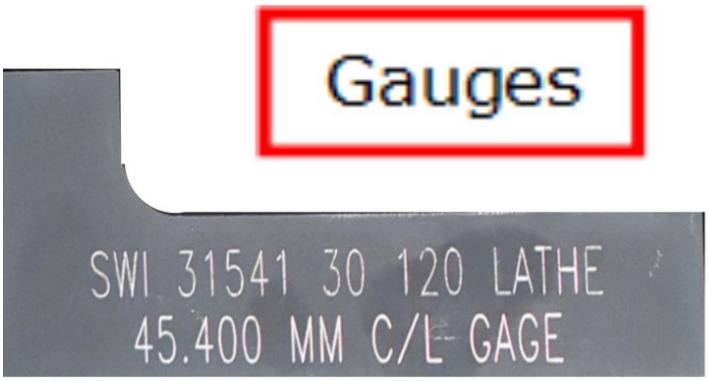
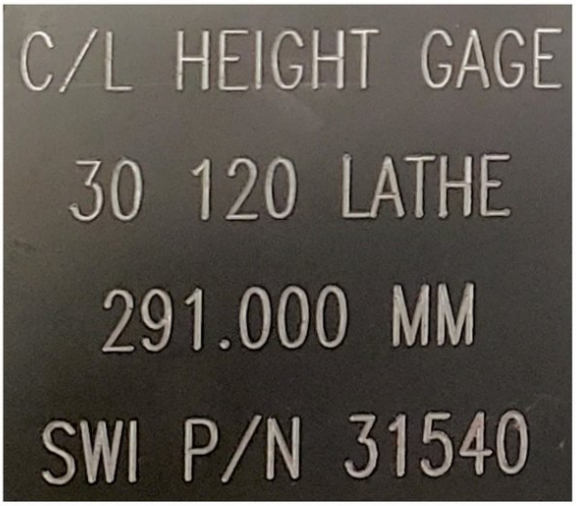
Big Lathe Turret - 30120RX Grind Base to Match Centerline

