

INSTRUCTIONS and PARTS

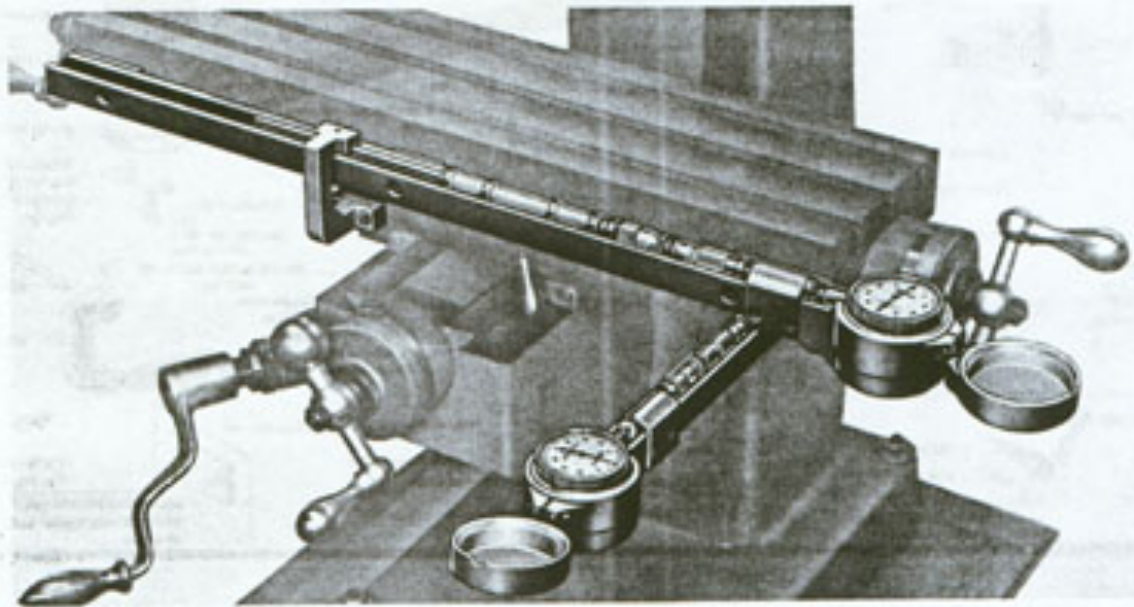
 **CLAUSING**

DIVISION, ATLAS PRESS CO.
KALAMAZOO, MICHIGAN

**No. 8630
Measuring
Attachment**

for
Nos. 8520 and 8525
Clausing Vertical Milling
Machines

OCTOBER 1959 FILE NO. 8630-1



MODEL 8630

MEASURING ATTACHMENT

**Preparing the Mill for Installing
the Measuring Attachment**

1. Remove stop block from front of table — use the socket cap screw to hold the cover in place. Install oiler in table after removing it from the stop block.
2. Remove both adjustable table stops.
3. On Model No. 8520 machines below serial No. 1839 and No. 8525 machines below serial No. 1863, remove the table lock and lock stop pin and replace with the swivel type table lock furnished.
4. Drill and tap six holes, two at (A), two at (B) in cross slide and two at (C) in the right side of the knee on Model No. 8520 machines below serial No. 002159 and No. 8525 machines below serial No. 001893. These holes are required for holding front stop bracket, side trough bracket and side stop bracket. Drill all holes $\frac{3}{4}$ " deep with No. 7 drill and then tap $\frac{1}{4}$ "-20 N.C. Thread $\frac{1}{2}$ " deep. Location of holes is shown in Figure 1.

