

SONY®

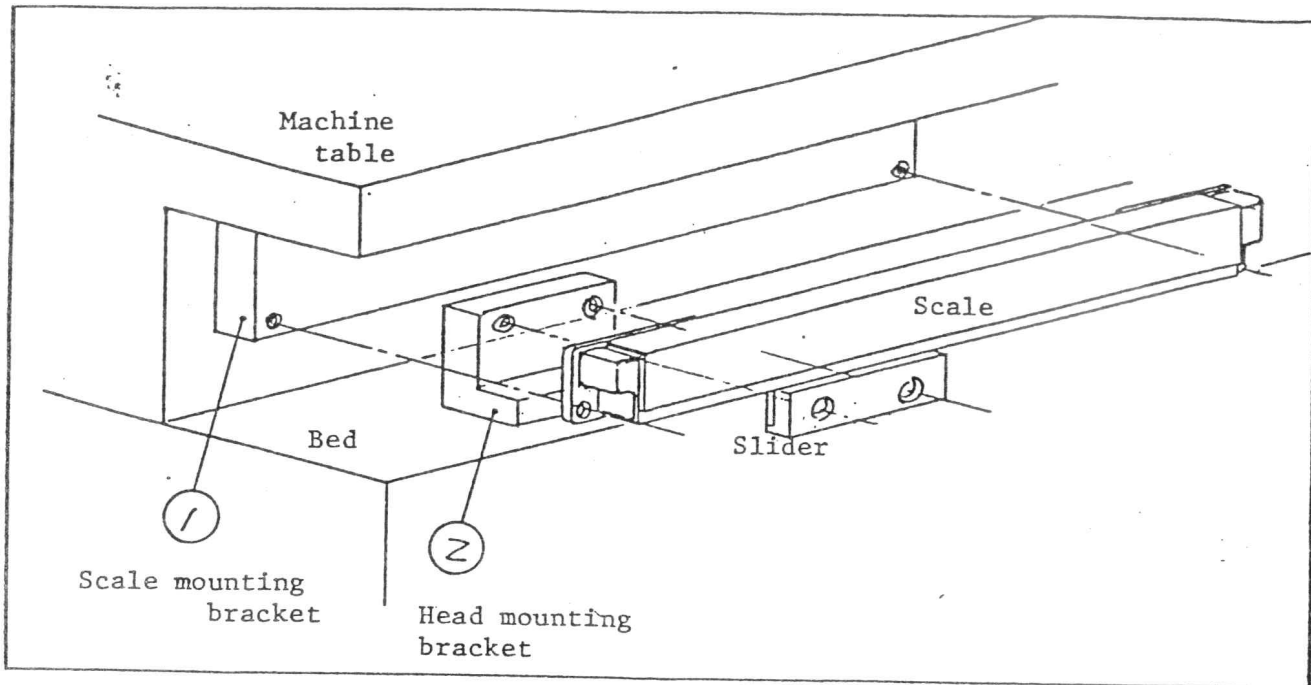
How to install the scale SR-741

Feb. 1982

2-994-035-01

Sony Magnescale Inc.

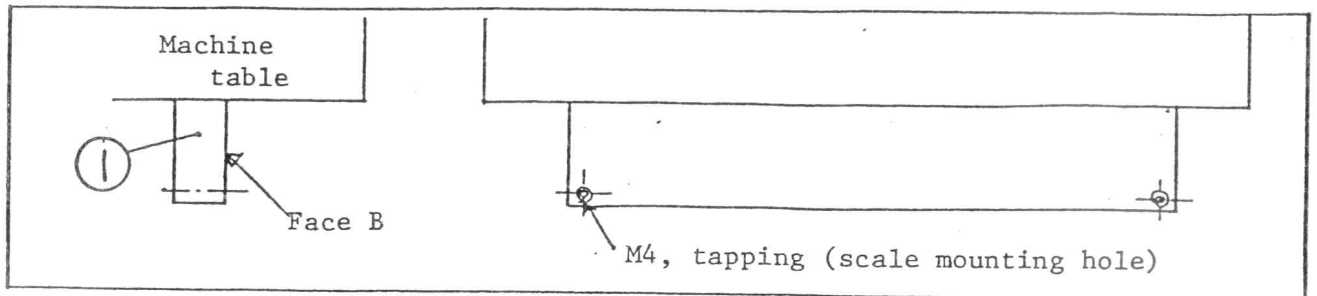
How to install the scale SR-741



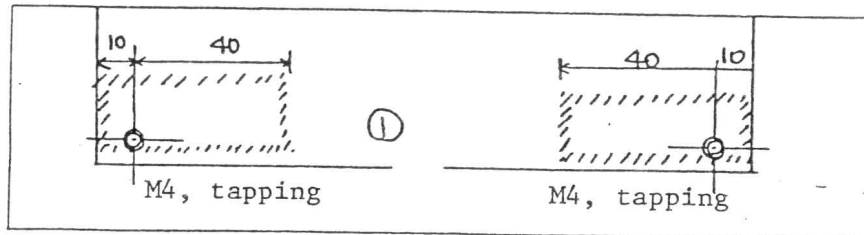
- (1) Install the scale mounting bracket ① .
- (2) Install the head mounting bracket ② .
- (3) Install the scale onto the scale mounting bracket ① .
- (4) Install the slider onto the head mounting bracket ② .

