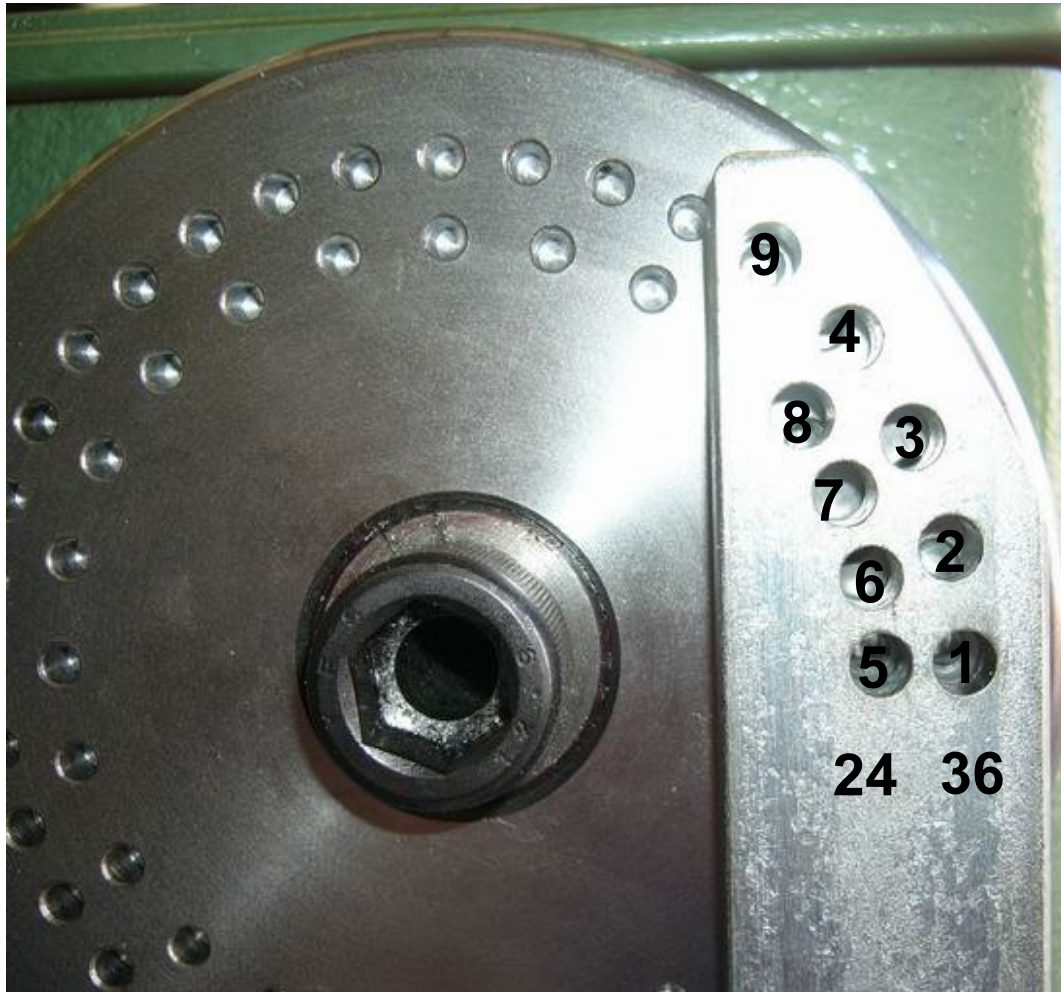


VERMEC

INDEXING ATTACHMENT

Code: ACC-285

Indexing Attachment Pin Holes



Hole 1 & 9 - Set Up only - use two pins for aligning only

Hole 1 = 36 index points

Hole 1 & 3 = 72 index points

Hole 1, 2, 3 & 4 = 144 index points

Hole 5 = 24 index points

Hole 5 & 7 = 48 index points

Holes 5, 6, 7 & 8 = 96 index points

Calculating Index Points

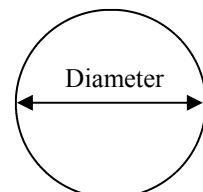
Calculate the circumference of the item by measuring the diameter then use the formula:

Diameter x π or 3.14

Add required Groove thickness and Space size together

Divide circumference by total of groove thickness and space size

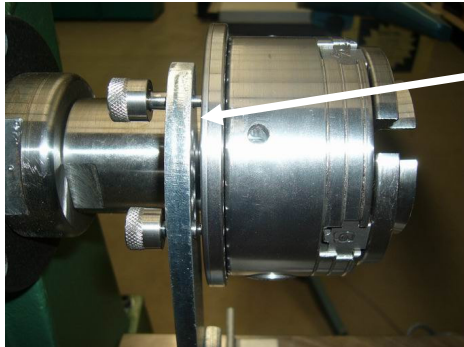
Choose the nearest index points from above list



Mounting Indexing Attachment onto Lathe



Step 1 - To line up, insert pins into 1st and 9th holes as shown. Mount bracket onto lathe between headstock and chuck, using disc and bolt. Tighten enough that frame can still be moved.



Step 2 - Make sure you have a 3-4mm gap between indexing plate and bracket.



Step 3 - Loosely tighten the bracket bolts - make sure the pins are able to be moved in and out after each tightening.



Step 4 - Loosely tighten the centre bolt. Check the pins again to make sure they can be moved in and out.



Step 5 - Check that the bracket is mounted square or 90° to the bed. Once aligned tighten all the bolts still making sure that the pins can be moved in and out.

Using the Indexing Attachment

This is an example of how the indexing attachment works

To calculate the indexing points for our example:

The diameter of our bowl is 340mm

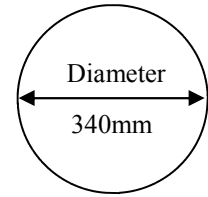
Using the Calculating Index Points on Page 1:

Diameter 340mm x 3.14 = 1068mm

Using Groove thickness of 4mm with Spaces of 3.5mm = 7.5mm

1068 divided by 7.5 = 142.44

The nearest index points is 144



Step 1: Insert pin into Hole 1. This will give 36 grooves (one turn)



Step 2: Insert pin from Hole 1 to Hole 3 without moving job from chuck. This gives you 72 grooves exactly in between



Step 3: Move pin to Hole 2. This gives you the bottom grooves for the 144 in between.



Step 4: Move pin to Hole 4. This gives you the remaining grooves for the 144 required.

