INSTALLATION OF ACU-RITE® MINI-SCALE ASSEMBLY

SECTION 1. INTRODUCTION

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This manual contains instructions for installing the ACU-RITE® Mini-Scale assembly (Figure 1). The Mini-Scale can be used with any of the ACU-FITE® digital readout (DRO) consoles. The instructions in this manual assume that you've read the operator's manual provided with your digital readout and that you will read these instructions carefully before proceeding with the actual mounting. Make sure you understand all the basic steps and follow them carefully.

NACOTE:

Dimensions and hardware references are in both English and metric terms. English hardware is supplied with your Mini-Scale assembly. Metric hardware may be substituted as indicated.

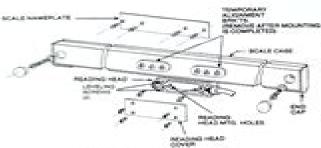


Figure 1. Mini-Scale Assembly [Partially Exploded View]

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CAUTION

Exercise extreme caution when removing the reader head from the scale assembly. The electronic circuitry or grating within this assembly can be easily damaged. The removal procedure should be performed only by a qualified service technician who has the special tools and training required.

SECTION 2. PREPARATION

Your Mini-Scale comes preassembled, ready to be mounted on your machine or fixture, although some installations may require that you fabricate mounting brackets for secure attachment. Temporary alignment brackets have been provided to hold the reading head casting in proper alignment to the scale.

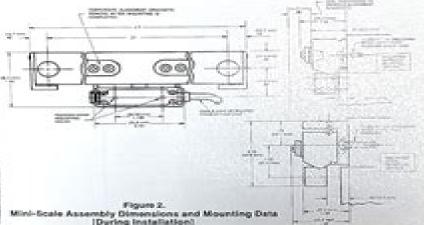
When you remove the scale assembly from its shipping container note the removable end caps/gaskets and sealing plugs on both ends of the assembly. Remove the end caps/gaskets and push out the sealing plugs on both ends of the assembly before starting the installation.

NOOTH III.

Do not remove alignment brackets at this time.

As you proceed with the installation remember to:

- a. Keep the reading head casting and alignment brackets tastened in position until the mounting is complete.
- The scale must be mounted such that the front surface of the scale is true to the machine table (and/or spindle) travel within .010" (.25 mm) T.I.R. over the full length of the scale case, and within .005" (foot (.13mm/300mm) T.I.R. The top surface must be true to the table within 005" (.13mm) T.I.R. at both ends of the scale.
- c. Mount the scale case with the rubber scale facing down or away from the machine outlers and coolent sprays. If the scale must be mounted with the seals facing cutter. and spray, fabricate a sheet metal or Neoprene cover to protect the seals.



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Direct support and general support maintenance manual for truck, cargo, tactical, 1-1/4 ton, 4x4, M1008 (2320-01-123-6827),1983 Truck Service Manual ,1984 **Technical Manual** United States Department of the **Direct Support and General Support Maintenance** Army, 1961 Motor's Truck & Tractor Repair Manual, 1956 **Technical Manual** United States. War Department,1946 Organizational, Direct Support and General **Manual** .1993 Support Maintenance Manual: Truck Tractor, Yard Type, 43,500 LB GVW, DED, 4x2, Army Model M878A1 (Ottawa Model 50) Direct Support and General Support Maintenance Manual for Truck, Lift, Fork, Diesel (NSN 2320-01-121-2102). Engine, Pneumatic Tired Wheels, Rough Terrain, 6,000 Lb. Capacity, 24"load Center, Anthony Model MLT6-2, **Army Model MHE-230, (NSN 3930-00-327-1575).** ,1979 Organizational Maintenance Manual for Truck, Cargo, Tactical, 1-1/4 Ton, 4X4, M1008 (2320-01-123-6827) ,1983

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