

# Installation instruction



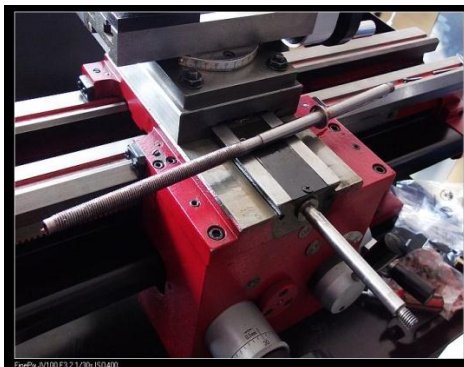
1. Dismount the handwheel and dial from cross slide.



2. Unscrew the leadscrew nut from cross slide.



3. Install the leadscrew nut from the DRCD kit.



4. Install the leadscrew nut from the DRCD kit.



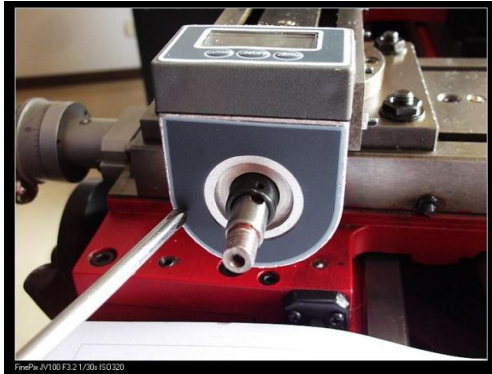
5. Install the bearing and bearing support from the DRCD kit.



6. Install the digital readout.



7. Fix by screws.



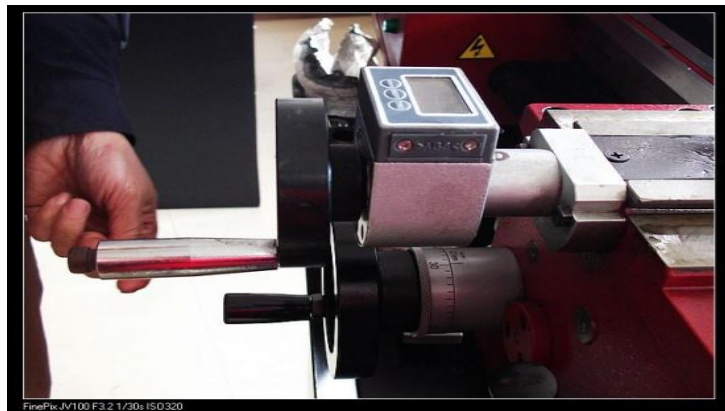
8. Stick on the front cover.



