

SHERLINE PRODUCTS

INCORPORATED 1974

RESETTABLE HANDWHEELS

PART NUMBERS: 2" – 3420 (Inch), 3430 (Metric)
 2"–3428 (Inch), 3429 (Metric)
 2½" – 3440 (Inch), 3450 (Metric)
 2½" Assembly, "Z" Axis – 3455 (Inch, 3459 (Metric)

Most expensive full size machine tools allow the machinist to reset the handwheel to "zero" (or any desired setting) at any time during a machining operation. Now that option is available on Sherline's miniature machine tools as well.

INSTALLATION

The resettable handwheels easily replace any standard Sherline handwheel. Simply loosen the set screw on the standard handwheel and slide it off the shaft. Slide the new handwheel onto the shaft. Align the hole in the red engraved collar with the set screw. With your other hand, push against the opposite end of the lead screw to eliminate all "play" (backlash) between the handwheel and column thrust and tighten the set screw.

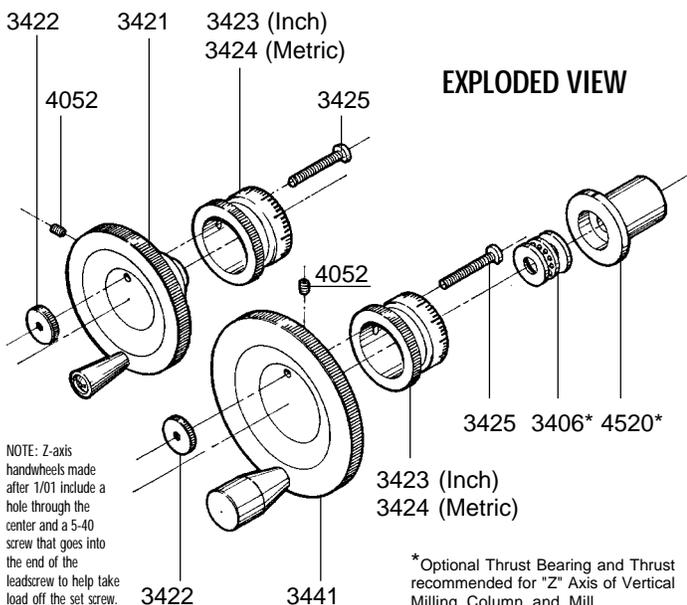
The larger 2½" handwheel is normally used on the Z-axis of the mill or vertical milling column and works best when used with the thrust and bearing set, because you are actually "lifting" the weight of the column with this handwheel when you crank it up. Handwheels turning on the horizontal axis are not subjected to this stress and work fine without thrust bearings. Later model Sherline mills and vertical milling columns include the Z-axis thrust bearing as standard. The

thrust on the column is bored to accept it. If you are upgrading an older mill or column that does not have a thrust bearing on the Z-axis, you will need to order P/N 3460 which consists of a handwheel and a bearing set plus a P/N 45200 bored column thrust to replace your existing plain thrust. If your existing handwheel has a set of ball bearings in it but you have a plain thrust, order P/N 3470. This includes a new new handwheel and a bored thrust but not the bearing set, which you will re-use from your old handwheel.

RESETTING THE HANDWHEEL

At any time during your machining operation, you can now simplify your calculations by resetting the handwheel to "zero." To do so, gently hold the handwheel in position with one hand while releasing the lock nut with the other. Rotate the red anodized, laser engraved collar until the "zero" setting is aligned with the scribed mark on the mill, lathe or thrust bearing collar. Then retighten the locking nut. Now you can crank in the exact amount of feed you want by reading the number directly off the handwheel.

Joe Martin, President and Owner
 Sherline Products, Inc.



PARTS LIST

PART #	DESCRIPTION
3406	Thrust Bearing and Washers
3420	2" Handwheel Assembly, Inch (Metric P/N 3430)
3421	2" Handwheel body
3422	Handwheel Locking Nut
3423	Engraved Hndwhl. Collar, Inch (Metric P/N 3424)
3425	6-32 x 7/8" Pan Head Screw
3426	Z-axis Hndwhl Collar, Inch (Metric P/N 3427)
3440	2½" Handwheel Assembly, Inch (Metric P/N 3450)
3441	2½" Handwheel Body
3455	2½" Hndwhl Asby, Z-axis, Inch, (Met. P/N 3459)
4052	10-32 x 3/16" Cup Point Set Screw
4520	Bored Column Thrust
3460	2½" Hndwhl w/Thrust & Bearings (Met. P/N 3465)
3470	2½" Hndwhl w/ Bored Thrust (Metric P/N 3475)