

G-13: Center Piece

SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.
- Machine is operating to position the indicator to the hole. Be aware of moving machine parts.

EQUIPMENT

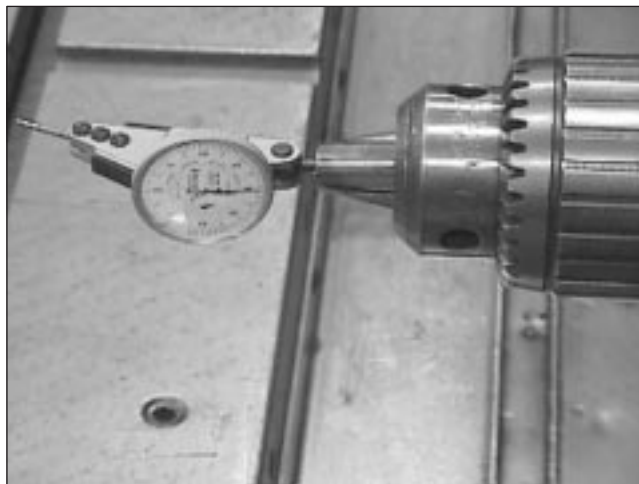
- dial indicator (at least .001")

RESOURCES

- manufacturer's manuals

Center Piece

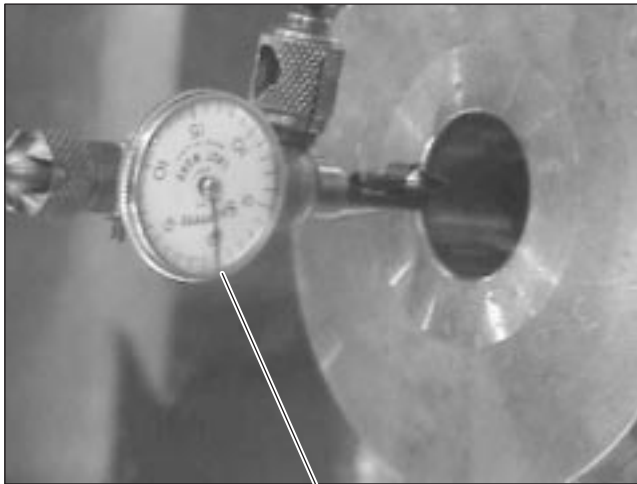
1. **Install the dial indicator in the spindle chuck.**



Installed Dial Indicator

2. **Move the spindle to the hole on the set up part.**
 - Move the spindle until the dial indicator rests on one end of the X axis.

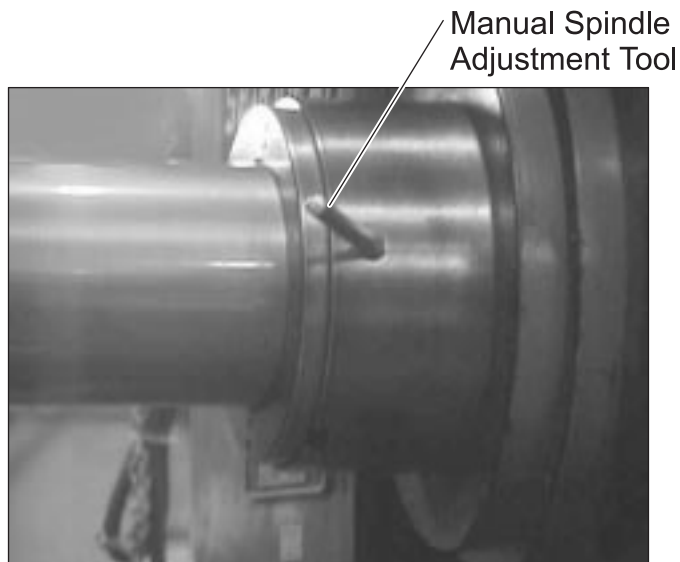
3. Zero the dial indicator.



Zeroed Indicator

4. Sweep the dial indicator 180 degrees clockwise.

- Manually turn the spindle to sweep the indicator.



- Divide the dial indicator measurement obtained from the sweep in half.



5. **Compensate the table for the X-axis.**
 - Turning the table adjustment arm for one half of the indicated measurement.
 - Move the table in if the measurement is positive, and out if the measurement is negative.
6. **Set the indicator on the Y-axis.**
 - Turn the spindle 90 degrees clockwise.
7. **Adjust the work head until the indicator registers zero.**
 - Turn the manual adjustment wheel to adjust the work head.
8. **Sweep the indicator 180 degrees clockwise.**
9. **Compensate for the Y-axis.**
 - Adjust the work head for one half of the indicated measurement.
 - Turn the work head manual-adjustment wheel so the table moves left if the measurement is positive and right if the measurement is negative.
 - Sweep all points to verify the center, checking that all points indicate zero.