

- (2) Assemble micrometer tool bit setting gage.

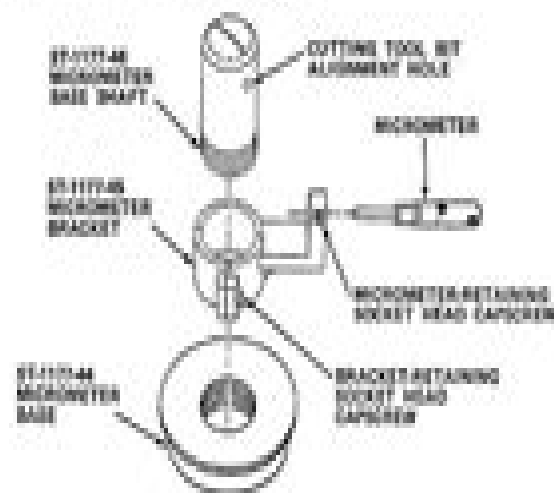


FIGURE 1

- (a) Place 57-1171-48 micrometer base shaft through 57-1171-49 micrometer bracket and screw shaft into 57-1171-44 micrometer base. Tighten securely.
- (b) Align cutting tool bit alignment hole in micrometer base shaft with hole in micrometer bracket.
- (c) Secure bracket to base shaft with socket head cap screw.

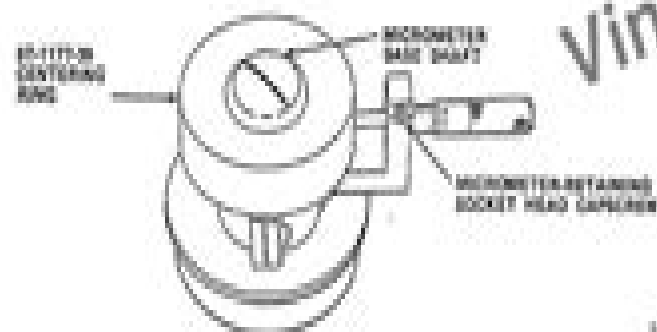


FIGURE 2

- (d) Slide 57-1171-50 centering ring over micrometer base shaft.
- (e) Install micrometer in micrometer bracket. Loosen micrometer retaining socket head cap screw some.
- (f) Adjust micrometer spindle to 4.750 in. (120.650 mm).
- (g) Hold micrometer spindle against centering ring and tighten micrometer retaining socket head cap screw.

- (h) Back off micrometer (reverse then recheck dimension).

- (i) Remove centering ring.

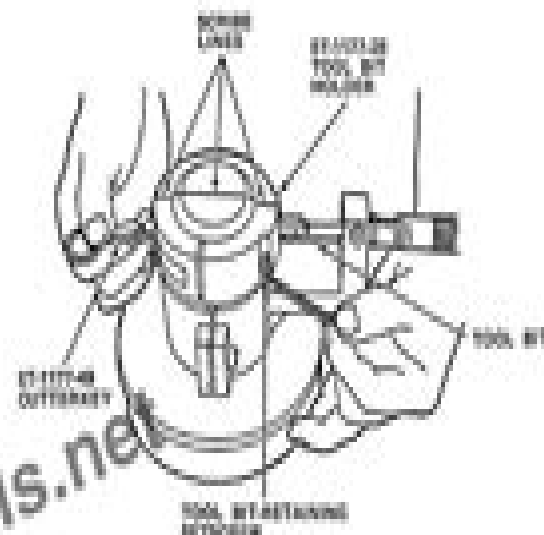


FIGURE 3

- (j) Slide 57-1171-28 tool bit holder onto micrometer base shaft.
- (k) Align scribe line on tool bit holder with scribe line on base shaft. This aligns through-hole in base shaft with tool bit hole in holder.
- (l) Select tool bit holder which is short enough so it does not extend the back of tool holder.
- (m) Insert tool bit into bit holder.

CAUTION

TO PREVENT CHIPPING OF BIT, DO NOT TIGHTEN MICROMETER SPINDLE AGAINST TOOL BIT POINT.

- (n) Set micrometer to 4.750 in. (120.650 mm).
- (o) With 57-1171-49 outer key inserted in through hole of base shaft, carefully push tool bit tip against micrometer spindle. Tighten tool bit retaining set screw in tool bit holder.
- (p) Back off micrometer then recheck dimension. Tool bit is now set at proper length for boring of new red caps to standard size.
- (q) Back off micrometer and remove outer holder from micrometer base.

Manual For A Cummins 300

Clifford Lane



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