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 ± .001 of each other. Anything over this tolerance would suggest improper replacement or damage.