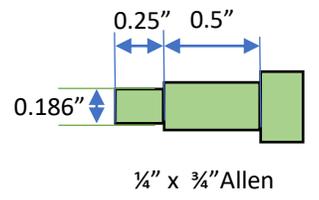
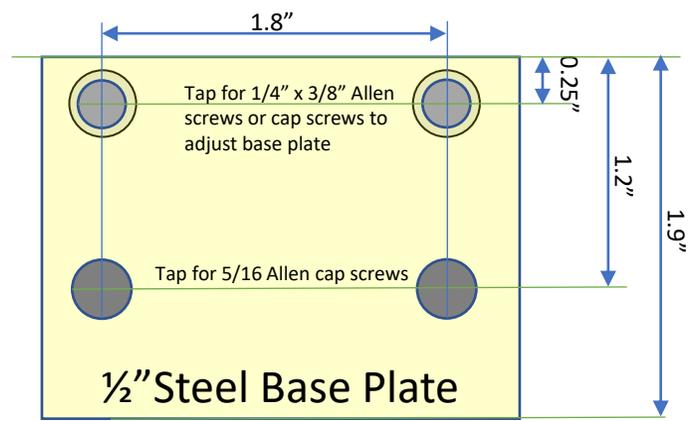
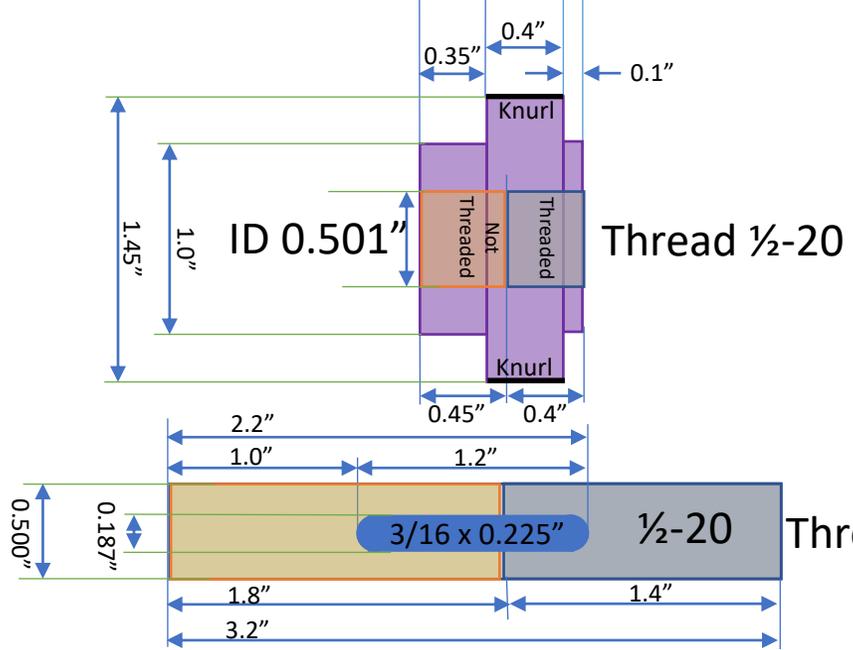
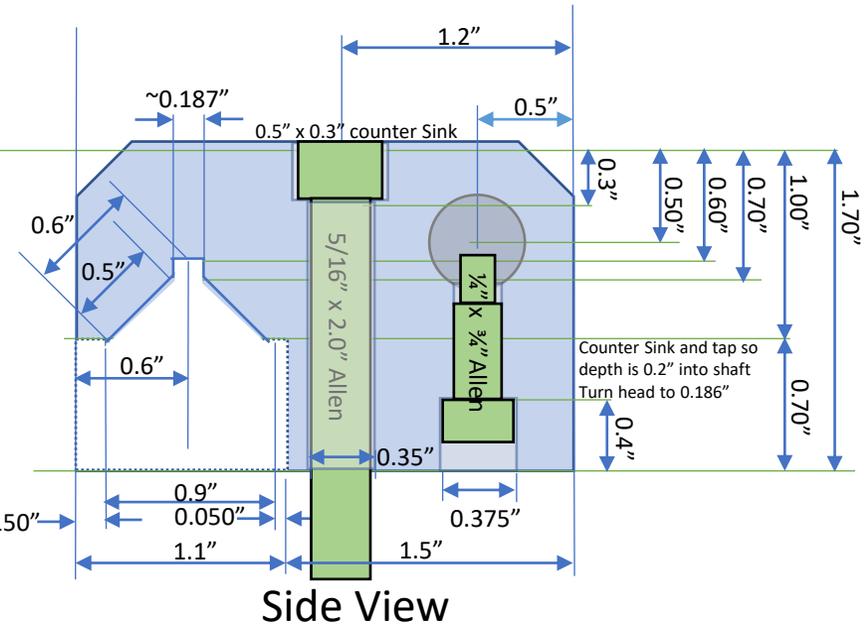
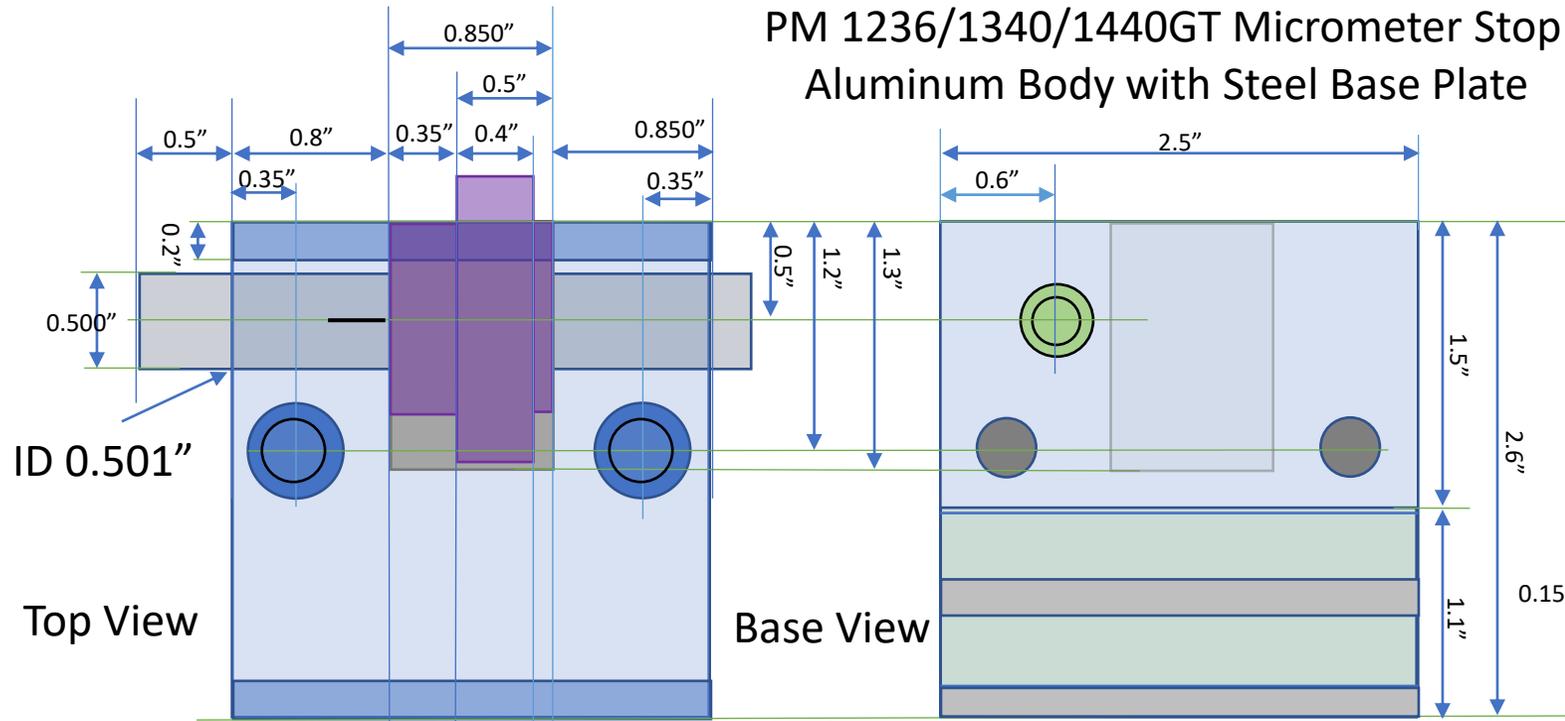


# PM 1236/1340/1440GT Micrometer Stop Aluminum Body with Steel Base Plate



Body is aluminum either 6061 or 7075, thumb wheel and shaft is steel rod (OD needs to be accurate, suggest O1 drill rod), base plate is 1/2" CRS mild steel plate milled to size. Use a 0.501" reamer on the shaft bore to allow clearance. Thumb wheel only tapped 0.4" the other 0.45" is drilled/reamed (0.501") to allow more shaft travel. Make the thumb wheel first so you can test fit with shaft thread and when milling the slot in the block. Knurl outside and can scribe indicator marks on rotary table. Ideally clearance is 0.0005" between wheel and body (alternative is to use a thin finger washer). Thumb wheel slot 1.3" into body 1.5" down (or though to base) needs to be milled from top into the body so the wheel fits, use a rougher and then finish with a 1/2" end mill. I size the pocket to the thumb wheel by taking 0.001" sequential cuts. Mill slot in micrometer shaft with 3/16 end mill, turn down head of 1/4" Allen screw to fit 3/16 slot in shaft. Counter sink Allen head from under the block to prevent rotation of the shaft. It must not bind. Micrometer travel is ~1.1".

