SR-24

Front Spindle Yoke key slot 2/16/24

- edgefinder to find centerline

→ use centerline to check perp. w/ dial indicator

~~- teach~~

→ to find centerline: (not relevant)

→ on DRO, go to axis ~~zero~~

→ probe

→ centerline

→ move to edge 1

→ teach

→ edge 2

→ teach

→ math

X zero at 0.25

not relevant

dist. btwn edges:

~~0.7834~~ 0.787

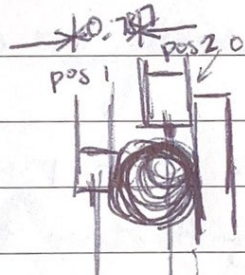
ø of piece is 0.7874

ø of edgefinder is 0.5

center so $\frac{0.5}{2}$ so 0.25

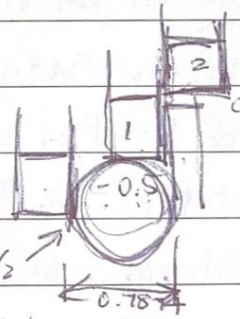
0.787

- 5/10 taper zcross part (spin



subtract .25?

$\frac{0.787}{2} = 0.3935$



- to find halfway btwn 2 edges:

→ right arrow

→ half (should be half of dim. + radius of edgefinder)

- slot

→ lock X and Z at same time to slot cut

→ instead of plunging bc plunging probably kills tool

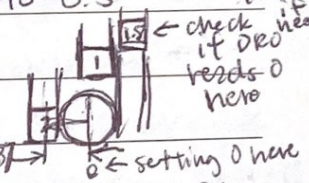
→ in center-ish of slot, not end (slowly go out to max slot dim)

some notes

→ 15 thou passes

→ 400 RPM? nope! 700 RPM

↳ last pass go ~~to full~~ dim

Clear steps ← trim mill
↳ clean vise and all surfaces
1) fixture part → don't fully tighten jack yet (top) bonk higher side w/ mallet handle
2) dial indicator on X-axis (yes, that's all you need)
↳ then tighten jack and check again
3) edgefind flat face for X zero, set to -0.25 → dial indicator slot over to check taper there
4) ① edgefind ~~static~~ fixed vise face, set to 0.5
setting centerline
→ ② edgefind small ø
→ right arrow > 1/2


→ sanity check if the dim on DRO makes sense
→ should be $\frac{0.7874}{2} + \frac{0.5}{2} = 0.6437$ (in this case)
5) figure out dim to slot to for initial passes
→ do not pass to max slot dim until last pass!
~~go to Y zero and lock Y-axis~~
6) lock X ~~and Z~~ axis as practice around halfway
→ prep for rocking X-axis while moving Z so endmill doesn't plunge into workpiece
7) set Z zero w/ touch-off 700 RPM
8) start rocking X around half-way slot as going down Z to ~~first pass~~ depth of cut
→ ~~0.015 dep~~ 0.015 depth of cut
9) go to max X-dim on last pass
10) deburr
* unlock Y-axis
11) check bearing fit
12) clean bed surface