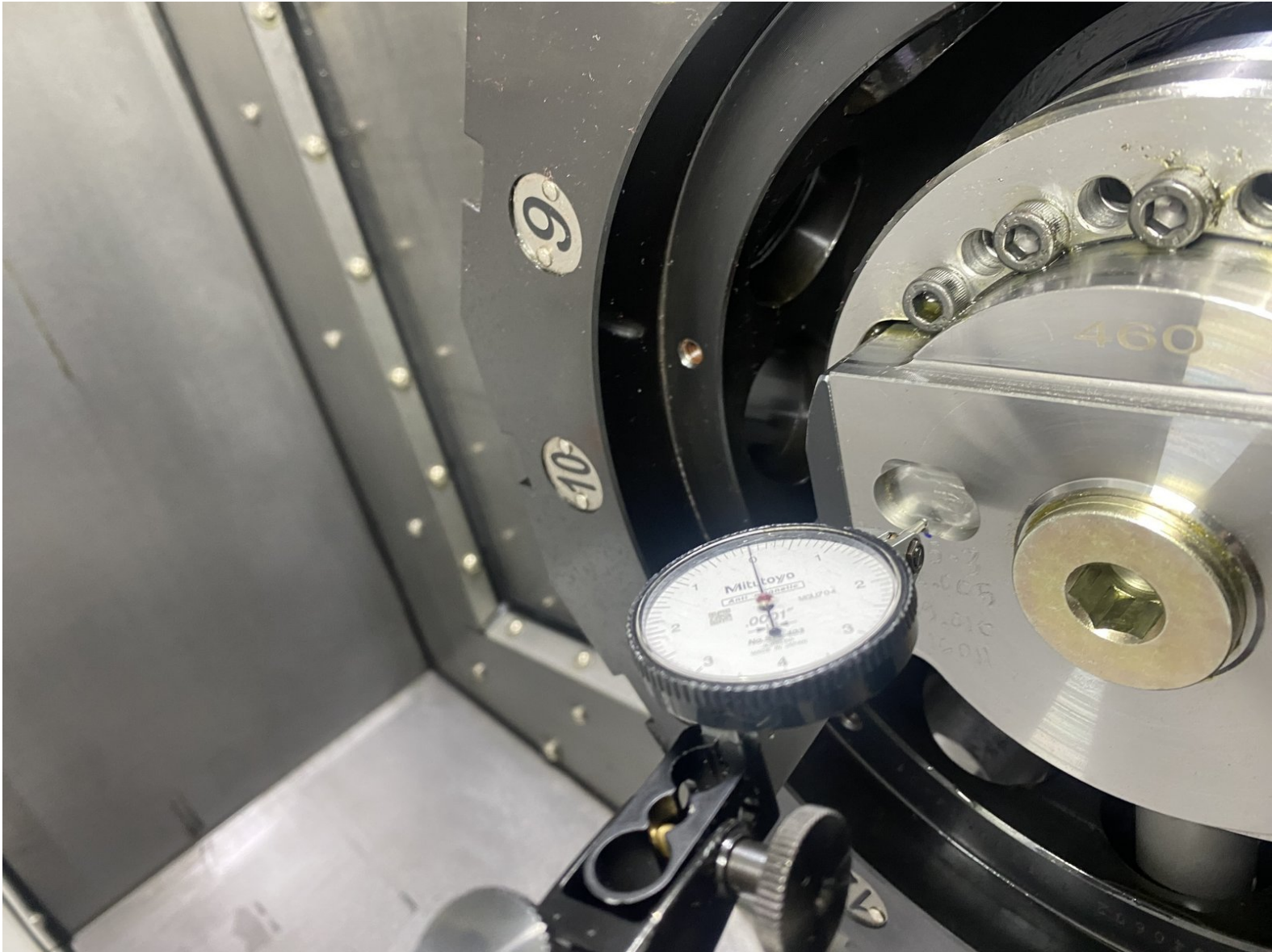


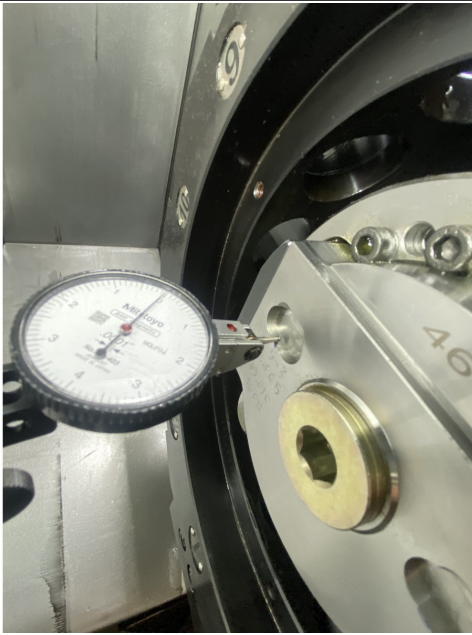


TC820LTYsi- Turret Alignment

Written By: Dylan Parr

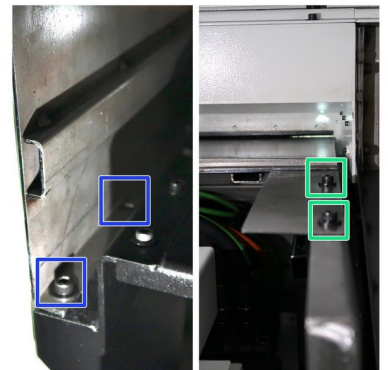
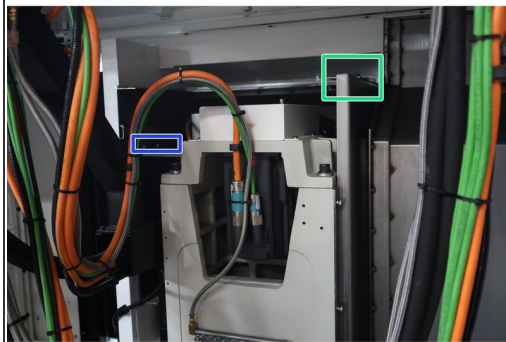
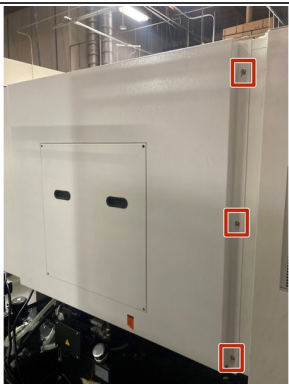


Step 1 — Checking tram of turret