9. Install the handwheel handle.

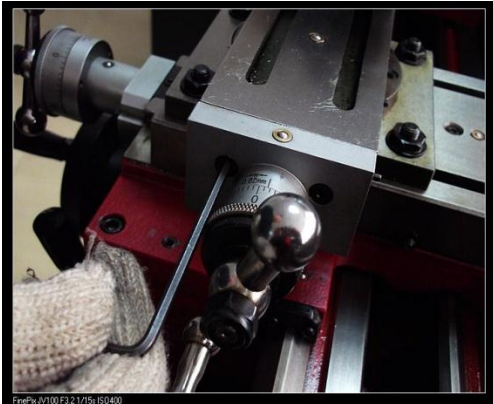


10. Tighten the handwheel nut.

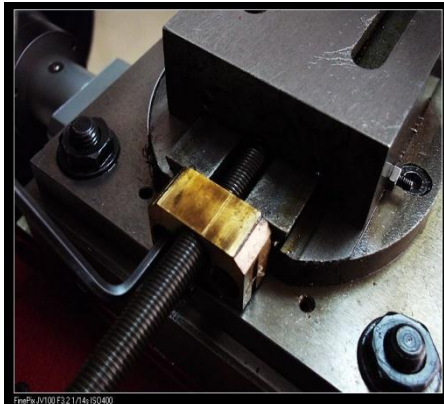


11. All done.

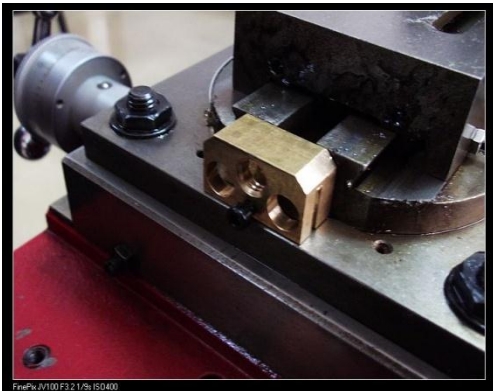
# Installation instruction



1. Unscrew the 2 inner hex screws.



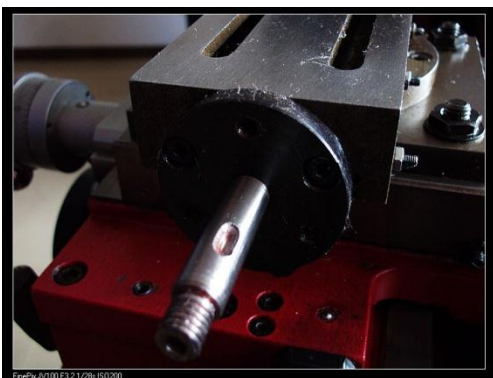
2. Unscrew the 3 screws which fixing the leadscrew nut.



3. Install the leadscrew nut from the DRCD Kit.



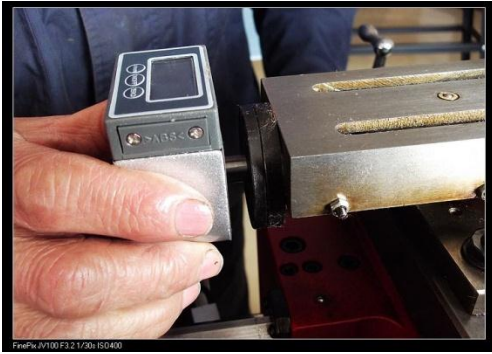
4. Install the leadscrew from the DRCD Kit.



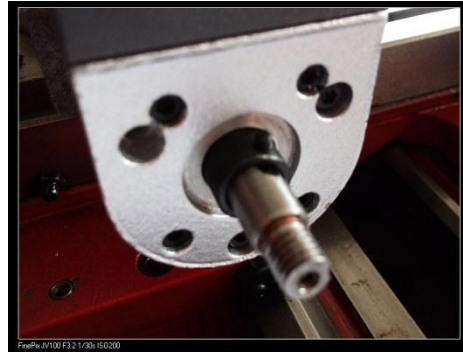
5. Mount the leadscrew support from the DRCD Kit.



6. Mount the connecting plate from the DRCD Kit.



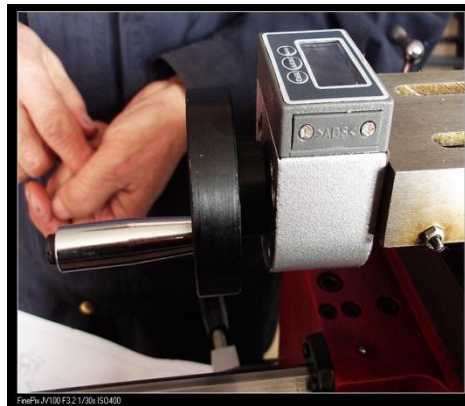
7. Install the digital readout.



8. Fix by screws.



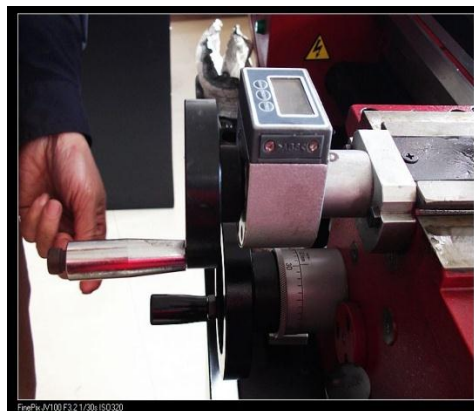
9. Stick on the front cover.



