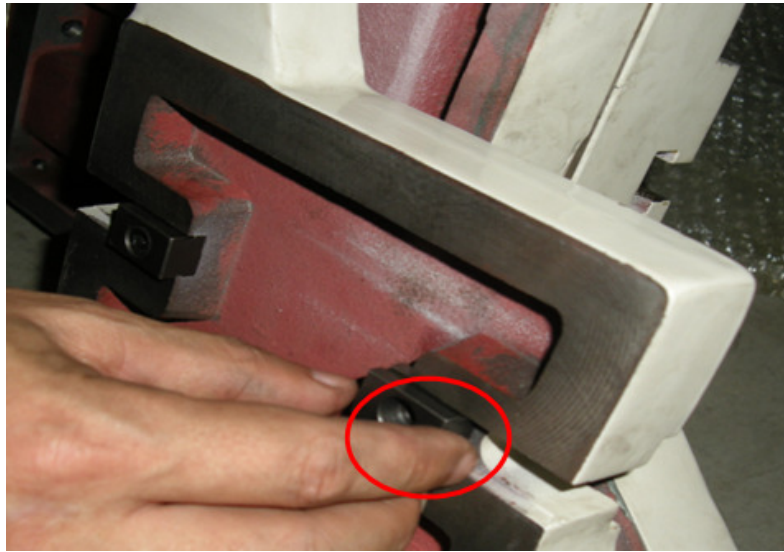
(h) Before use with fixed locking bolts and spring washers to complete the installation.



(i) There are installed with optical ruler must install this one pad.



(j) Remove this fixed block pad for easy installation.



(k) Pad mounted below.





(l) This has two M12 screws, lock pad use.

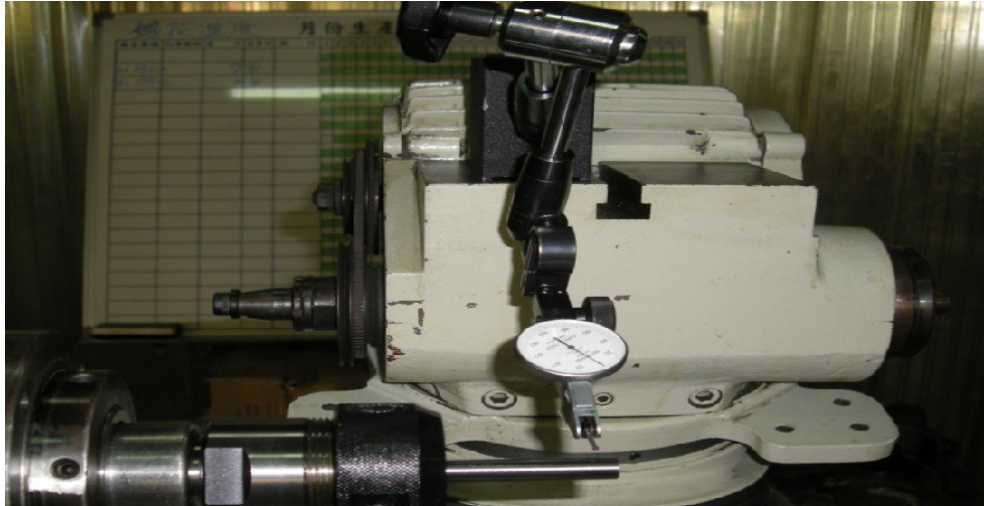


(m) After locking.

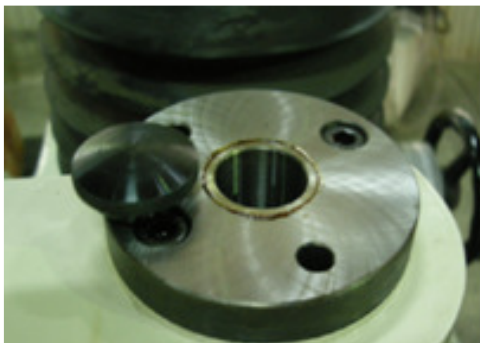


4. Method of operation

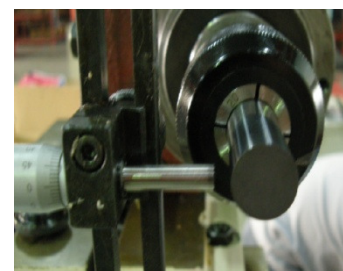
(a) Major correction workpiece level.



- (b) Whether the 2nd correction workpiece rotation center, with a center line of this part have attached a random attachment
 Member operates as follows: The center of rotation 2 → put the lid open attachments.

