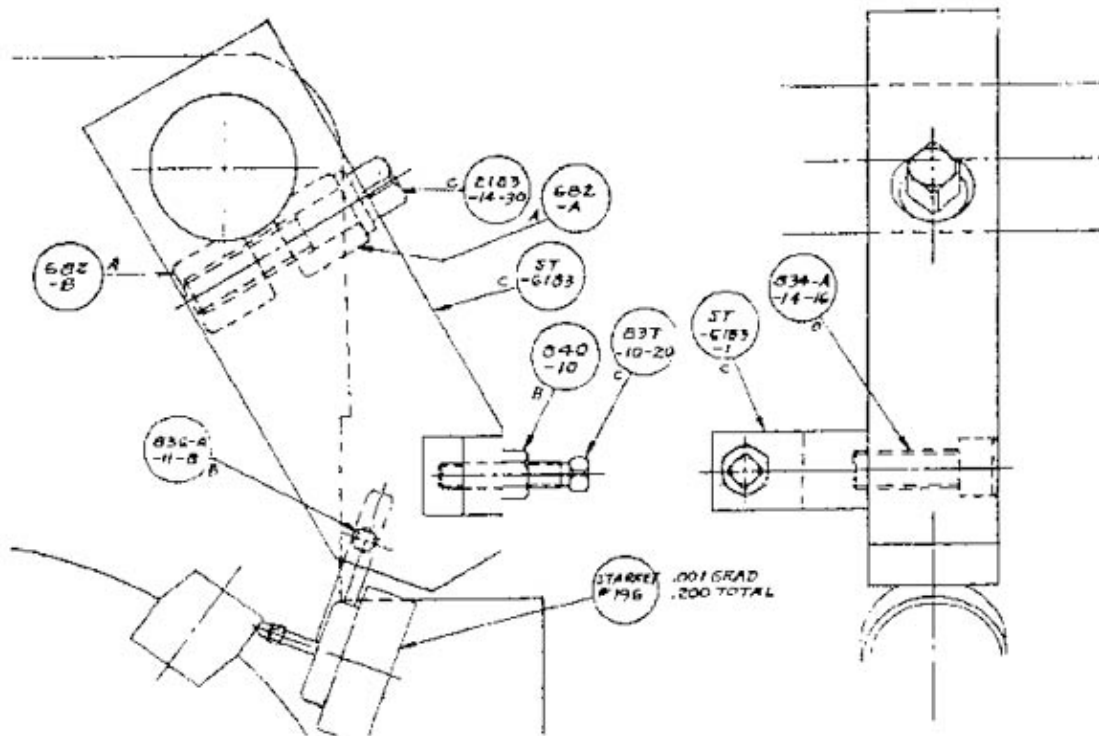


## Checking the locating blocks on the revolving head for block to block uniform location without removing the revolving head from the machine.

1. Remove **Spindle Change Gears**.
2. Remove **3rd Position Tool Arm** and replace with **Fixture ST-6183**.
3. Ensure that the machine is in working cycle with the head firmly locked in position with the **Locating Lever (5080-34-1)**.
4. Set indicator on fixture to make contact with **Locating Block 724-1** with as much contact as possible without hitting O.D. of Revolving Head, lock in place with set screw.
5. Adjust **Stop Screw** on fixture to come in contact with **Spring Retainer Bolt** on revolving head cap so that indicator will make only 1/2 revolution on dial when up against the locating block. **Set indicator at "0"**.
6. Swing indicator away to clear index and proceed to inspect each of the Locating Blocks after head is completely locked in location with **Locating Lever (5080-34-1)**
7. **The indication of all five blocks should not exceed  $\pm .001$  of each other. Anything over this tolerance would suggest improper replacement or damage.**



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