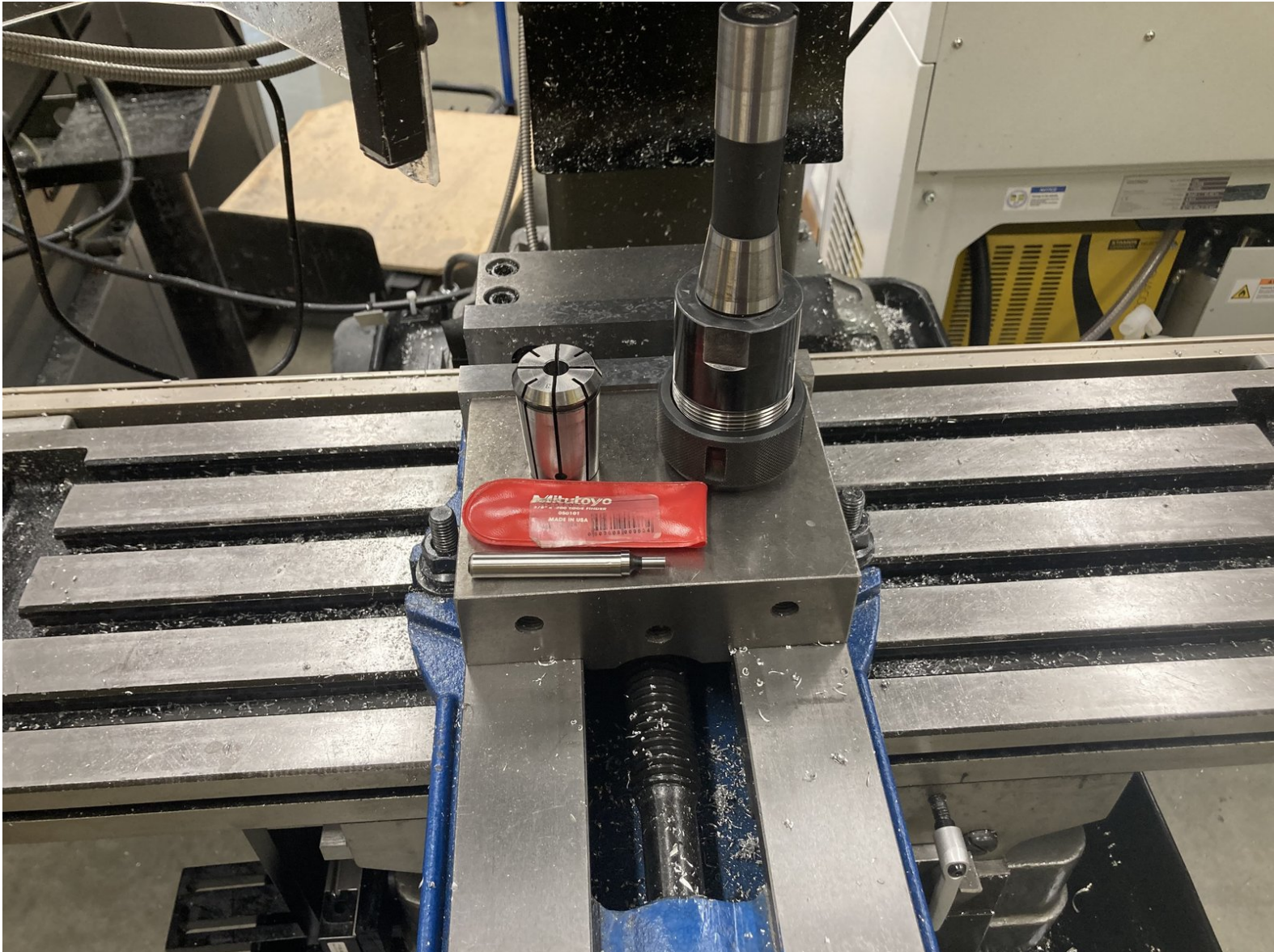


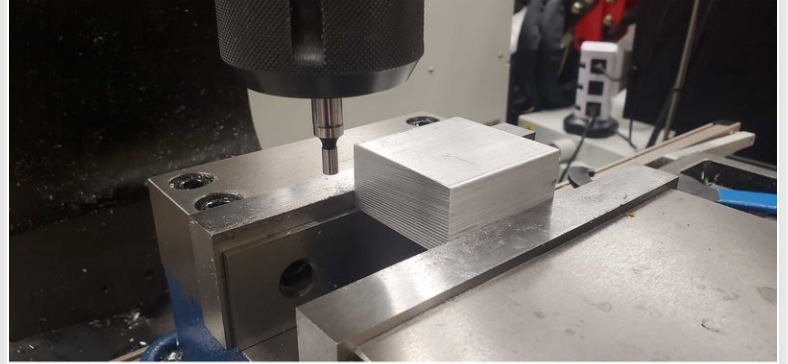


IFL Training Shift 05-2: Drill/Mill Edge Finder & DRO

Written By: Kenny Davis Jr



Step 1 — Edge Finder Set-up



- Once the part is secured in the jaws, gather a collet chuck, a 3/8" collet, and the edge finder.
- Insert the edge finder into the collet and secure the collet in the mill.
- Turn on the Digital Readout(DRO).
- Turn on the mill and set the rpm to around 500 rpm.

Step 2 — Using the Edge Finder



- With the machine on, move the z axis down and lock it when the tip of the edge finder is halfway below the surface of your stock off to any edge.
- As the edge finder spins you will notice that the tip is not true to the shaft.
- Slowly move the edge finder against the edge of the stock until the tip is true.
- Once this is complete, zero the DRO and move the edge finder straight up in the z direction.

Step 3 — Using the DRO



- With the edge finder above the surface of the stock and the DRO zeroed, move the bed until the DRO reads 0.1".
 - Since the tip of the edge finder is 0.2", the zero on the DRO needs to be at the tip's center. Moving half of the diameter puts the edge finder at center.
 - Once this is complete, lock whichever axis you just zeroed and repeat this guide for the other axis.
-