

Accuracy: 0.01mm(the parallelism of the line between two centers to the guide surface)

- 1-Indicator holder
- 2-V-slot
- 3-Left tailstock
- 4-Guide surface
- 5-Right tailstock
- 6-Base



1. Bench center is mainly used to measure cylindrical workpiece's roundness, concentricity and deflective difference.

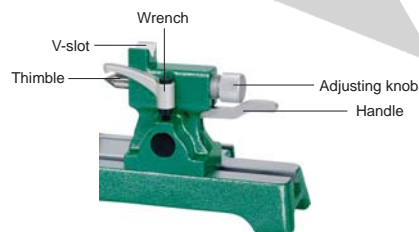
2. Description of each part:

Left tailstock: Left tailstock can be moved through guide surface, and then fix it with rotating wrench clockwise.

Notice: Lift the wrench, rotate the wrench counterclockwise, put down the wrench, and then rotate wrench clockwise. Do those steps until the left tailstock is fixed.

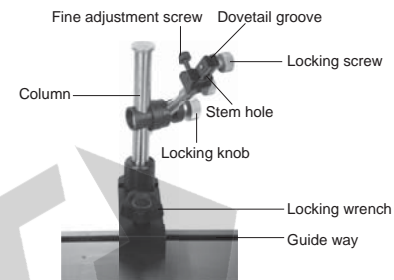


Right tailstock: Right tailstock can be moved through guide surface, and then fix it with rotating wrench clockwise. Use the wrench the same way as the left wrench. Press the handle to install the workpiece, rotate the adjusting knob to adjust the pressure of thimble, and avoid clamping excessively.



Indicator holder: Clamp the indicator to fix it. Clamp the indicator by dovetail groove or stem hole, fix it with the locking screw. Adjust the indicator with the fine adjustment screw. Loosen the locking knob, arm can be moved through column and rotated freely, adjust appropriately and tighten the locking knob. Loosen the locking wrench, indicator holder can be moved through guide way.

Notice: Open the package, take out product, it is necessary to install the indicator holder: unscrewing the locking wrench, lift up indicator holder, rotate 180°, put indicator holder back the guide way, screw on the locking wrench, indicator holder with the right position as the following picture.



3. Measurement:

Workpiece with center hole(fig.1)

- It is necessary to clean faces of guide surface, guide way, thimble, V-slot, workpiece before measurement
- Before measurement, move the left tailstock in the appropriate position, and fix it
- According the size of the workpiece, move the right tailstock to set the distance, and fix it
- Press the handle to install the workpiece and release it, rotate adjusting knob to adjust the pressure appropriately
- Install the indicator, adjust the appropriate position, rotate the workpiece during the measurement, and get the result from the indicator

Workpiece without center hole(fig.2)

- It is necessary to clean faces of guide surface, guide way, thimble, V-slot, workpiece before measurement
- Before measurement, according to length of workpiece to move the left tailstock and right tailstock in the appropriate position, and fix them
- Put the workpiece on V-slots
- Install the indicator, adjust the appropriate position, rotate the workpiece during the measurement, and get the result from the indicator



fig.1



fig.2

4. Notice:

- Tailstocks can be moved carefully, avoid the thimbles' collision
- Forbid to disassemble the left and right tailstocks, indicator holder, or else it will affect the accuracy
- Avoid placing the product in the air with moisture to prevent rustiness, oil it after use

5. Optional accessory: Dial test indicator(code: 2880-02)