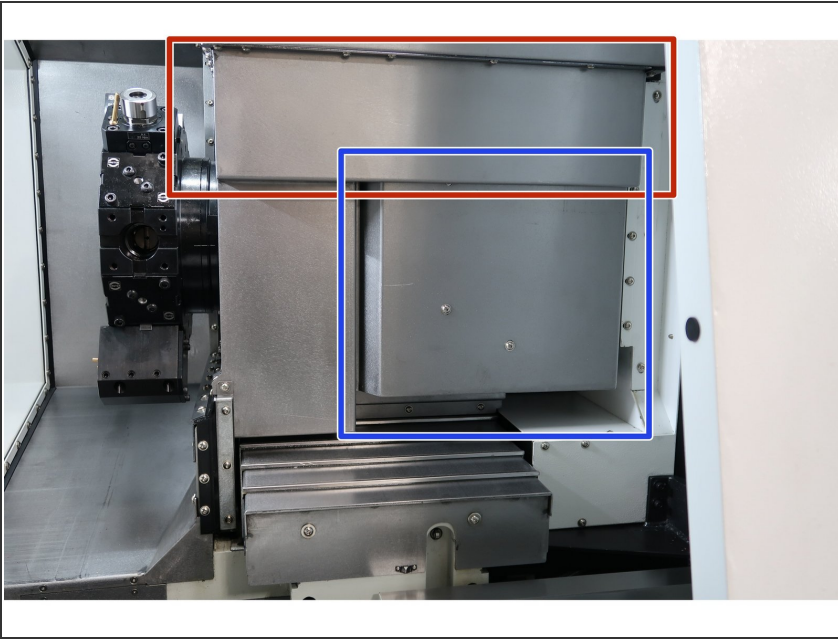
- In the event of a crash or suspected repeatability issues, checking the turret alignment is necessary.
- To check turret alignment, position an indicator into the two pockets and measure back and forth in the X direction, noting the tram measurements.

