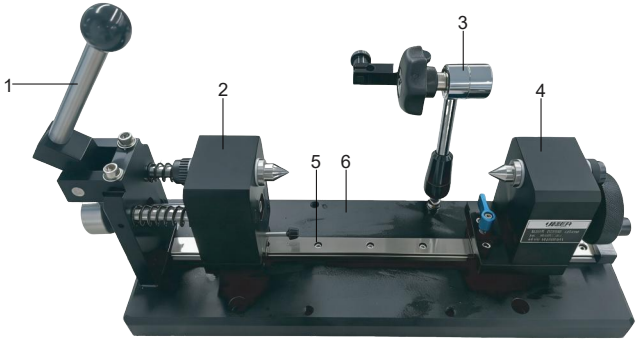
OPERATION INSTRUCTION

Bench Center

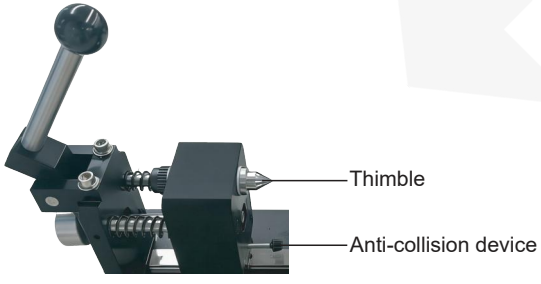
Code	Center height	Distance between two centers	Runout accuracy
4739-151	70mm	150mm	2μm



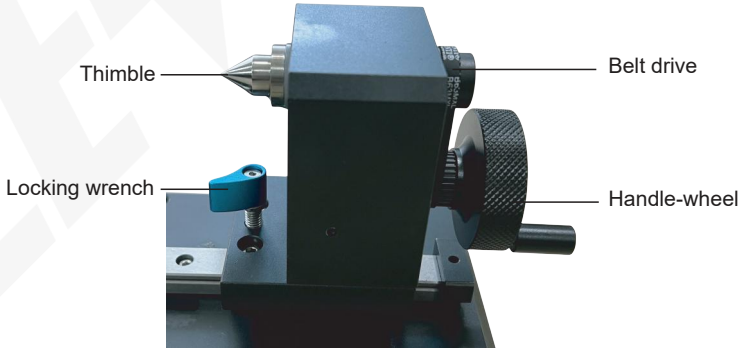
1-load/unload handle
2-Left tailstock
3-Indicator holder
4-Right tailstock
5-Guide6-Base
7-Standard rod

1. Bench center is mainly used to measure cylindrical workpiece's circular runout. Quick positioning, suitable for mass measure-ment

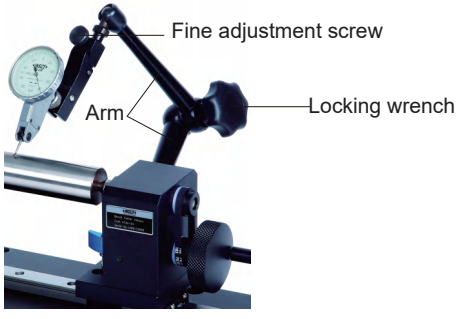
2. Description of each part: Left tailstock: Left tailstock can be moved left along the guide by pressing the load/unload handle, and then released to return to its original position. There is an anti-collision device at the bottom of tailstock to prevent violent pushing and hitting the thimble.



Right tailstock: Right tailstock can be moved through guide, and then fix it with rotating locking wrench.
Hand-wheel: Rotate the workpiece by rotating hand-wheel.



Indicator holder: Clamp the indicator to fix it. Clamp the indicator by dovetail groove or stem hole, the direction of fine adjusting movement is contrary to the direction of the measuring point by force, which avoids to affect the result. Loosen locking wrench, arm and locking device can move freely, tighten it after setting its position.



MN-4739-E
V1

3. Usage:

---Holding probe as below ways.

Caution:To avoid the measurement error which caused by fine adjustment elasticity, the lever needle and the fine adjust□ment screw should be located at the opposite side(fig.1);

When working, adjust the fine adjustment screw so that component 1 is between the top of thread and the middle of thread, to increase the elasticity of head, do not let component 1 be at the bottom of thread(fig.2).

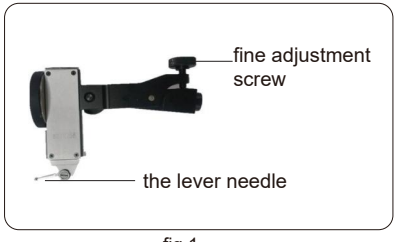


fig.1

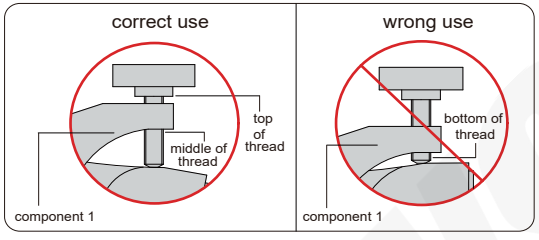


fig.2

4. Measurement:

---It is necessary to clean faces of guide, thimble, workpiece before measurement

---According the size of the workpiece, move the right tailstock in the appropriate position, and fix it

---Press the load/unload handle to install the workpiece and release it

---Install the indicator, adjust the appropriate position, rotate the handle-wheel to measure, get the result from the indicator

---Rotate driving wheel to move indicator holder for straightness measurement, get the result till the pointer is steady

5. Notice:

---Be careful to control the force applied on the wrench to avoid damaging internal locking device

---The moment that start to turn hand-wheel, the pointer of indicator is jumping. Get reading after the pointer is steady

---Take workpieces down carefully and forbid to drop workpieces on the guide to avoid damaging.

---Avoid placing the product in the air with moisture to prevent rustiness, oil it after use

6. Optional accessory: Dial test indicator (code: **2880-02**, **2880-02R**)