

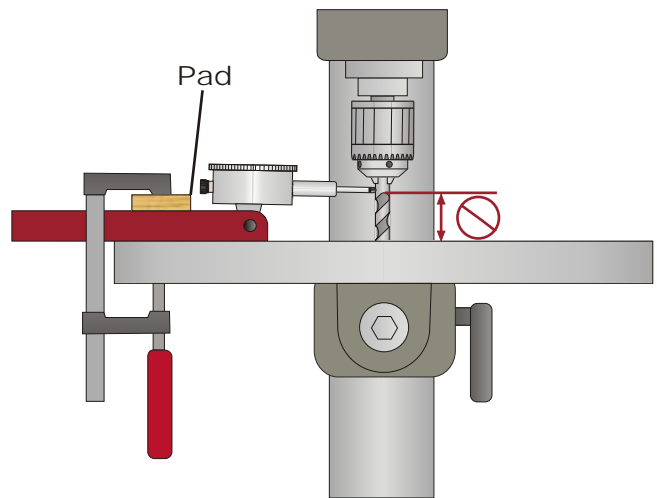
A-LINE-IT™ Drill Press Test # 2 Checking Chuck & Spindle Run-Out

In the Illustration to the right, you can see the A-Line-It™ configured to check the chuck and/or spindle run-out on a drill press.



Start by configuring the A-Line-It™ as shown in the Illustration to the right. If you have the Deluxe A-Line-It™, insert the precision pin into the drill chuck, and tighten. If you have the Basic A-Line-It™, you can use a 3/8" - 1/2" drill bit for this purpose. If you do this, make sure that the tip of the dial indicator is above the flutes in the bit, as shown in the Illustration to the right. Elevate the drill table so the tip of the indicator is just slightly below the tips on the drill chuck.

To avoid scratching the mounting bar, place a protective pad, (such as a piece of scrap wood or cardboard) on top of the mounting bar. Lightly clamp the mounting bar to the drill press table.



Position the tip of the indicator as close to the center-line of the pin or drill bit as you can, and tighten the clamp.

Set the "zero" on the dial indicator, as shown in the Illustration to the right.

To check run-out, rotate the spindle. I would suggest you do this by turning the pulley, and not place your hand on the drill chuck. If it appears that you have excessive run-out, I would loosen the chuck, and reinstall the pin. If this doesn't correct the problem, you may want to remove the chuck from the spindle. Do this same test on the spindle to see if it is bent, and check for contamination on the spindle or in the chuck socket that may be causing the run-out.