10. Install the handwheel assembly.

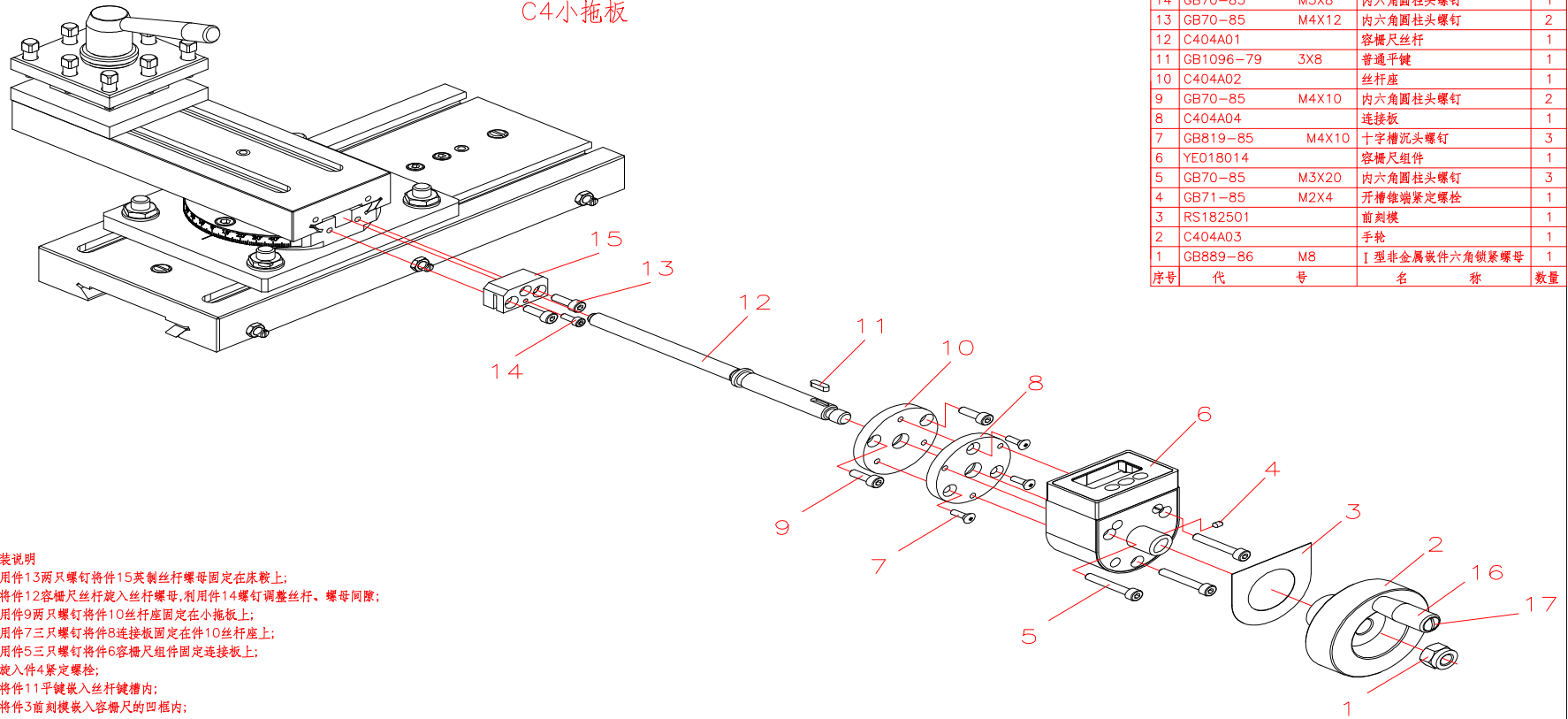


11. Tighten the handwheel nut.



12. All done.

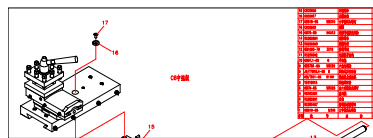
### C4小拖板

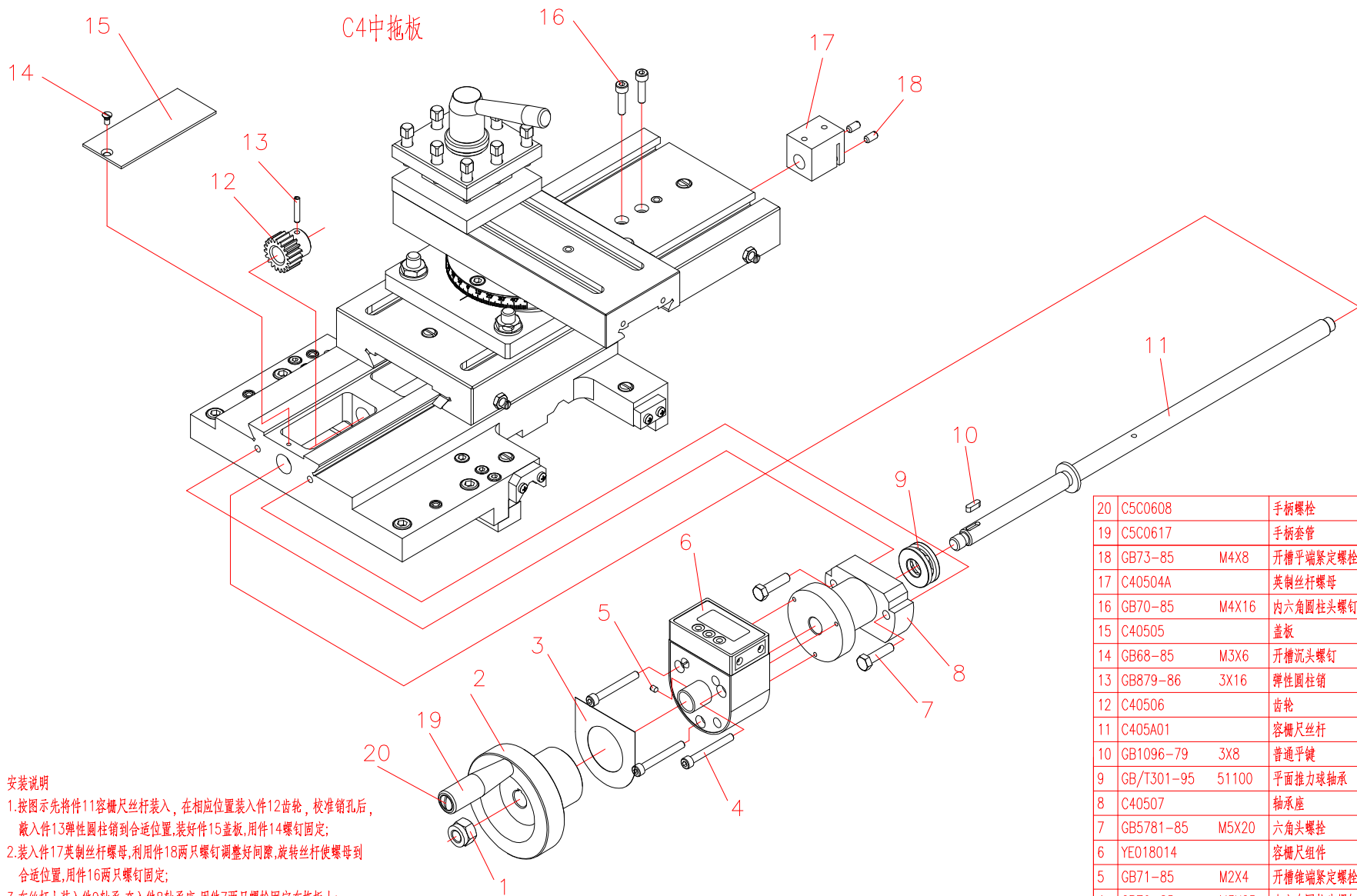


17	C5C0608		手柄螺栓	1
16	C5C0617		手柄套筒	1
15	C40407A		英制丝杆螺母	1
14	GB70-85	M3X8	内六角圆柱头螺钉	1
13	GB70-85	M4X12	内六角圆柱头螺钉	2
12	C404A01		容栅尺丝杆	1
11	GB1096-79	3X8	普通平键	1
10	C404A02		丝杆座	1
9	GB70-85	M4X10	内六角圆柱头螺钉	2
8	C404A04		连接板	1
7	GB819-85	M4X10	十字槽沉头螺钉	3
6	YE018014		容栅尺组件	1
5	GB70-85	M3X20	内六角圆柱头螺钉	3
4	GB71-85	M2X4	开槽锥端紧定螺栓	1
3	RS182501		前刻模	1
2	C404A03		手轮	1
1	GB889-86	M8	I型非金属嵌件六角锁紧螺母	1
序号	代号		名称	数量

