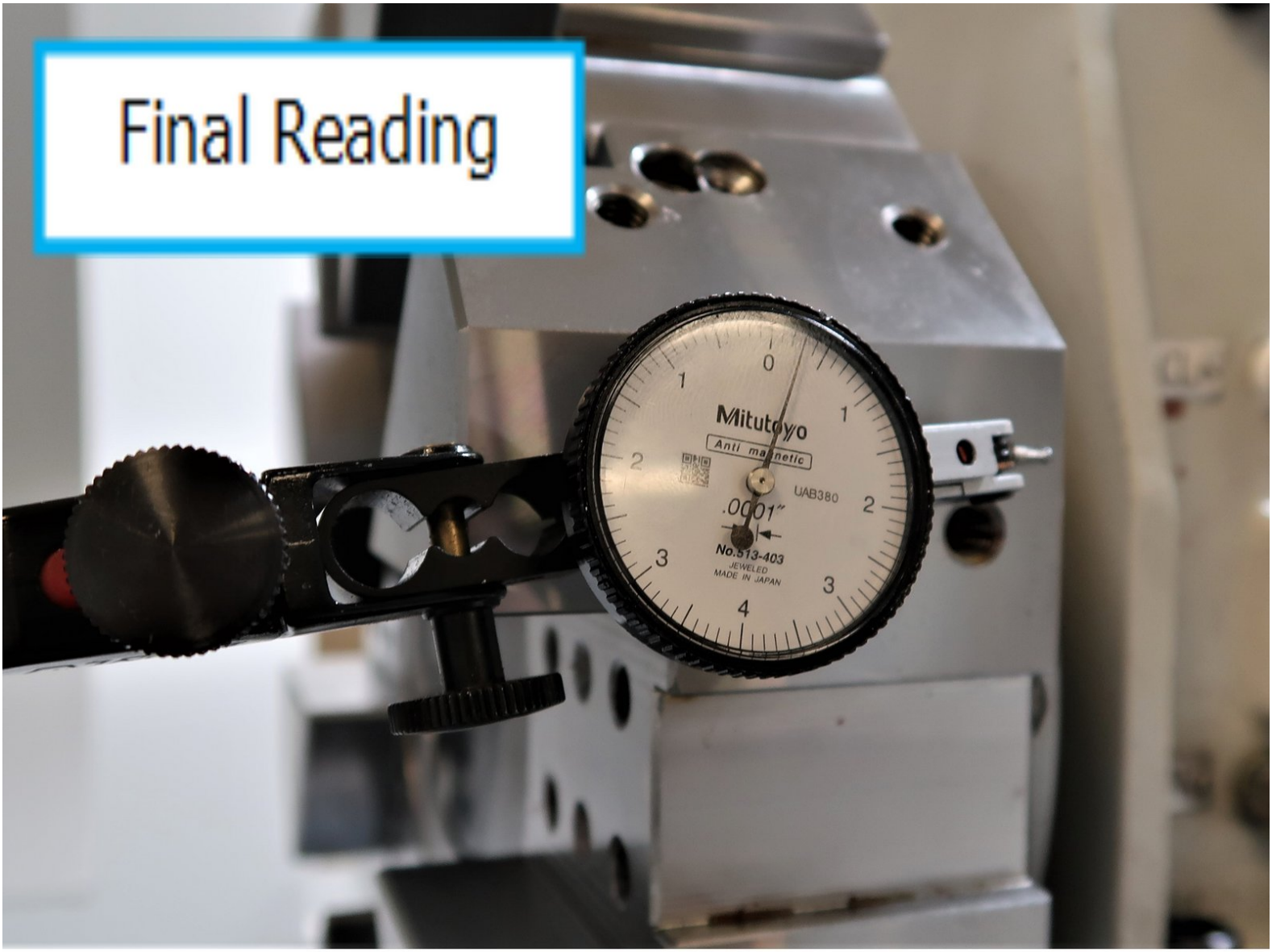
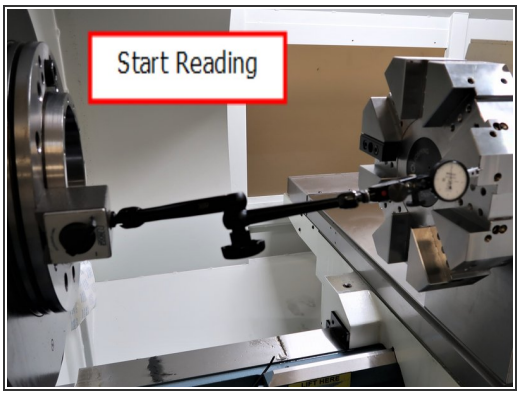
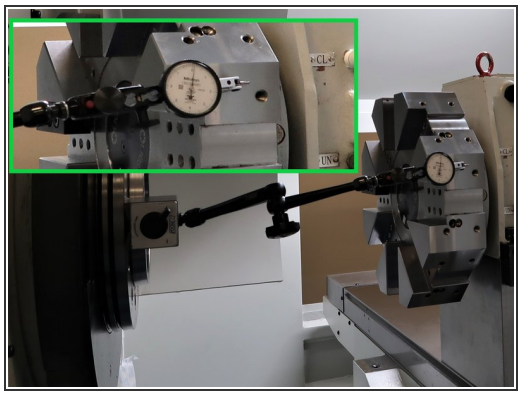
Big Lathe Turret - Align Turret to Z - Set Tolerance

