



VAS2N 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 5/8	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	2	1/4-20	Adjustment Knob
E	1	M6 x 12	S.H.C.S.

