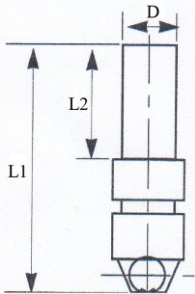
	<p>The Wiggler and Centre Finder Set is suitable for use in vertical milling and drilling machines and provides a fast and accurate method of positioning the machine spindle in the required position above the work piece.</p> <p>Set Includes:</p> <table border="0"> <tr> <td>Probe Holder:</td> <td>Holds range of push in probes</td> </tr> <tr> <td>Point Probe:</td> <td>Scribed line location</td> </tr> <tr> <td>Ball Probe:</td> <td>Side face location</td> </tr> <tr> <td>Disc Probe:</td> <td>Restricted features, slots etc.</td> </tr> <tr> <td>Indicator Attachment:</td> <td>Dial Test Indicator Holder</td> </tr> </table>	Probe Holder:	Holds range of push in probes	Point Probe:	Scribed line location	Ball Probe:	Side face location	Disc Probe:	Restricted features, slots etc.	Indicator Attachment:	Dial Test Indicator Holder
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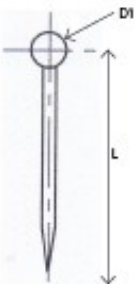
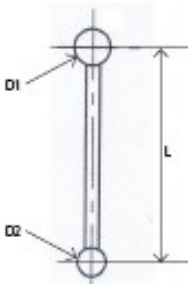
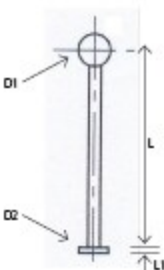
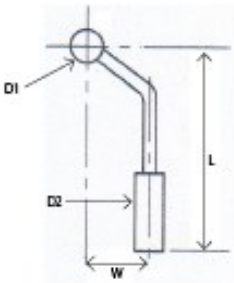
Packed Weight and Dimensions

Code	Description	Weight g	W mm	H mm	L mm
4100-004	Wiggler Set	119	130	25	130

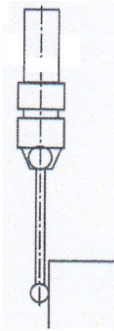
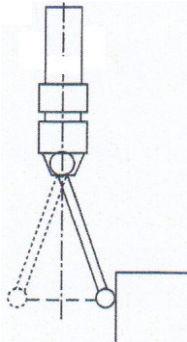
Probe Holder

	<p>Probe Holder Dimensions</p> <table border="1"> <thead> <tr> <th>D</th> <th>L1</th> <th>L2</th> </tr> </thead> <tbody> <tr> <td>3/8"</td> <td>2-1/2"</td> <td>1-1/8"</td> </tr> </tbody> </table>	D	L1	L2	3/8"	2-1/2"	1-1/8"
D	L1	L2					
3/8"	2-1/2"	1-1/8"					

Probes

Point Probe	Ball Probe	Disc Probe	Indicator Attachment
			
<p>L: 2-3/16" D1: 5/16"</p>	<p>L: 2-3/32" D1: 5/16" D2: 0.250"</p>	<p>L: 2-3/16" L1: 0.080" D1: 5/16" D2: 0.100"</p>	<p>L: 2-1/4" D1: 5/16" W: 7/16" D2: 0.230" & 0.200"</p>

Instructions for Ball and Disc end Probes



Insert the Probe Holder into the machine chuck or collet. Slightly unscrew the Holder collet and push in the selected probe, retighten the collet but do not over tighten as the probe should be free to move in the Holder. Position the probe at an angle and turn on the machine spindle (500 – 1000 rpm)

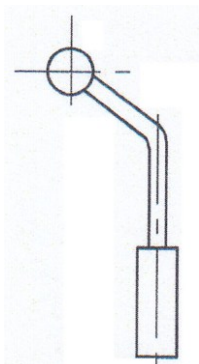
With the machine spindle running, allow the Probe end to oscillate slightly, slowly advance the probe towards the vertical component face until it touches, further movement will reduce the amount the probe oscillates. When the probe reaches the datum position it will run off along the face of the component. At this position the distance between the centre line of the machine spindle and the vertical component face will be half the diameter of the probe contact.

Instructions for Point end Probe



Insert the Probe Holder into the machine chuck or collet. Slightly unscrew the Holder collet and push in the Point probe, retighten the collet but do not over tighten as the probe should be free to move in the Holder. Turn on the machine spindle (500 – 1000 rpm)
Set the point to run true by using a rule or other suitable tool. Move the work piece under the rotating probe and position the point as close as possible to the surface of the work piece without touching. Traverse the work piece to align the point directly above the line or mark. The centre line of the machine spindle is now directly in line with the desired mark

Instructions for Indicator Attachment



The Indicator Attachment is used to mount a Dial Test Indicator for use when checking the alignment of work pieces mounted to the machine table. Also usefull for checking the alignment of vices, vee blocks and other fixtures fitted to the machine table.

Choose a universal clamp which will suit one of the mounting diameters on the Indicator Attachment and the spigot diameter of the Dial Test Indicator

Ensure that the Indicator Attachment is firmly clamped in the Probe Holder as it should not be able to move for this application.

Do not use with the machine spindle switched on