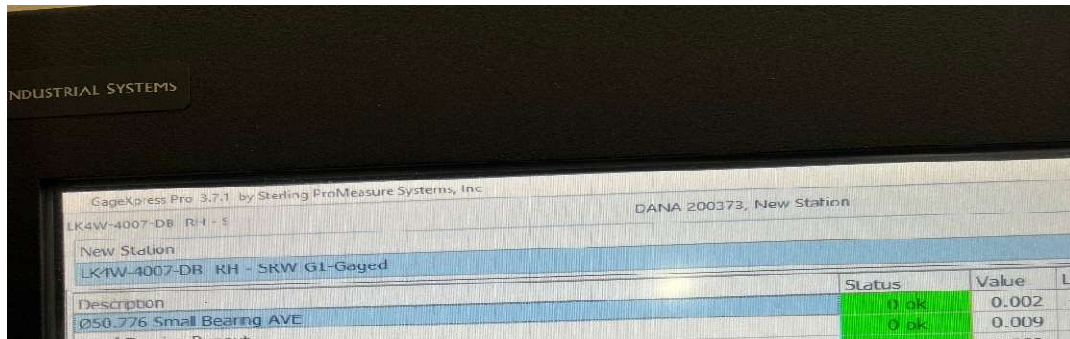


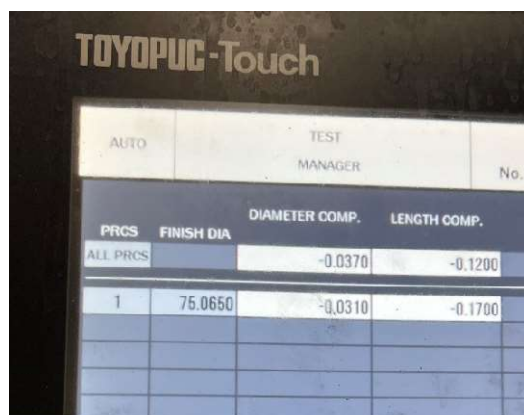
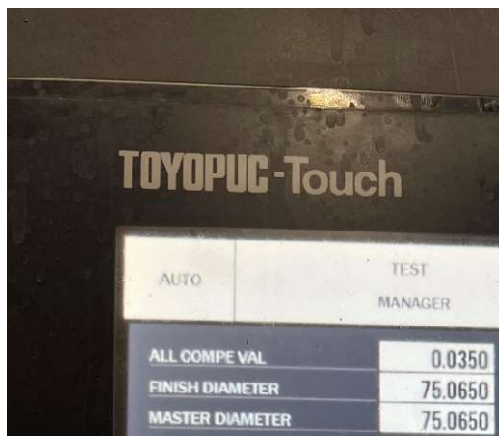
## Mastering Gauge Fingers



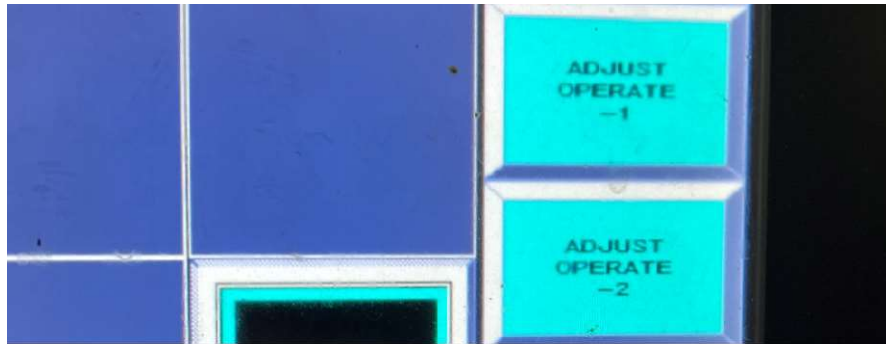
1. Put a part in the auto gauge and get a measurement of the small bearing. Once you have the measurement write it down, you will need it later in the process.