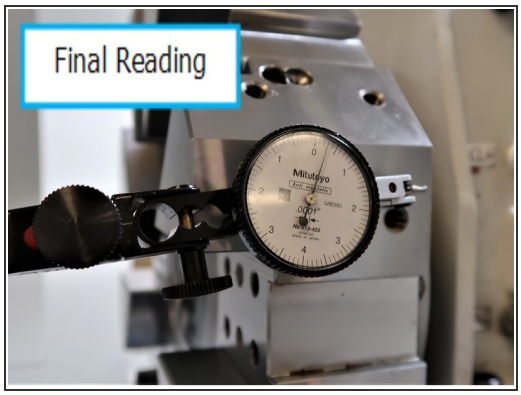
Written By: Trent Plungas



Step 1 — Checking the Accuracy of Turret



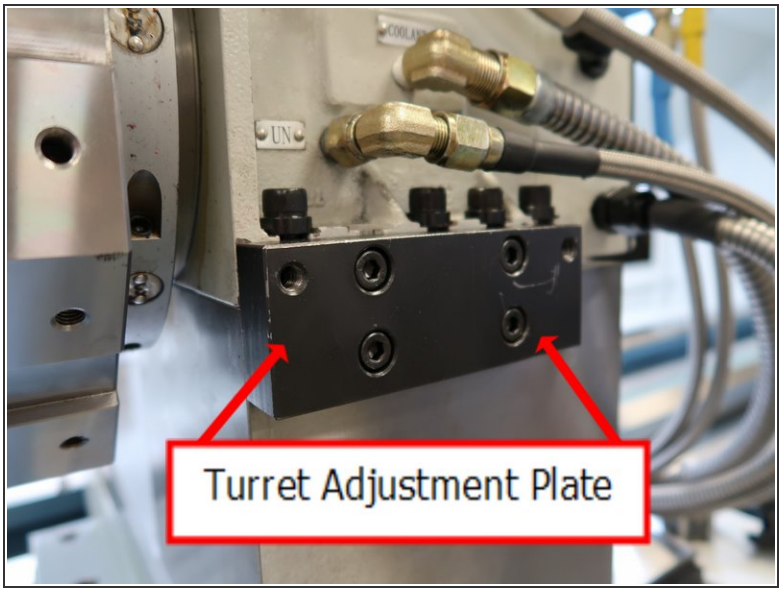


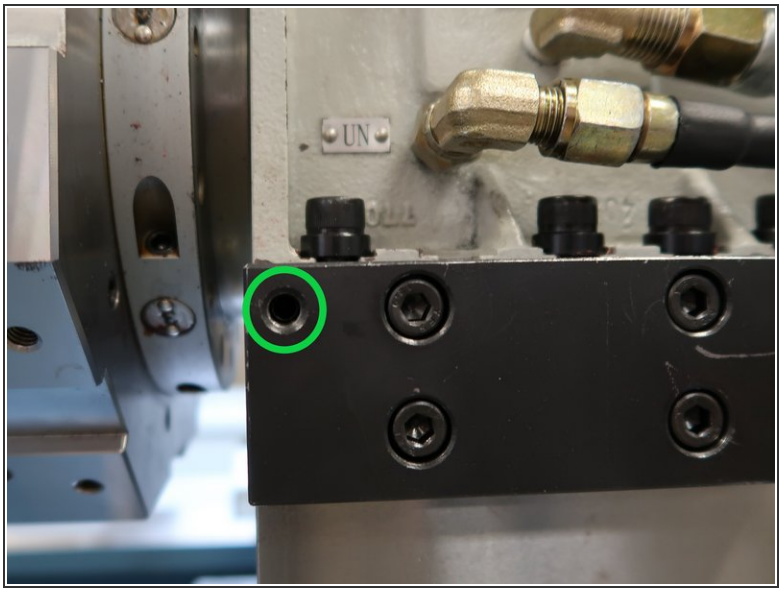


- Set up dial indicator on the spindle as shown. Adjust to read smooth surface on the turret. Start at one end of the surface.
- Reading along the surface, dial indicator close to zero.
- Final reading at the end of the smooth surface shows .0002 difference.

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Step 2 — Adjust Turret if Needed





- If needed and adjustment can be made to meet spec of 0.0005" over the length of the measured surface. The socket head cap screws (SHCS) on the bottom row of the turret adjustment plate should be tight while the top row should be loosened a little as well as the bolts holding the turret.
- There is a set screw on each end of the adjustment plate. Use top row center two socket head cap screws (SHCS) screws to pull on the turret, and the set screws to push on the turret to adjust. Make small changes at a time and check the measurement. You can do this as needed to get a reading within Spec. of .0005” or less.

After adjusting, SHCS and setscrews should all be tight to not allow for shifting.