



## VAS1N ARTICULATING ARM INSTRUCTIONS

### INSTALLATION: BRIDGEPORT TYPE KNEE MILLS

#### **1. Check contents of package:**

- Support arm (pre-assembled)
- DRO support tray (May not be standard with this kit)
- Hardware package (Symbols and contents of hardware are listed in table at bottom of page)

#### **2. Choose mounting location:**

- Ideal location is 12" back from the center line of quill handle on ram (Make certain arm does not interfere with ram locks/re: Alliant)

#### **3. Pre-mounting operations:**

- Install (A) ¼-20 set screws into base
- Set the base into position, level in all directions, and transfer punch holes
- Drill and tap for ¼-20 (Approximately 1 ½" deep)

#### **4. Mounting arm and final assembly:**

- Using the (B) ¼-20 cap screws supplied with this kit, bolt arm assembly to casting and torque to standard settings for ¼". *BE CERTAIN TO LEVEL ARM PROPERLY. IF THIS IS NOT DONE, IT MAY CAUSE DAMAGE TO STRUCTURAL COMPONENTS AND CAUSE FAILURE.*
- The DRO tray may now be installed with two (C) 10-24 X ½ button head cap screws (Tray will tilt front to back to eliminate glare on readout)
- Install (D) adjust knobs and tighten. *\*\*TO AVOID INJURY, SUPPORT END OF ARM FROM BOTTOM WHEN LOOSENING SCREWS ON BACK, AND RETIGHTEN PROPERLY WHEN FINISHED.*

#### **5. Mounting of readout:**

- Mount the DRO to the tray/arm assembly using the (E) M6 screw supplied in the hardware bag (Make certain not to over torque the threads)

#### **6. General:**

- Always follow any and all special instructions from the DRO manufacturer regarding installation of the DRO. Ideal adjustment height will have to be determined by each individual operator.



### MOUNTING HARDWARE

CODE #	QTY.	SIZE	DESCRIPTION
A	4	1/4-20 x 1/4	S.S.
B	4	1/4-20 x 3/4	S.H.C.S.
C	2	10-24 x 1/2	B.H.C.S.
D	1	1/4-20	Adjustment Knob
E	1	M6 x 12	S.H.C.S.