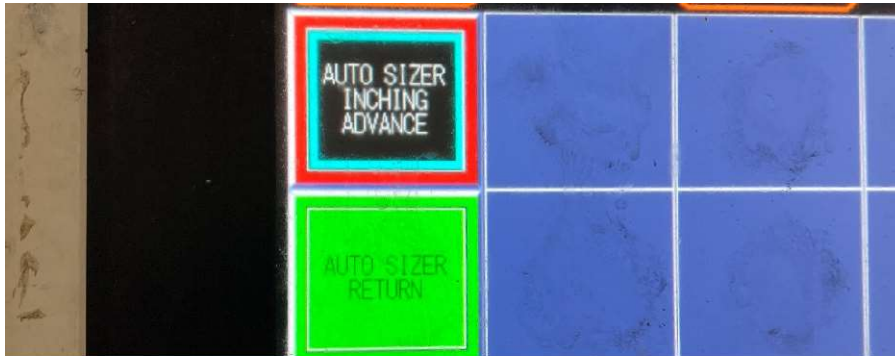
2. Place the part that you just measured between centers and move table to grinding position.



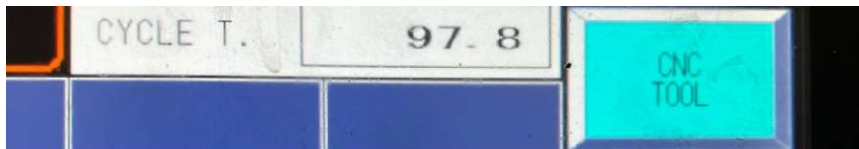
3. You need to erase all comps for the diameter and set them to 0.



4. Then you will hit **adjust rate 1**.



5. Then you will advance gauge fingers.



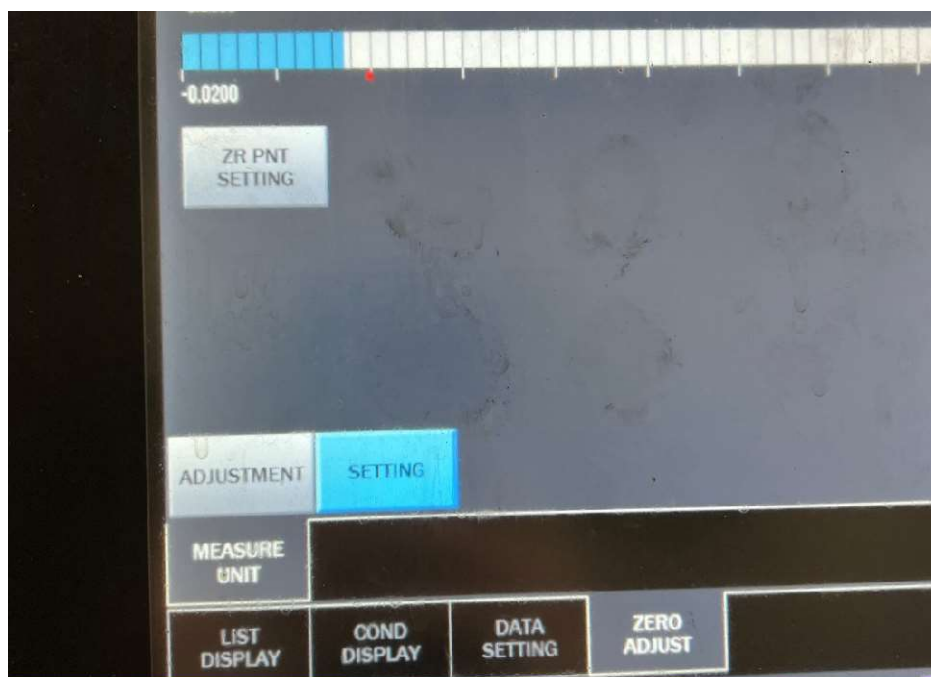
6. Next you will need to navigate to CNC tool.



7. Next you will hit monitor.



8. Once you hit monitor you will tap COND DISPLAY. This will tell you what the gauge fingers think your part measures. If this measurement dose not match the first measurement you took on this part, they need to be mastered out continue with the process however if it matches your part measurement your gauge fingers are good no need to continue.



9. So now you will hit ZERO ADJUST and then adjust pins on gauge fingers to match the part measurement once it matches you will then hit ZR PNT SETTING this will zero out the gauge and your good to run a part.