Step 2 — Removing Sheet Metal Covers (backside)



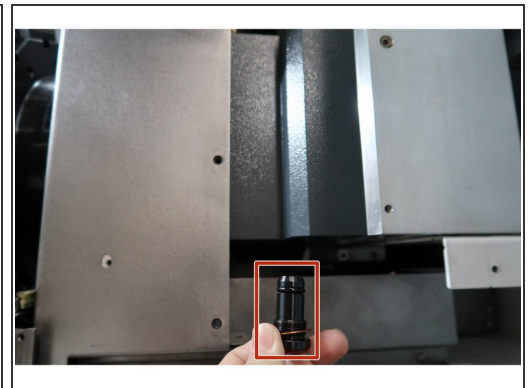
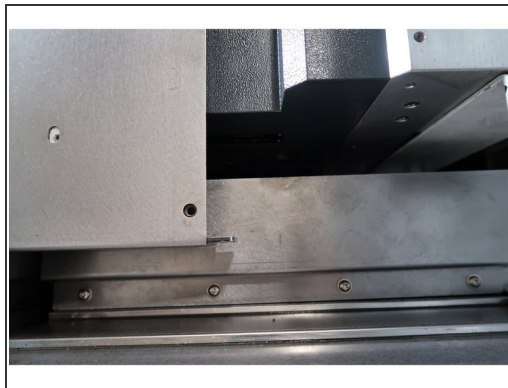
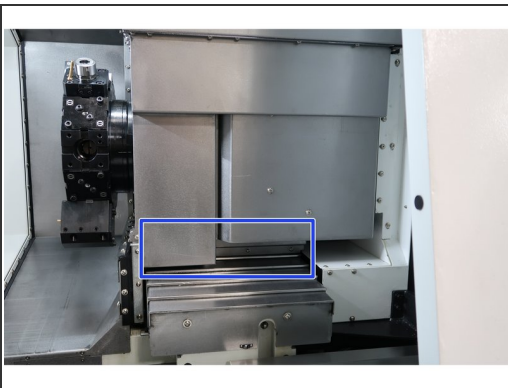
- Begin by loosening the **six 4mm screws** on the sheet metal cover at the back of the machine; there's no need to remove them completely. Slide the cover upward and pull it outward to detach.
- With the main panel removed, locate the specified areas for the **5mm socket head cap screws** securing the front panels.
- Remove the **two 5mm** socket head cap screws (SHCS) on the **left side**.
- Remove the **two 5mm** socket head cap screws (SHCS) on the **right side**.

Step 3 — Removing Sheet Metal Covers (frontside)



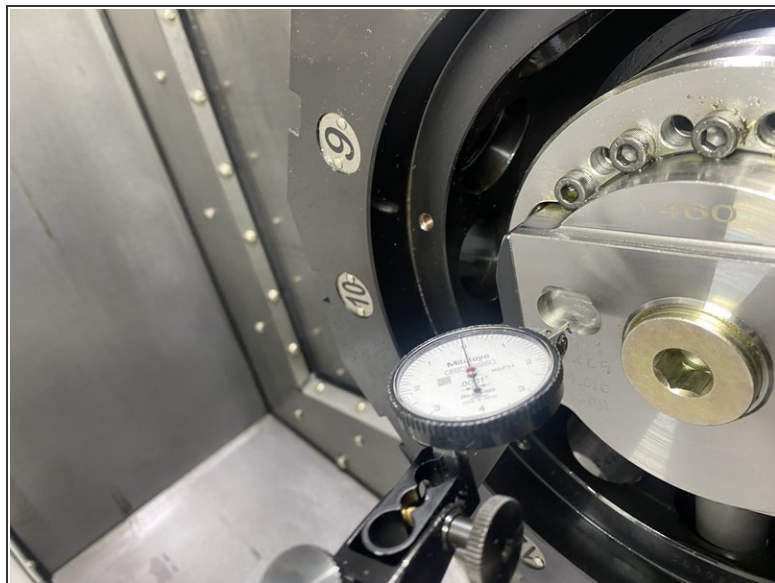
- The highlighted covers must be removed to access the locking mechanism for the turret.

Step 4 — Adjusting Turret Alignment



- The area needing access is highlighted in blue. The following steps reference this area once the covers have been removed:
- There is a **black, threaded plug** on the underside that can be removed using a **6mm hex key**.
- Beneath this plug, there is a **5mm hex screw** that, when loosened, will allow the turret to move.
- By tapping the turret with a rubber mallet, small adjustments to the turret's alignment can be made.

Step 5 — Confirm alignment and reinstall covers



- Using a **tenths indicator**, tram the turret using the ground oblong pockets on the face of the disk.
- Once the turret is tightened down and rechecked for **squareness**, reinstall the plug and sheet metal.
- The turret is now aligned.