Mounting the Base to Your Fixture

The base is mounted to your fixture by means of two 1/4-20 holes in the bottom of the base. As an alternative, a groove is provided around the base that can be used with Sherline's angle clamps. Drill and tap 10-32 holes in your fixture in the appropriate locations and use 10-32 socket head cap screws to hold the angle clamps. Angle clamps are P/N 35580 and can be ordered from Sherline.

Manual and CNC Versions

The manual version (P/N 6560) utilizes a handwheel that is graduated in .001" increments. There are 50 divisions on the handwheel, so one turn of the handwheel advances the table .050". The metric handwheel is graduated in .01 mm increments. There are 100 marked divisions, so one turn of the handwheel advances the table 1 mm.

The CNC version is ready to accept a 23 frame size stepper motor. Four mounting screws are provided. Also included is a handwheel (P/N 40080 or 41040) that can be mounted to the rear shaft of a dual-shaft stepper motor. This handwheel is graduated in .001" (or .01 mm) increments, with one revolution resulting in .050" (or 1 mm) of movement. The front shaft of the stepper motor is secured to the coupling by means of a set screw. The set screw is tightened by aligning it with the hole in the stepper motor mount and inserting a hex key to tighten it against the motor shaft.

Putting a Flat on the Stepper Motor Shaft

Stepper motors ordered from Sherline come with a flat on each shaft where the coupling set screw is to be tightened. If you use a stepper motor from another source it is important that you machine or file a flat in the appropriate location before installation. If the set screw is not tightened against a flat, it can upset the surface of the shaft, making it impossible to remove from the coupling. The attached drawing of the mount shows the location for the flat on the motor shaft. The center of the flat will occur .515" (13.1 mm) from the mounting surface of the stepper motor.

Thank you,
Sherline Products Inc.