



Edge Finders provide a fast and accurate method of allowing the work piece to be moved to a known position relative to the centreline of the machine spindle

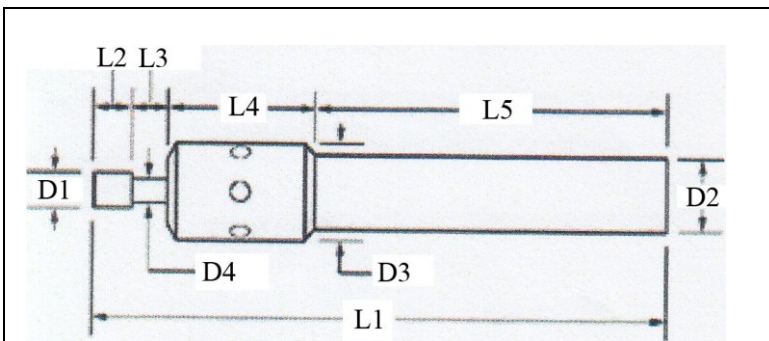
Edge Finders can only be used on conductive materials as they depend on an electrical circuit being made through the machine tool when the probe touches the work piece.

4 x Highly visible red indicator lights placed at intervals of 90° around the body of the instrument.

Main Body and Cylindrical Contact manufactured from high quality tool steel, hardened to 60 HRC

Packed Weight and Dimensions

Code	Description	Weight g	W mm	H mm	L mm
4200-520	Edge Finder Inch	48	23	23	118
AUD-BAT	Battery 23-A	7	10	10	28



All measurements in inches

D1	D2	D3	D4	L1	L2	L3	L4	L5
0.200	0.500	0.625	0.157	4.0	0.250	0.250	1.0	2.375

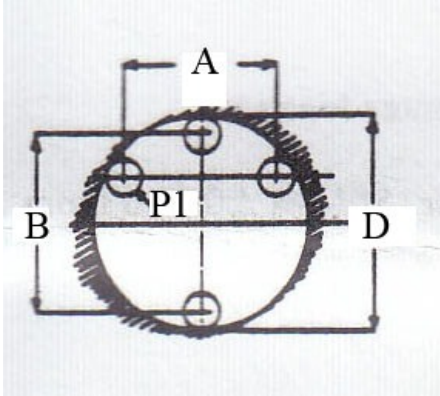
Imperial Electronic Edge Finder
 Will read off any electrically conductive material
 Illuminates instantly when probe touches work edge
 Repeatability 0.0002"
 Cylindrical probe 0.200" diameter
 Shank 0.500" diameter
 Overall Length 4"
 Power: 1 x 23-A-12V battery

Edge Location



- Test the Edge Finder before use with a conductive metal wire or flexible steel rule to ensure it illuminates when a circuit is made between the probe and the main shaft
- 1 Do not place the Edge Finder's main body below the surface of the work piece
 Ensure that the spindle is no more than 5mm below the surface of the work piece
 - 2 Feed the work piece slowly towards the Edge Finder's spindle
 When contact is made with the work piece the indicator lamp will illuminate.
 - 4 At this position, the work piece can be moved half the diameter of the probe to bring the centre line of the machine spindle in line with the edge of the work piece

Hole Diameter Measurement & Centre Location



- 1 Move the work piece below the sensor and align within the hole.
Position the sensor spindle at a depth between 1 - 5mm from the top of the surface of the hole
Feed the work piece on its X axis slowly towards the sensor spindle so it touches at position P1. Set DRO to zero
Traverse the work piece on its X axis so that the sensor touches the hole at P2. The DRO now indicates the A dimension
- 2 Move the work piece back along its X axis by half the A dimension
- 3 The centre line of the sensor now coincides with the centreline of the hole on its X axis.
- 4 Feed the work piece on its Y axis slowly towards the sensor spindle so it touches at position P3. Set DRO to zero
- 5 Move the work piece slowly back along its Y axis towards the sensor spindle so it touches at position P4. The DRO now indicates the B dimension.
- 6 To calculate the diameter of the hole: Add B dimension to Sensor Spindle Diameter
- 7 To align machine spindle centre with hole centre: Move the work piece back along its Y axis by half the B dimension