



User's Guide

Spin Fixture TIR/FIM Gage

November '2006



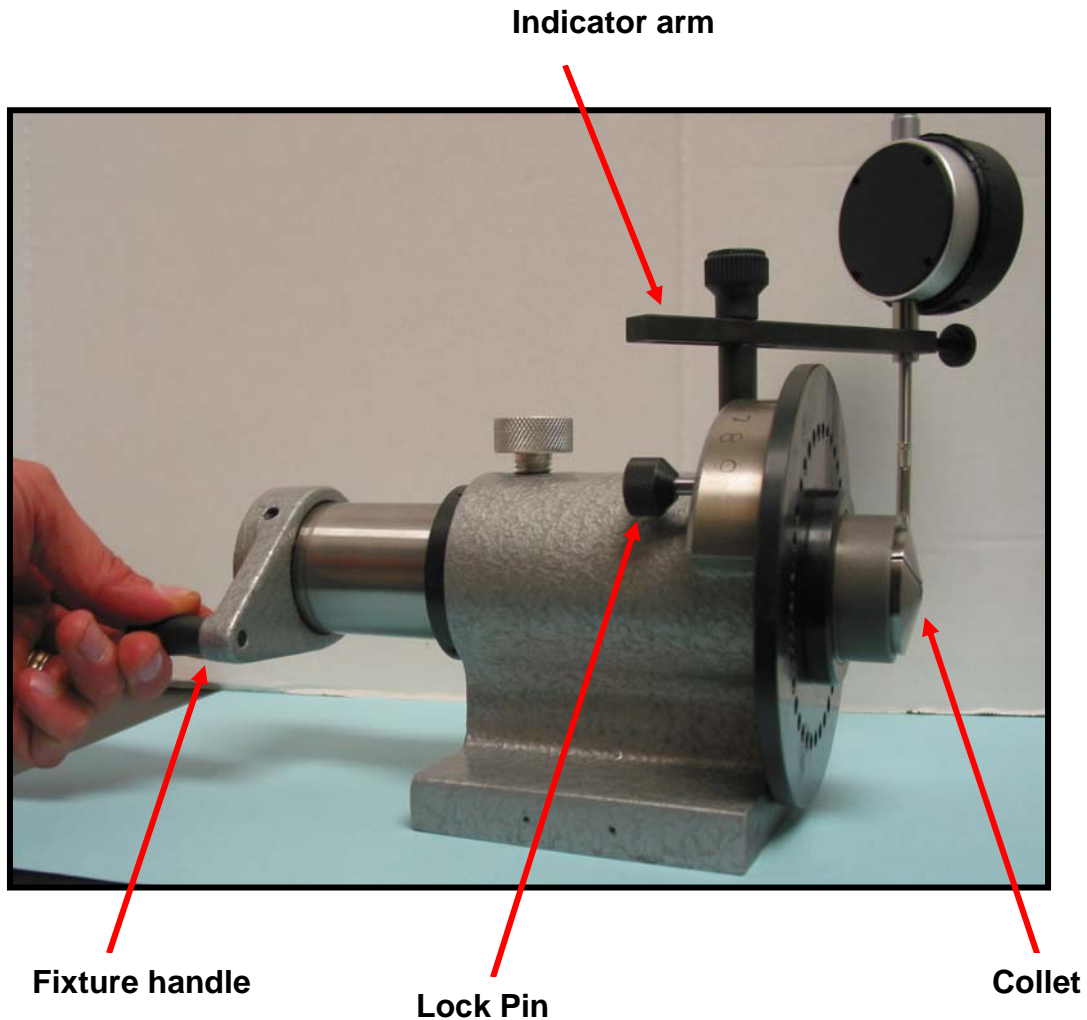
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Procedure:

1. Slide the lock pin into the index ring to prevent fixture shaft rotation.
2. Select the desired collet and slide it into the fixture shaft. Rotate the collet pressing toward the back of the fixture until the collet finds the internal groove and slides all of the way back into the fixture shaft.
3. Press the handle on the end of the shaft toward the collet. When they come in contact rotate the handle clockwise until it has screwed firmly on to the collet.