#### 安装说明

1. 用件13两只螺钉将件15英制丝杆螺母固定在床鞍上;
2. 将件12容栅尺丝杆旋入丝杆螺母,利用件14螺钉调整丝杆、螺母间隙;
3. 用件9两只螺钉将件10丝杆座固定在小拖板上;
4. 用件7三只螺钉将件8连接板固定在件10丝杆座上;
5. 用件5三只螺钉将件6容栅尺组件固定连接板上;
6. 旋入件4紧定螺栓;
7. 将件11平键嵌入丝杆键槽内;
8. 将件3前刻模嵌入容栅尺的凹框内;
9. 将件2手轮装入丝杆,旋紧件1锁紧螺母。

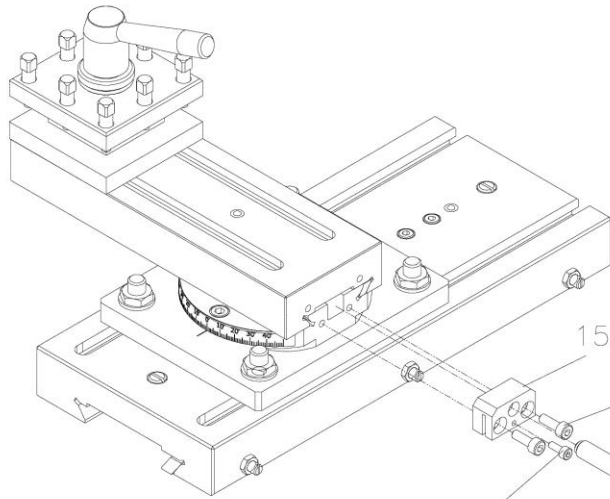




**安装说明**

1. 按图示先将件11容栅尺丝杆装入,在相应位置装入件12齿轮,校准销孔后,装入件13弹性圆柱销到合适位置,装好件15盖板,用件14螺钉固定;
2. 装入件17英制丝杆螺母,利用件18两只螺钉调整好间隙,旋转丝杆使螺母到合适位置,用件16两只螺钉固定;
3. 在丝杆上装入件9轴承,套入件8轴承座,用件7两只螺栓固定在拖板上;
4. 套入件6容栅尺组件,用件4三只螺栓固定在固定座上,装入件5紧定螺栓;
5. 将件3前刻模嵌入容栅尺的凹框内;
6. 将件10平键嵌入丝杆键槽内;
7. 将件2手轮装入丝杆,旋紧件1锁紧螺母。

20	C5C0608	手柄螺栓	1
19	C5C0617	手柄套管	1
18	GB73-85	M4X8 开槽平端紧定螺栓	2
17	C40504A	英制丝杆螺母	1
16	GB70-85	M4X16 内六角圆柱头螺钉	2
15	C40505	盖板	1
14	GB68-85	M3X6 开槽沉头螺钉	1
13	GB879-86	3X16 弹性圆柱销	1
12	C40506	齿轮	1
11	C405A01	容栅尺丝杆	1
10	GB1096-79	3X8 普通平键	1
9	GB/T301-95	51100 平面推力球轴承	1
8	C40507	轴承座	1
7	GB5781-85	M5X20 六角头螺栓	2
6	YE018014	容栅尺组件	1
5	GB71-85	M2X4 开槽锥端紧定螺栓	1
4	GB70-85	M3X25 内六角圆柱头螺钉	3
3	RS182501	前刻模	1
2	C405A02	手轮	1
1	GB889-86	M8 I型非金属嵌件六角锁紧螺母	1
序号	代 号	名 称	数量



