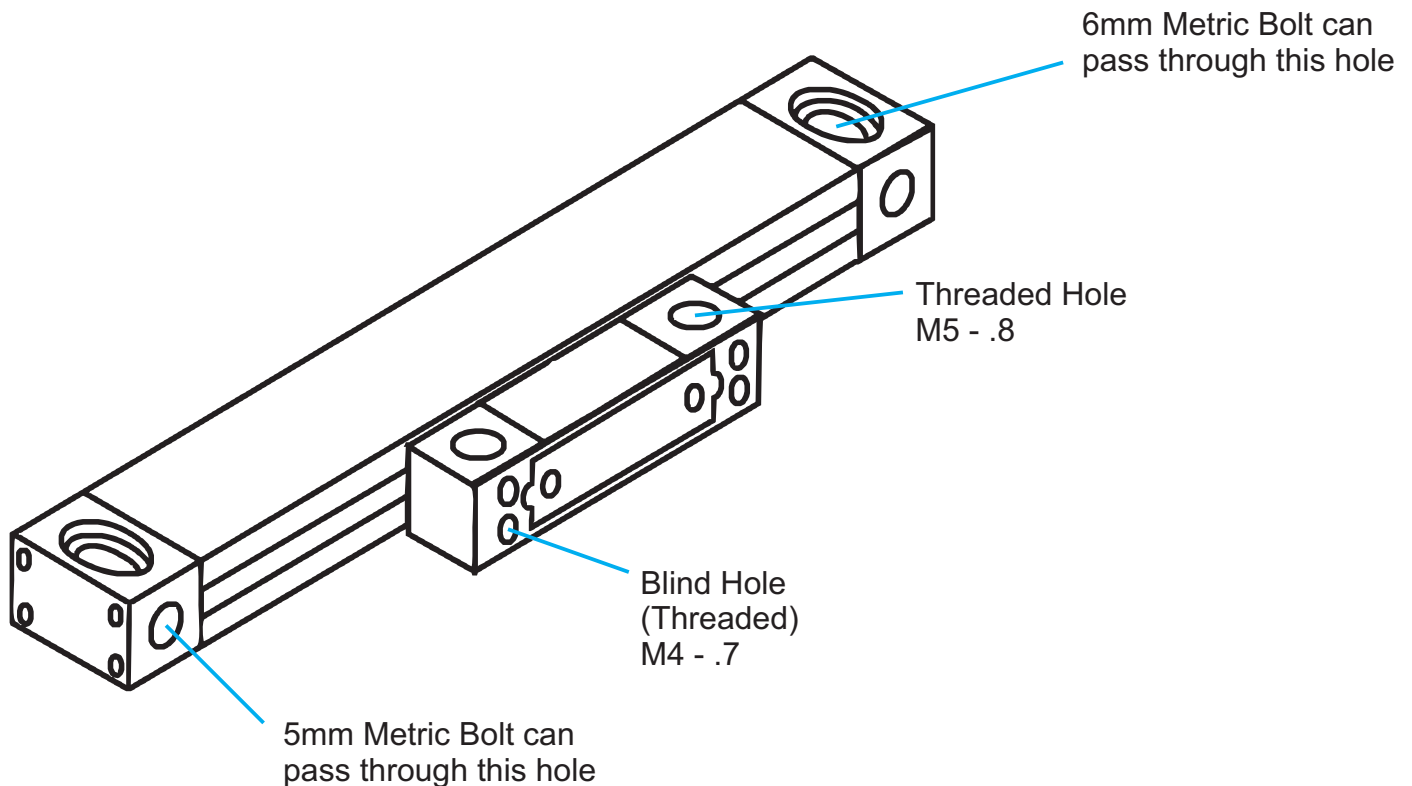


Installing The Scales

When installing scales, the most important thing to remember is that there is not “one right way”. When faced with the task of mounting scales, it is very common for different machinists to come up with several different mounting plans, depending upon their experience, time allowed for installation, and individual creativity. Remember, installation is more about creativity than it is an exact science. Which direction you mount the scales, or which holes you use, depends entirely on what you believe best fits your particular circumstances.

The scale endcaps have two holes, neither of which are threaded. The larger, oblong holes allow a 6mm bolt to pass through it, while the smaller round hole is clearanced for a 5mm bolt.

The trolley has two pass-through side holes which are tapped with an M5 x .8 thread. The 4 smaller holes are blind holes, and are tapped with an M4 x .7 thread.



Depending on your particular kit (ie lathe vs mill, 2 vs 3 axis etc), your DRO kit will contain a mixture of metric hardware. These are the most common size components in our kits:

Socket head cap screw	M6 - 1.0 x 30
Socket head cap screw	M6 - 1.0 x 25
Socket head cap screw	M5 - .8 x 30
Socket head cap screw	M5 - .8 x 10
Lock washer	M6
Lock washer	M5
Flat washer	M6
Flat washer	M5
Hex nut	M6 - 1.0

For tapping your machine, we recommend having a couple of M6 & M5 plug taps on hand:
ENCO (1-800-873-3626) has M5x0.8 plug taps for \$3.29 each as part number 311-4141
ENCO (1-800-873-3626) has M6x1.0 plug taps for \$3.76 each as part number 311-4181