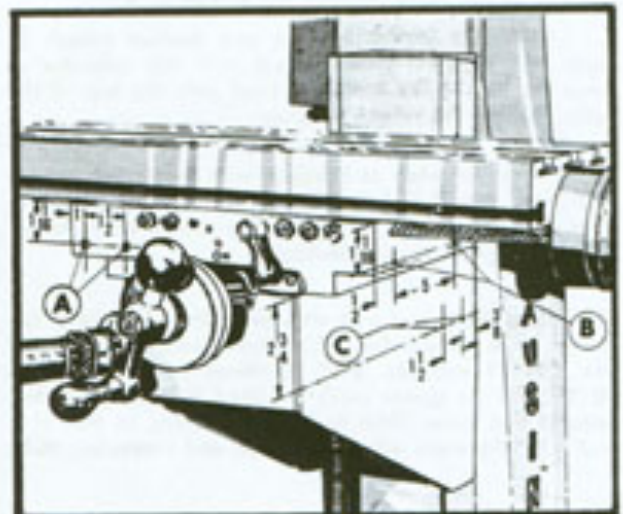
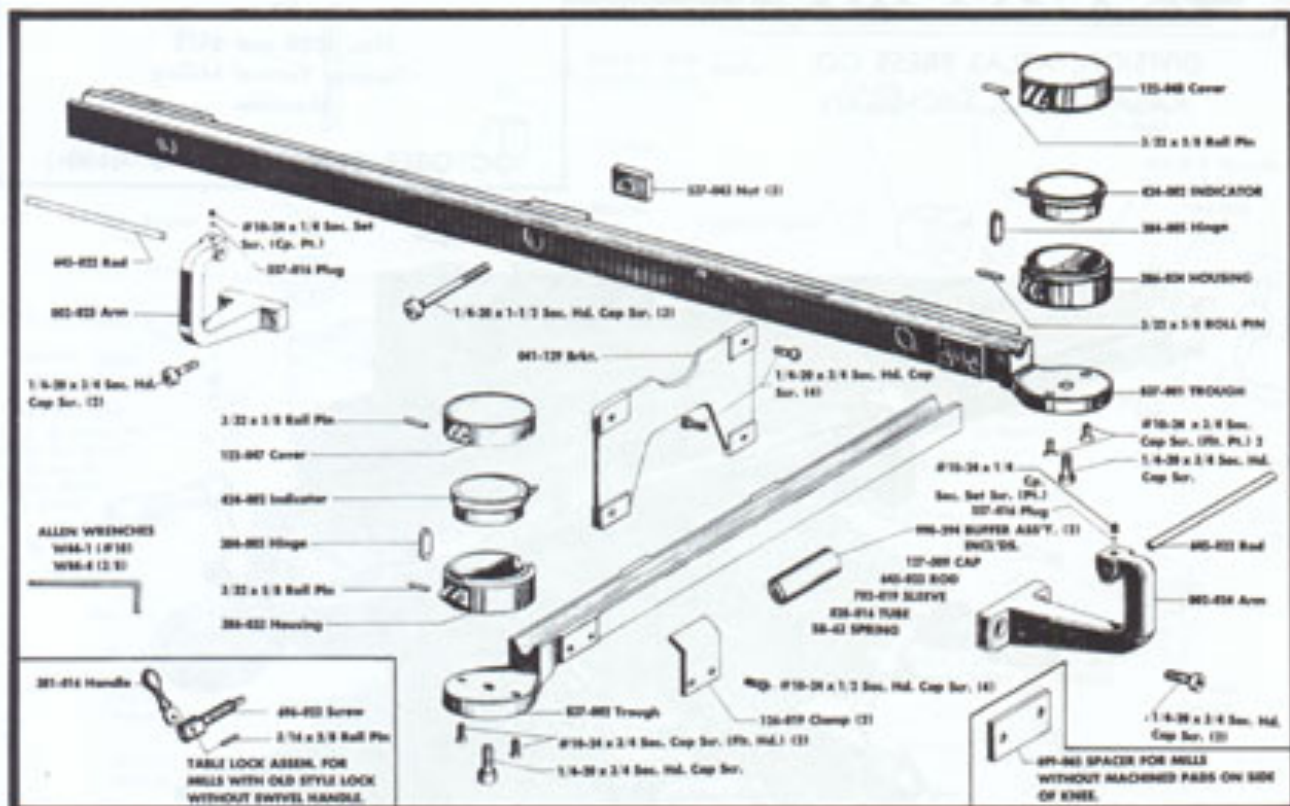


Fig. 1

MODEL 8630

MEASURING ATTACHMENT ASSEMBLY



Machine is now ready for Installing Measuring Attachment

1. Mount longest trough to front of table using socket cap screws and anchor nuts furnished. Use a dial indicator to check top of the trough — when it's level with the top of the table, tighten the screws securely.
2. Mount side trough bracket and shortest trough to right side of cross slide. Check with the indicator — when the top of the trough is level with the top of the table, tighten the screws securely.
3. Attach indicators in housings with socket cap screws — buffers should just touch end of indicator spindles. Note — if buffers are removed, they should be replaced with slotted end toward indicator.
4. Mount front and side stop brackets with screws furnished. On Model No. 8520 machines below serial No. 002159 and No. 8525 machines below serial No. 001893 use the spacer block furnished, between side stop bracket and knee. Shim or file if necessary, so that stop rod is in alignment with side trough and measuring rods.

CAUTION: EXTREME CARE SHOULD BE TAKEN WHEN HANDLING AND USING THE INDICATORS. DO NOT FORCE THE INDICATORS BEYOND THEIR RANGE OF .025".

BUFFERS ARE NOT POSITIVE STOPS — THEY'RE USED TO TAKE OUT BACK LASH IN TABLE FEED SCREWS, AND APPLY TENSION ON MEASURING RODS FOR ACCURATE READINGS.

ORDERING INFORMATION

IMPORTANT — The following information must be furnished on all repair part orders:

- 1 — Quantity Required
- 2 — PART NUMBER and NAME of Part
- 3 — MODEL NUMBER of Attachment

Parts shown without part numbers are standard parts and should be purchased locally.

We reserve the right to make changes in design and specifications without notice.