Each installation is described in detail in the following pages.

- (1) Install the scale mounting bracket ① onto the machine table.

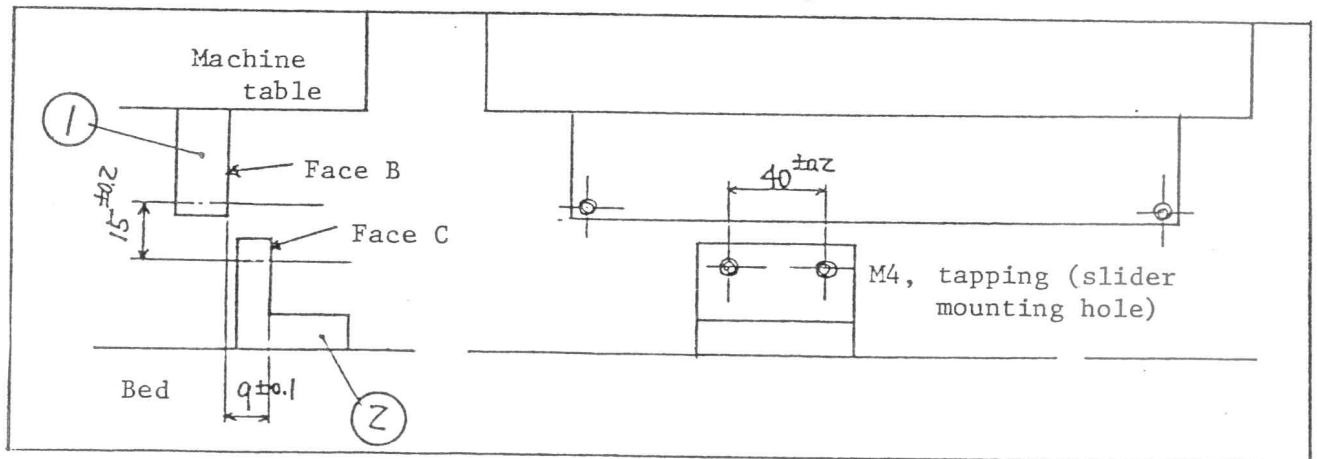


Make the parallelism of the face B against the slide of the machine table within 0.1mm.



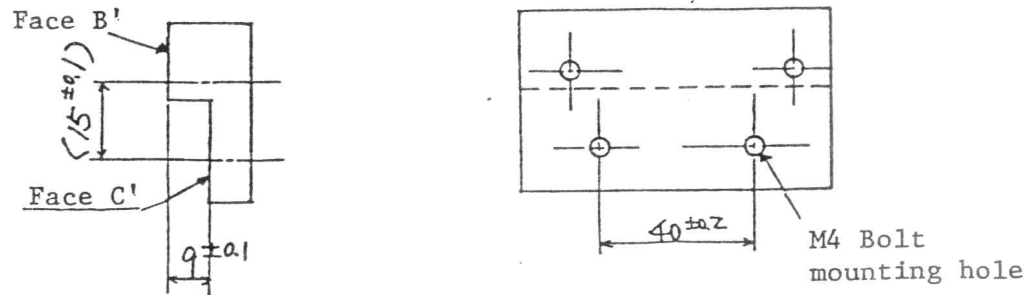
For the parallelism of the face B, measure the parallelism around the tapping holes (over the length of 50mm from each edge: see the above figure) and make it within 0.1mm.

- (2) Install the head mounting bracket ②.



Make the parallelism of the face C against the face B within 0.05mm, and make the clearance between the face B and the face C to be 9 ± 0.1 mm.

Make a jig as shown below and position the head mounting bracket ② against the scale mounting bracket ① with it.