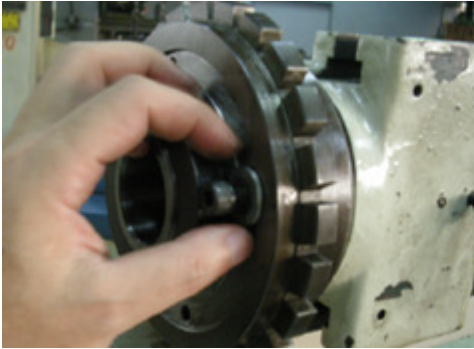


- (c) 25mm rod clamp on the premise of the center of rotation angle correction set at 0 degrees.

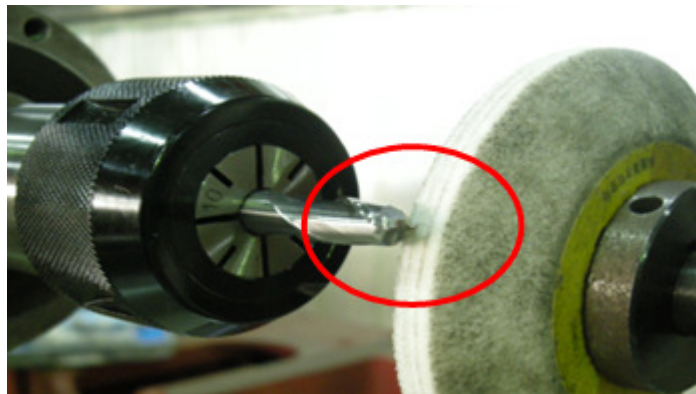


- (d) Correction center to move the 2nd short axis (Y-axis) will be the same before and after the correction from the long axis (X-axis) as to interfere with removable attachments.

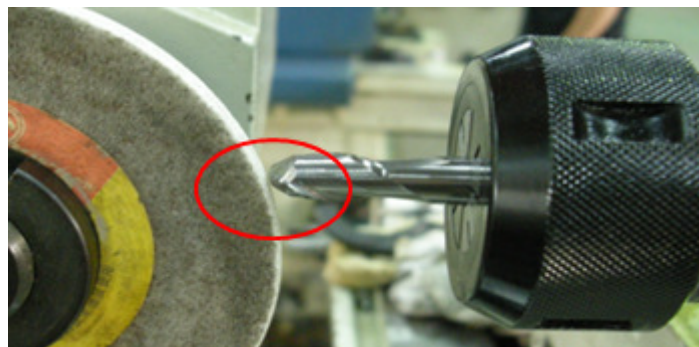
(e) Mounted on the knife before indexing device.



(f) Processing will begin preparing the knife fell to the needs of the Grinding wheel spindle height to grind Circular arc knives.



(g) In the polishing operation 0 degrees to 90 degrees.



(h) 1/4 after a good round for Flutes grinding mill can grind feed Circular arc must
BED Y axis feed, is not determinable by two
No. motivated knife or grind is not really the center circle Circular arc to run away.

6. Circular Arc No. 2 List

Project	Product No.	Name	Specification	Quantity
1	M120010**	Fix seat		1
2	M120011**	Scale ring		1
3	M120030**	base		1
4	M120040**	Aspect two seats to mobile		1
5	M120050**	Block feed around		1
6	M120060**	Guides fix seat		2
7	M120078**	Guide nut		2
8	M120088**	Screw pole		1
9	M120098**	Screw pole		1
10	M120100**	Fix collars		2
11	M120118**	Scale ring		2
12	M120120**	Bushings		1
13	M120130**	Bearing cap		1
14	M120140**	Gasket		1
15	M120150**	Axis of rotation		1
16	M120160**	Scale ring		1
17	M120170**	Positioning rod		1
18	M120180**	Support ring		1
19	M120190**	Fulcrum		1
20	M120200**	Gasket		1
21	M120210**	Positioning nut		1
22	M120220**	Clamping block		1
23	M120230**	Dust-proof cover		1
24	M120260**	Bolt		4
25	M120270**	Bolt		1
26	M120280**	Bolt		1
27	M120290**	Handle		2
28	M120300**	Bolt		2
29	M430070**	Fix nut		1
30	M450030**	Key		6
31	GB020020	Tapered Roller Bearings	30207	1
32	GB020059	Tapered Roller Bearings	30212	1
33	M451060**	Hand lever fix screws		2
34	M110380**	Adjust positioning nut		2