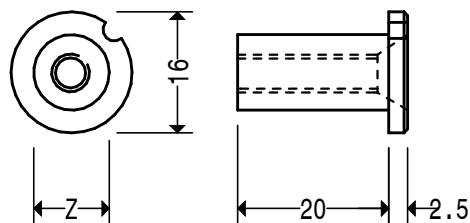


NOTES

1. X AND Y TO SUIT WORKPIECE BEING LOCATED
2. THE 10MM AND X DIAMETERS MUST BE CONCENTRIC
3. DIAMETER X MAY BE THE LARGER DEPENDING ON THE HOLE IN THE WORKPIECE BEING LOCATED.
4. IF 10MM IS THE LARGER, MAKE FROM 12MM BAR SO THAT BOTH DIAMETERS CAN BE MACHINED TO ENSURE THEY ARE CONCENTRIC.
5. THE 10MM DIAMETER MUST BE A CLOSE FIT IN THE UPPER PLATE.

MATERIAL STEEL 230M07 12MM DIA, OR LARGER IF DIAMETER X IS LARGER THAN THIS

WORKPIECE LOCATER C



NOTES

1. DIAMETER Z TO BE A CLOSE FIT IN THE ROTARY TABLE OR THE TAPER ADAPTOR
2. DIAMETER Z AND THE 16MM DIAMETER MUST BE CONCENTRIC. THEREFORE, MAKE FROM 18MM DIAMETER SO THAT BOTH DIAMETERS CAN BE MACHINED.
3. THE 16MM DIAMETER MUST BE A CLOSE FIT IN THE UPPER PLATE
4. MAKE TWO LOCATERS, ONE WITH AN M6 THREAD AND THE OTHER M3 FOR USE WHERE M6 IS TOO LARGE FOR THE HOLE IN THE WORKPIECE BEING LOCATED.
5. MAKE THE DRILLED CENTRE AT LEAST 8MM DIAMETER AS IT IS USED FOR LOCATING THE ROTARY TABLE ON THE MILLING MACHINE TABLE.
6. FILE THE ANTI TURN NOTCH AS IT DOES NOT NEED TO BE A CLOSE FIT.

MATERIAL STEEL 230M07 18MM DIAMETER.

ROTARY TABLE AND UPPER PLATE LOCATER A