

Front spindle Yoke Pre-CNC

2/11/24

- Dimensions

→ 6.088" long target: 5.840
diff: 0.247"

slight burrs

- check tool angle and height
- dial indicator to adjust in/stock

- plug drill w/
wt glue

Steps

- 1) face ~~to 2.5~~ (zero z) BGC2 (65 thou/rev)
- 2) ~~turn~~ 2) center drill
- 3) turn
- 4) chamfer

face

- 50 thou cuts .050
- 325 RPM (350 chatter) .100
- set z 3.585" .150
- lock z when facing .200

turn

- 5.1 thou/rev for first 1-3 passes target: 0.7874
- and then keep going up
- 0.125" depth of cut
- init. cut diam

left	right			
2.3792	2.3792	.125	5.1 thou/rev	335 RPM
2.2498	2.2491	.75		525
2.1205	2.1205	.375	5.3 thou/rev	355 RPM
2.0207	2.0207	.5		8'
1.8750	1.8758	.625	5.8 thou/rev	360 RPM
1.7484	1.7484	.75		

left	weight	press	soft chgs
1.6696	1.6703	.875	370 RPM
1.4904	1.4908	1.000	375 RPM
1.3676	1.3678	1.125	
1.3684	1.3678	re-measure	
1.3675	1.3678	re-measure	
1.2402	1.2407	0.125	
1.0149	1.0150	0.25	
0.99987	0.9998	0.375	
0.9333	0.9382	0.435	2 1/2 thou left 60 thou press (start removing every press)
0.8735	0.8734		
0.8127	0.8127		

		skim	
0.8094 ²	0.8087	5 thou	
0.8043	0.8038		
0.8041	0.8038	1 thou	
0.8036	0.8038	1 thou	
0.8025	0.8036	1 thou	
0.8006	0.8025	1 thou	
0.7979	0.7989	2 thou	
0.7964 ⁵	0.7967	1 thou	1/10 thou adjust
0.7947	0.7954	1 thou	3/10 thou adj
0.7935	0.7941	1 thou	4 thou out pulsock adj
0.7919	0.7918	1 thou	
0.7910	0.7910	1 thou	
0.7890	0.7890	2 thou	
0.7881	0.7882	1 thou	
0.7875	0.7876		

left
0.1875

right
0.1874

(spring mount)
it slips on!

- how to chamfer w/ file **★ note for next year:**
actually chamfer w/ tool,
not file, both edges

Mill Key slot on Front Spindle Yoke pre-CNC

- 6mm endmill (check size)

- edgefile

- fixture (take later)