

# K-07

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## TOOLMAKER TRAINING

### SKILL CHECK GUIDE

Duty K: Internal Grinder

**K-07: Set Up Machine (Lathe Chuck, Magnetic Parallel,  
Face Plate, Taper Pot, or No Holding Device)**

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## **Rationale**

This Skill Development Guide provides the knowledge a Learner needs to set up the machine. The Learner must be able to set up the internal grinder.

## **Skill Check Set-Up**

Set up the internal grinder so the Learner can practice indicating and centering a part.

Provide the tools, materials, and resources needed to demonstrate the task.

## What The Learner Will Need

This section contains the safety information, tools, and resources you will need before setting up the machine.



- Follow all Caterpillar facility safety standards when performing this task.
- Be aware of rotating equipment and unexpected machine movement.



- internal grinder
- dial indicator (tenths)
- setup equipment (required holding device)
- shop towel
- measuring equipment (micrometers, calipers, etc.)
- Arkansas stone
- copper/brass knocker
- jo blocks



- dimensional print
- standards for holding tolerances from tool design



## Skill Check

Given a process sheet and dimensional print requiring internal grinding, set up the internal grinder.

Needs  
Mastered Practice

### Safe Work Practices

- |       |       |  |
|-------|-------|--|
| _____ | _____ | 1. Follow all Caterpillar facility safety standards when performing this task. |
| _____ | _____ | 2. Be aware of rotating equipment and unexpected movement.                     |

### Task Standards

- |       |       |  |
|-------|-------|--|
| _____ | _____ | 1. The part must be installed to the required holding device, as determined from the dimensional print.                                |
| _____ | _____ | 2. The holding device and/or part must be centered on the permanent magnet within .0001" or less, when measured with a dial indicator. |
| _____ | _____ | 3. All safe practices must be demonstrated during the setup procedure.   |



## Evaluator's Sign-Off

The Learner has demonstrated safe work practices and competent performance of the task.

Evaluator: \_\_\_\_\_ Date: \_\_\_\_\_

Learner: \_\_\_\_\_ Clock No: \_\_\_\_\_