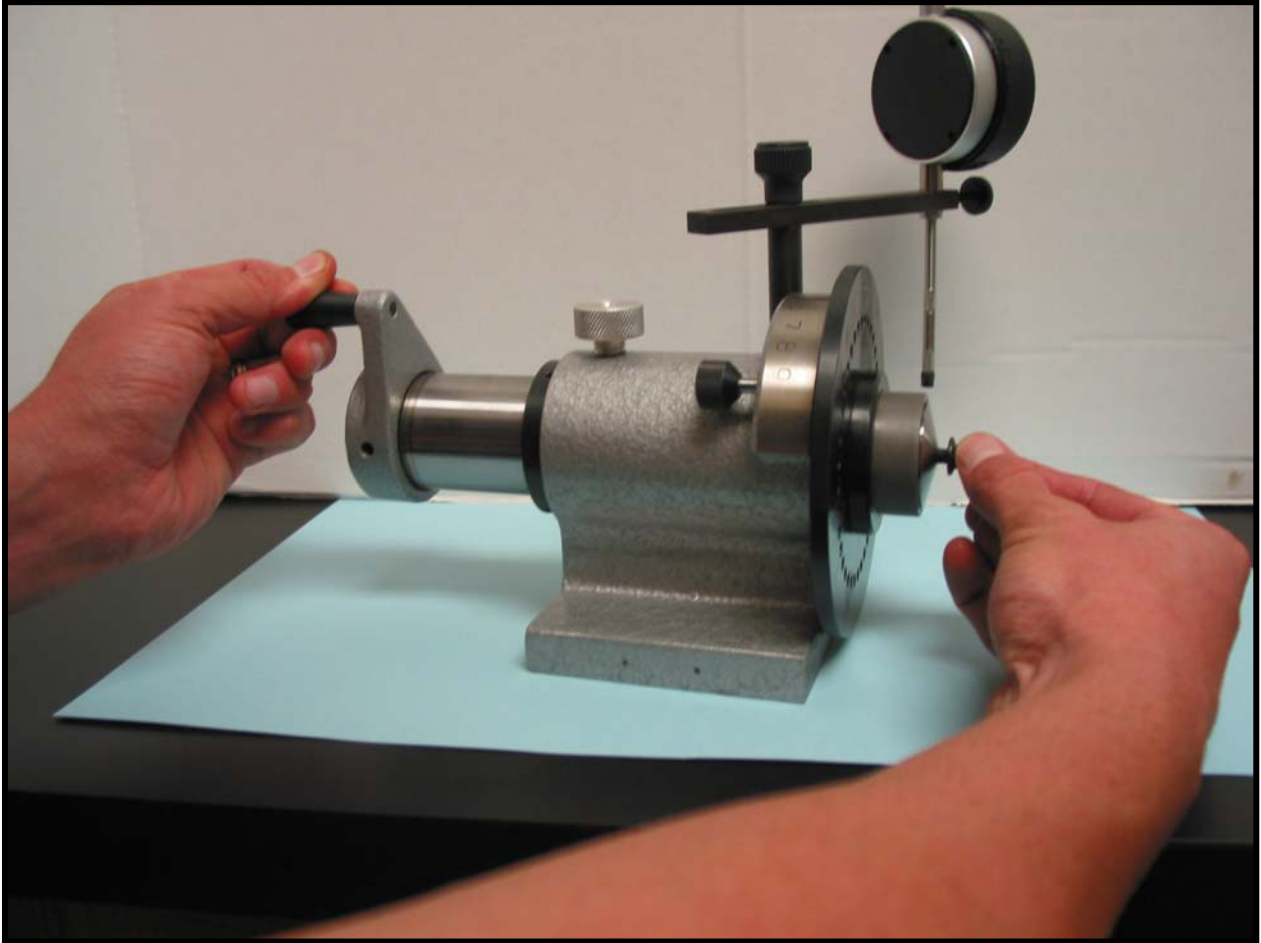


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4. Rotate the handle counterclockwise to loosen the collet slightly.
5. Place the sample screw in the collet with about one diameter length sticking out the face of the collet. Rotate the handle clockwise to tighten the collet on the screw.

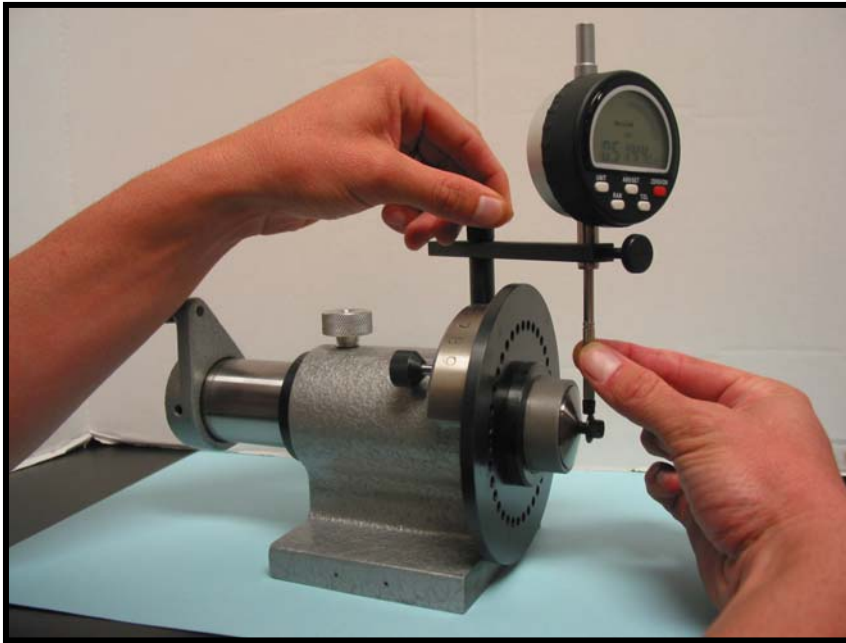


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6. Loosen the thumb screw on the indicator arm and position the indicator point immediately over the point at which the part is to be measured and tighten the thumb screw to make fix the indicator into position.



7. Pull the lock pin out of the indexing plate so the fixture shaft can rotate.
8. Press the ZERO/ON button. If the indicator is not in the desired increments press the IN/MM button to change from inches to millimeters or millimeters to inches..



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9. Press the RAN (Range) three times to put the indicator into the “TIR/FIM” mode.



10. Rotate the fixture handle three times in each direction. The value on the display is the “Total Indicator Reading” or the “Full Indicator Movement”.

Note: “Concentricity” is $\frac{1}{2}$ of TIR/FIM.



11. To remove the screw slide the lock pin into the indexing plate, rotate the fixture handle counterclockwise until the screw is released. Remove the screw and place the next sample in the fixture.

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