C4小拖板

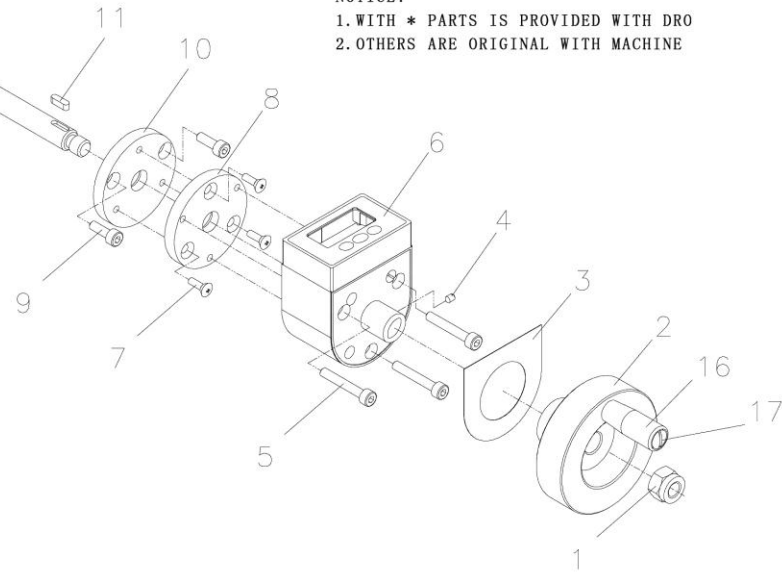
**FIX INSTRUCTION:**

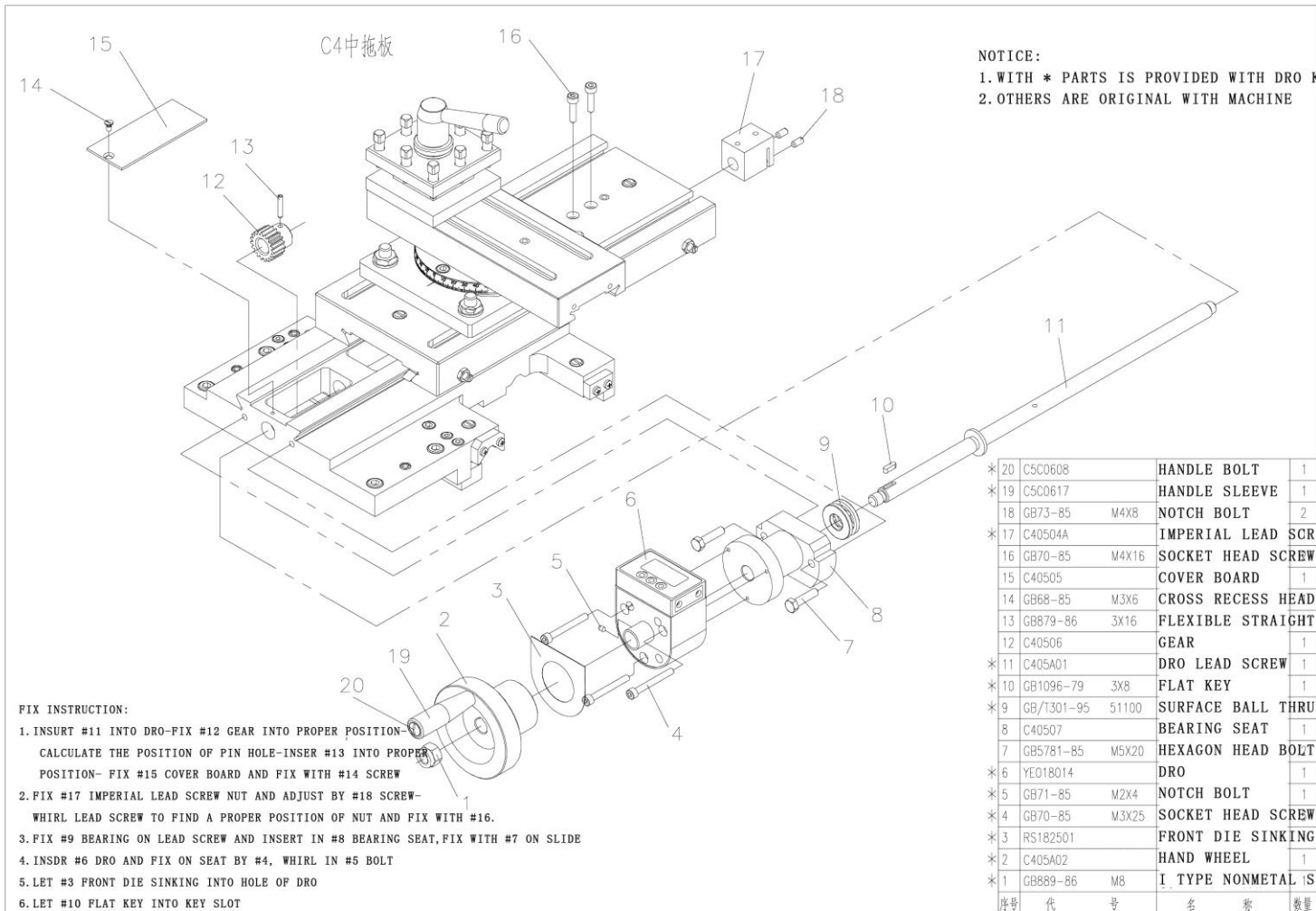
1. FIX #15 LEADSCREW ON SADDLE WITH #13 SCREWS
2. WHIRE #12 INTO LEAD SCREW, USE #14 TO ADJUST LEAD SCREW & NUT
3. FIX #10 ON COMPOUND SLIDE WITH #9 SCREWS
4. FIX #8 CONNECTION BOARD ON #10 LEADSCREW HOLDER BY #7 SCREWS
5. FIX #6 DRO ON CONNECTION BOARD BY #5 SCREWS
6. WHIRL IN NOTCH BOLT
7. LET #11 FLAT KEY INTO KEY SLOT
8. LET #3 FRONT DIE SINKING INTO HOLE OF DRO
9. FIX #2 HAND WHEEL INTO LEAD SCREW, WHIRL #1 TO FIX NUT

