

FIG. 1

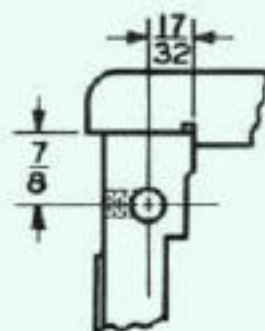


FIG. 2

### HOW TO INSTALL THREAD INDICATOR DIAL

CLAMP THE LEAD SCREW HALF NUTS OVER THE THREADS OF LEAD SCREW AND PUT ON THREAD DIAL INDICATOR BY PLACING THE SHAFT OF INDICATOR IN HOLE ON RIGHT SIDE OF APRON AT "B".

IF NECESSARY TO DRILL APRON TO RECEIVE THE INDICATOR SHAFT, DRILL A  $\frac{3}{8}$  HOLE IN APRON, LOCATED AS SHOWN IN FIG. 2. THEN DRILL A  $\frac{13}{64}$  HOLE, LOCATED AS SHOWN IN FIG. 1, ON FRONT OF APRON AND TAP IT  $\frac{1}{4}$ -20 THREAD FOR  $\frac{1}{4}$ -20  $\times$   $\frac{3}{8}$  HOLLOW HEAD SET SCREW FOR LOCKING INDICATOR SHAFT TO APRON.

SWING THE INDICATOR WORM WHEEL INTO MESH WITH THE LEAD SCREW, BEING SURE THAT THERE IS NO BINDING AND NOT TOO MUCH BACK LASH BETWEEN THE WORM WHEEL AND LEAD SCREW. THEN LOCK THE SHAFT WITH SCREW AS SHOWN AT "C".

TO ADJUST DIAL MARKS TO COINCIDE WITH WITNESS MARK, INSERT HEX. WRENCH IN HOLE "A" AND LOOSEN SET SCREW JUST ENOUGH TO ALLOW SHAFT TO TURN. LEAVE THE HEX. WRENCH IN THE SLOT TO PREVENT DIAL FROM TURNING DURING THE NEXT OPERATION.

MESH THE THREAD DIAL WITH THE LEAD SCREW. CLOSE THE LEAD SCREW HALF NUT AND RUN LATHE UNTIL CARRIAGE TRAVELS AN INCH OR TWO TOWARD THE HEADSTOCK.

WITNESS MARK AND DIAL MARK MUST COINCIDE, THEN TIGHTEN SET SCREW SECURELY AND REMOVE HEX. WRENCH.

### HOW TO USE THREAD INDICATOR DIAL

FOR ALL EVEN THREADS, CLOSE LEAD SCREW HALF NUT ON ANY LINE ON DIAL. FOR ALL ODD THREADS, CLOSE LEAD SCREW HALF NUT ON ANY NUMBERED LINE ON DIAL.

FOR ALL THREADS INVOLVING  $\frac{1}{2}$  THREAD, SUCH AS  $1\frac{1}{2}$ , CLOSE LEAD SCREW HALF NUT ON ANY  $\frac{1}{2}$  REVOLUTION OF DIAL.

UNIT				9" 10K LATHE THD DIAL			
SHEET NO.		NO. SHEETS		SCALE			
SOUTH BEND LATHE, INC.				SOUTH BEND, IND., U.S.A.			
DRAWN BY		C'D. BY		TRACED BY		C'D. BY	
MORGAN		MORGAN		MORGAN		JW	
DATE		LET.		WAS		DR. NOTICE	
3-21-46				3-21-46		4-2-46	