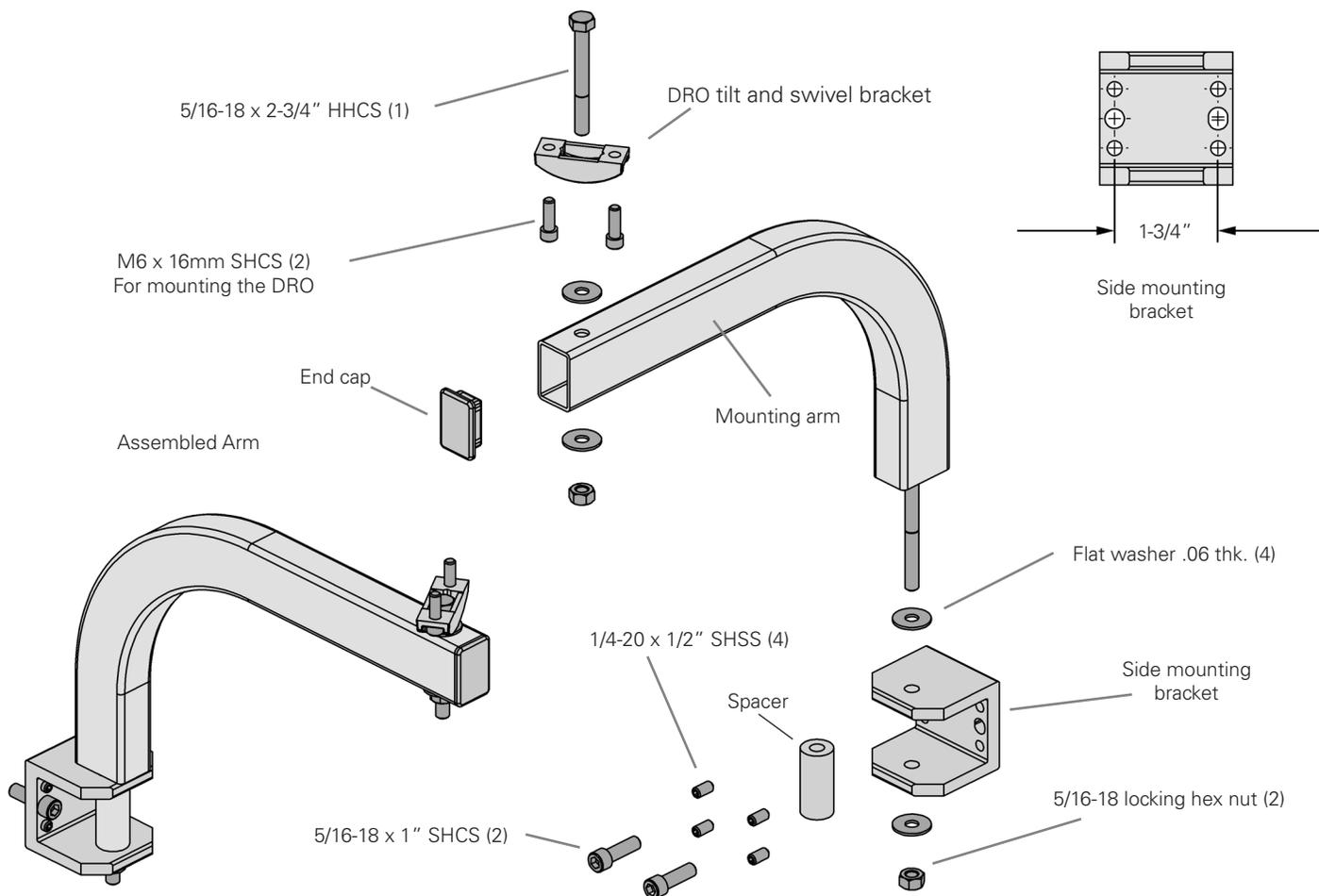


DRO Mounting Kit

Instructions for general vertical surface mounting

Side mounting bracket ...

The tilt and swivel bracket provided with this kit is not used with the VUE DRO. The VUE DRO has an integrated tilt and swivel feature.



- These instructions are for mounting the DRO using the side mounting bracket and arm for mounting kit ID 683665-01.

Before proceeding:

- ▶ Please read the instructions completely before beginning the installation.
- ▶ Clean the mounting surface.
- ▶ DRO mounting location must not interfere with machine movement or allow the DRO to be damaged during machine operation.
- ▶ An older DRO may require a 1/4-20 x 3/4" SHCS in place of the M6 x 16mm SHCS.

Installation Steps ...

- ▶ Attach the arm to the side mounting bracket and hold the assembly to the side of the machine (include the DRO if necessary). Mark the bracket location on the machine.
- ▶ Disassemble the arm from the bracket. Hold the bracket to its mounting location and mark one mounting hole to the machine.
- ▶ Drill and tap the hole location for 5/16-18 x 5/8" deep.

- ▶ Attach the bracket with a 5/16-18 x 1" SHCS. Position the top of the bracket horizontal using a level.
- ▶ Transfer punch the second mounting hole location to the machine. Drill and tap the location for 5/16-18 x 5/8" deep. Attach the bracket loosely.
- ▶ Insert the (4) 1/4-20 x 1/2" SHSS and assemble the arm to the side bracket. Using a level, position the bracket horizontal, and the arm horizontal with the aid of the leveling screws. Secure assembly in place. Insert the end cap at the end of the arm.
- ▶ Insert the 5/16-18 x 2-3/4" HHCS into the tilt and swivel bracket and attach the bracket to the DRO with (2) M6 x 16mm SHCS. To attach the VUE DRO, refer to the installation instructions ID 1084373-9x.
- ▶ Attach the DRO assembly to the arm. Tighten the locking hex nuts to obtain the desired tilt and swivel tension for both the DRO, and arm.
- ▶ Route the cables along the arm to the back of the DRO, cable ties are provided. Secure cables providing sufficient slack loops to allow for arm and DRO movement.

HEIDENHAIN CORPORATION

333 East State Parkway
Schaumburg, IL 60173-5337 USA
☎ +1 (847) 490-1191
FAX +1 (847) 490-3931
E-Mail: info@heidenhain.com
www.heidenhain.com