*17	C5C0608	HANDLE BOLT	1
*16	C5C0617	HANDLE SLEEVE	1
*15	C40407A	IMPERIAL FEED SCREW NUT	
14	GB70-85 M3X8	SOCKET HEAD SCREW	1
13	GB70-85 M4X12	SOCKET HEAD SCREW	2
*12	C404A01	DRO LEAD SCREW	1
*11	GB1096-79 3X8	FLAT KEY	1
*10	C404A02	LEAD SCREW HOLDER	1
*9	GB70-85 M4X10	SOCKET HEAD SCREW	2
*8	C404A04	CONNECTION BOARD	1
*7	GB819-85 M4X10	CROSS RECESS HEAD SCREW	
*6	YE018014	DRO	1
*5	GB70-85 M3X20	SOCKET HEAD SCREW	3
*4	GB71-85 M2X4	NOTCH BOLT	1
*3	RS182501	FRONT DIE SINKING	1
*2	C404A03	HAND WHEEL	1
*1	GB889-86 M8	I TYPE NONMETAL SOCKET HEAD LOCK	
序号	代号	名称	数量

**NOTICE:**

1. WITH \* PARTS IS PROVIDED WITH DRO
2. OTHERS ARE ORIGINAL WITH MACHINE





**FIX INSTRUCTION:**

1. INSURT #11 INTO DRO-FIX #12 GEAR INTO PROPER POSITION-  
 CALCULATE THE POSITION OF PIN HOLE-INSER #13 INTO PROPER  
 POSITION- FIX #15 COVER BOARD AND FIX WITH #14 SCREW
2. FIX #17 IMPERIAL LEAD SCREW NUT AND ADJUST BY #18 SCREW-  
 WHIRL LEAD SCREW TO FIND A PROPER POSITION OF NUT AND FIX WITH #16.
3. FIX #9 BEARING ON LEAD SCREW AND INSERT IN #8 BEARING SEAT, FIX WITH #7 ON SLIDE
4. INSDR #6 DRO AND FIX ON SEAT BY #4, WHIRL IN #5 BOLT
5. LET #3 FRONT DIE SINKING INTO HOLE OF DRO
6. LET #10 FLAT KEY INTO KEY SLOT
7. FIX #2 HAND WHEEL INTO LEAD SCREW, WHIRL #1 TO FIX NUT