

## Indexer

With this spin fixture you are able to: spin grind, install radii and angles, use on a milling machine, submerge in fluid and use for inspecting angles or roundness.

### **Topside Shotpin**

The topside Shotpin allows lock-in indexing every 15 degrees, repeatable within 10 arc seconds. To use, twist the topside thumbscrew allowing the Shotpin to drop into place.

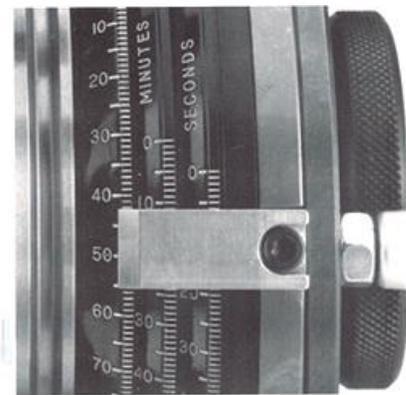
### **Indexing Plates**

Simple long lasting indexing plates can be set to any angle very accurately. To use the indexing plates loosen the backside nut until the plastic plates are loose. Pull the second plate to the back of the fixture. Join the minutes plate teeth into the seconds plate teeth. Hold these two plates together join the minute's plate into the teeth of the degrees plate.

**Note: If setting minutes are greater than 30' you should be setting the angle to the next higher setting.**

**Example: 90° 40'**

**You will see 91° exposed, because the indexing plates are closer to that position. Seconds plate will follow the same process as minutes plate.**



Tighten the backside nut. Twist the whole assembly of plates so the setting is at the edge of the datum bar. Insert the wedge narrow end first. The angle is now set.

### **Adjustable Stops**

Two adjustable stops are standard. Using additional stops more than 30 repeatable angles can be used with one setup. Install the stops at the top center of the fixture since the stop must be tipped to attach to the OD of the faceplate. Use a stop when arcing to an angle so your grinding wheel does not hit the adjoining flat.

### **Locking An Angle Using A Stop**

Loosely install a stop onto the perimeter of the faceplate. Slide the backside Shotpin into the stop. Using the indexing plates or a sine plate, set the angle. Install the wedge and tighten the stop.

### **Spindle**

The spindle is guaranteed to 50 millionths TIR for one year from purchase date. The faceplate is guaranteed +/- .0003" square over 3 3/4".

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**Zero Null Benefit**

Nullify the zero setting by removing the wedge. Fix the topside Shotpin at zero degrees. Loosen the backside nut. Align the plastic plates to zero and tighten the backside nut. Loosen the two backside button head screws. Insert the wedge narrow end first. Tighten the two button head screws. The fixture is now zeroed.

**5C Insert**

The standard 5C insert is ground to fit a particular fixture. The serial number is engraved onto the insert.

**Lubrication**

Re-lube the fixture every six months if it is used for dry grinding. If you use the fixture in a wet environment re-lube weekly using **LPS Thermaplex Aqua Bearing Grease**. A 1/4-28 grease port can be found on the side of the fixture.

**Submersion**

The fixture can be safely used in a wet environment or submerged into fluid by attaching an air regulator into the grease port and supplying 2 pounds of air pressure. Electrical grounding of the fixture is required in an EDM environment.

**Motor**

The 1/15 hp variable reversible 1200-rpm motor produces a zero to 400-rpm spindle speed of the fixture.

<b><u>Specifications:</u></b>	
Spindle roundness	50 millionth TIR
Deflection	+-.0003" 3 - 3/4" Out
Topside shotpin	10 arc-second repeatability
Center height	3.004" +- .002" from bottom
Thru hole	1- 1/4" plus
Weight	18 lbs
Base size	3 -1/4" x 4 -1/2"
Height	5 - 1/2"
Bottom holes	2 - 1/2" centers
Material	A2
V-Block capacity	1- 1/2"

**Available Accessories**

- Precision Three Jaw Chuck
- 4" Magnetic Chuck
- Quick Mount Adapter for Magnetic Chuck
- LPS Thermaplex Aqua Bearing Grease