Written By: Trent Plungas

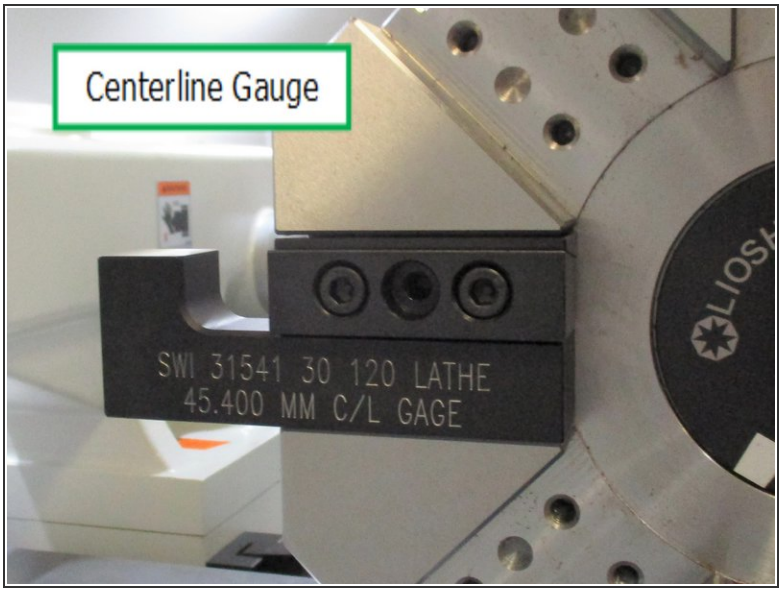






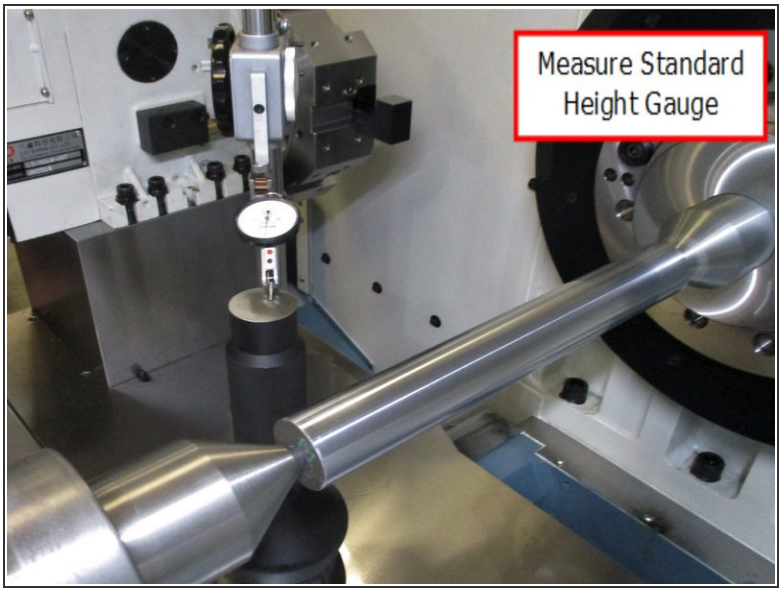
Step 1 — Test Equipment

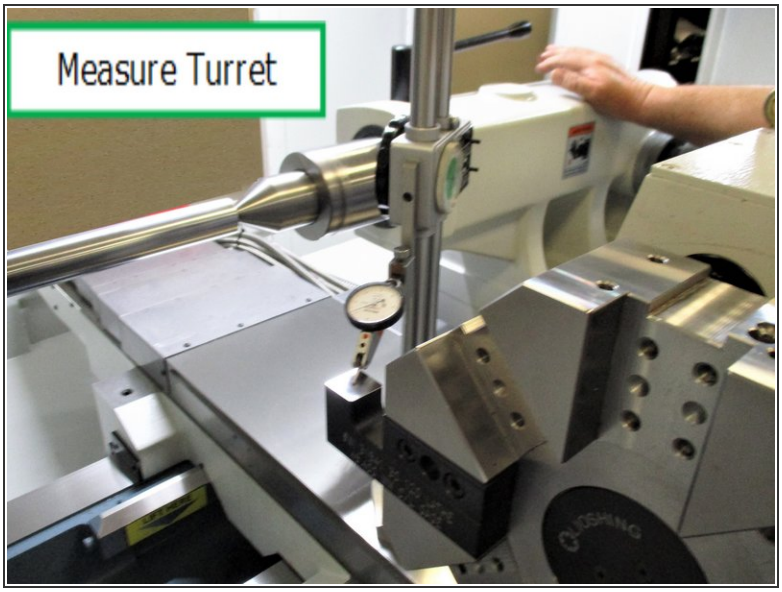




- Standards: you will use the Centerline Gauge for this calculation. Height Gauge is used during machine inspection to measure the centerline height. We need that measurement for this calculation.
- Mount the gauge into the turret. Height of machined flat spot of the gauge is 20 mm above the centerline of the cutting edge on the turret.

Step 2 — Take Measurments to find Base Dimension





- Zero out the dial gauge on the standard height gauge.
- Carefully slide over the dial indicator to measure the height of the turret.
- The difference from the height gauge, the centerline gauge, and the turret height will give you the number needed for the base. This part is ground to that specific dimension at TRAK.
- **Example:**
  - Spindle Centerline - Turret Centerline = Turret base height
  - Turret centerline will come from the documentation sheet. We can double check it with the factory setup turret base. We should get a measurement of +/-.05mm (+/-.002”),
  - 290.000 Gauge Standard - 20 C/L Standard - 80 Turret = number needed for base (millimeters)

ⓘ The 8 Tool Turret = 80 number is supplied by the manufacturer, rounded here to show theory, actual number is much more accurate.