Parallelism between the face B' and the face C' :
within 0.05mm

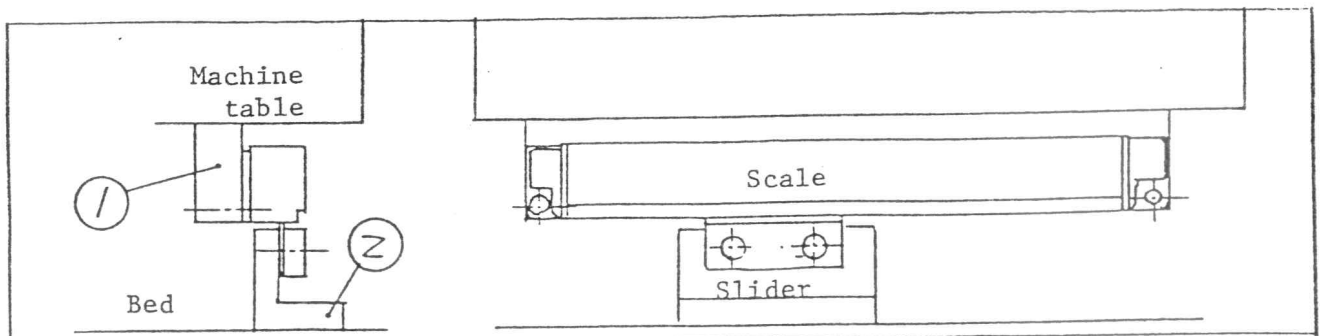
Clearance between the face B' and the face C' :
 9 ± 0.1 mm

Installation with the above jig:

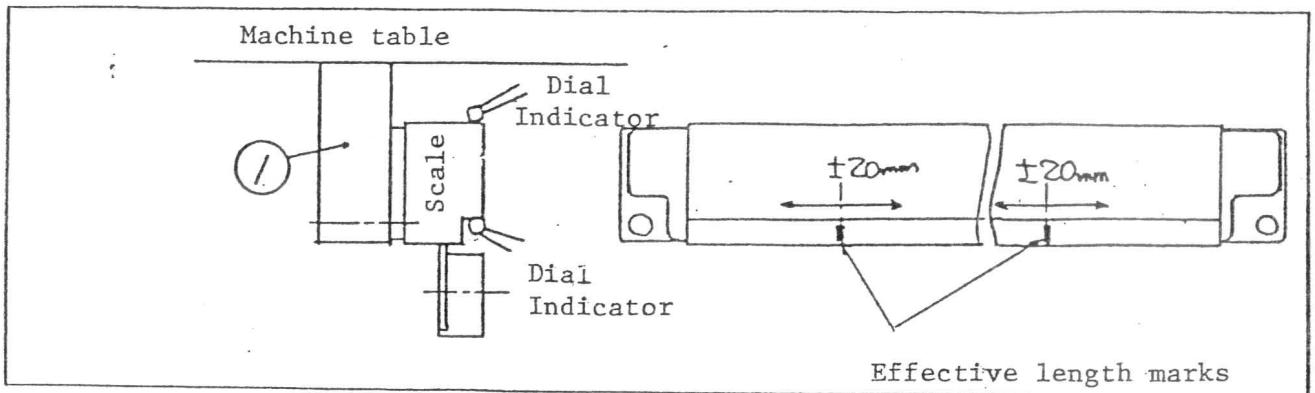
- Put the face C' of the jig onto the face C of the head mounting bracket ② and fix them making use of the slider mounting holes on the head mounting bracket ② .
- Then put the face B' of the jig onto the face B of the scale mounting bracket ① and fix them making use of the scale mounting holes.
- Fix the head mounting bracket ② onto the bed with spacers between.
- Remove the jig.

Check that the scale mounting bracket and the head mounting bracket are positioned as specified.

(3) Install the scale onto the scale mounting bracket ① .



Install the scale onto the scale mounting bracket ① temporarily, and remove the jig block (accessory).

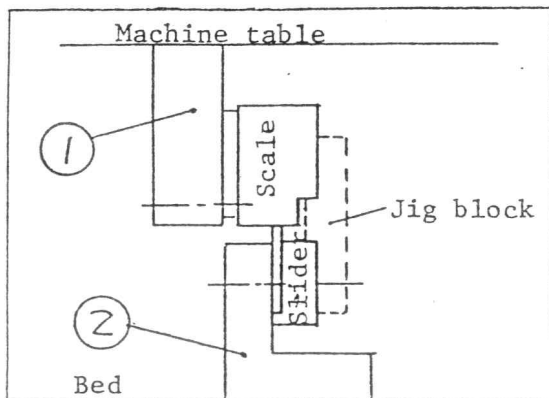


- ° Measure the parallelism of the scale against the slide of the machine table with a dial indicator, and make it within 0.1mm.

Put a dial indicator on either side of the scale (see the above figure) and move it over the length of $\pm 20\text{mm}$ around the effective length marks.

- ° When the parallelism is made within 0.1mm, fix the scale.

- (4) Install the slider onto the head mounting bracket ② .



Be sure to install the slider where it has been secured with the jig block in (3).

Put the jig block (accessory) onto the scale and the slider as shown in the figure, and fix the slider.

Then remove the jig block.

- (5) Install the slider cover and the blinds (rubber plugs). (see the instruction manual, page 8.)