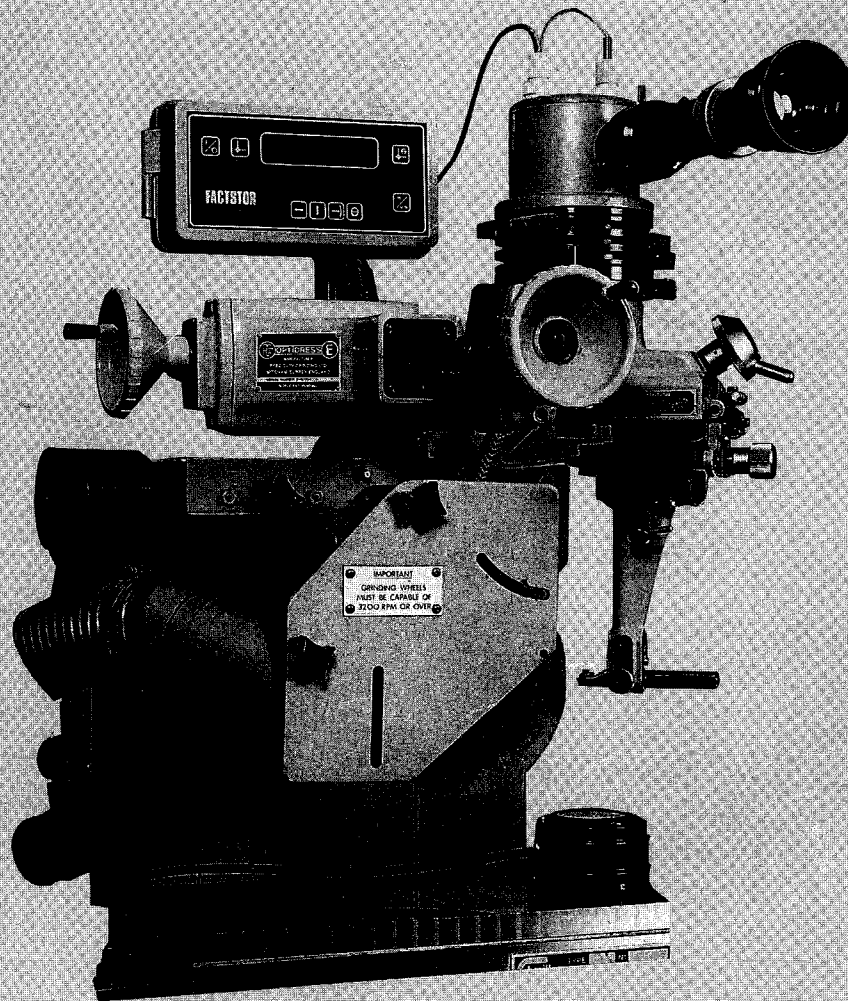


Optidress E

Factstor 2

 **COMSAT**
PG Technology



Parts List

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In accordance with our policy of continued improvement, details and specification are liable to change without notice

Introduction

The keyed illustration of the Optidress E (figure1) indicates the position of each sub-assembly and element referred to in this parts list, together with the corresponding figure number.

Due to the Company's policy of constant improvement, the details as shown in this parts list may be subject to occasional variation. Therefore, it is important when ordering spare and replacement parts, that the following information is given:

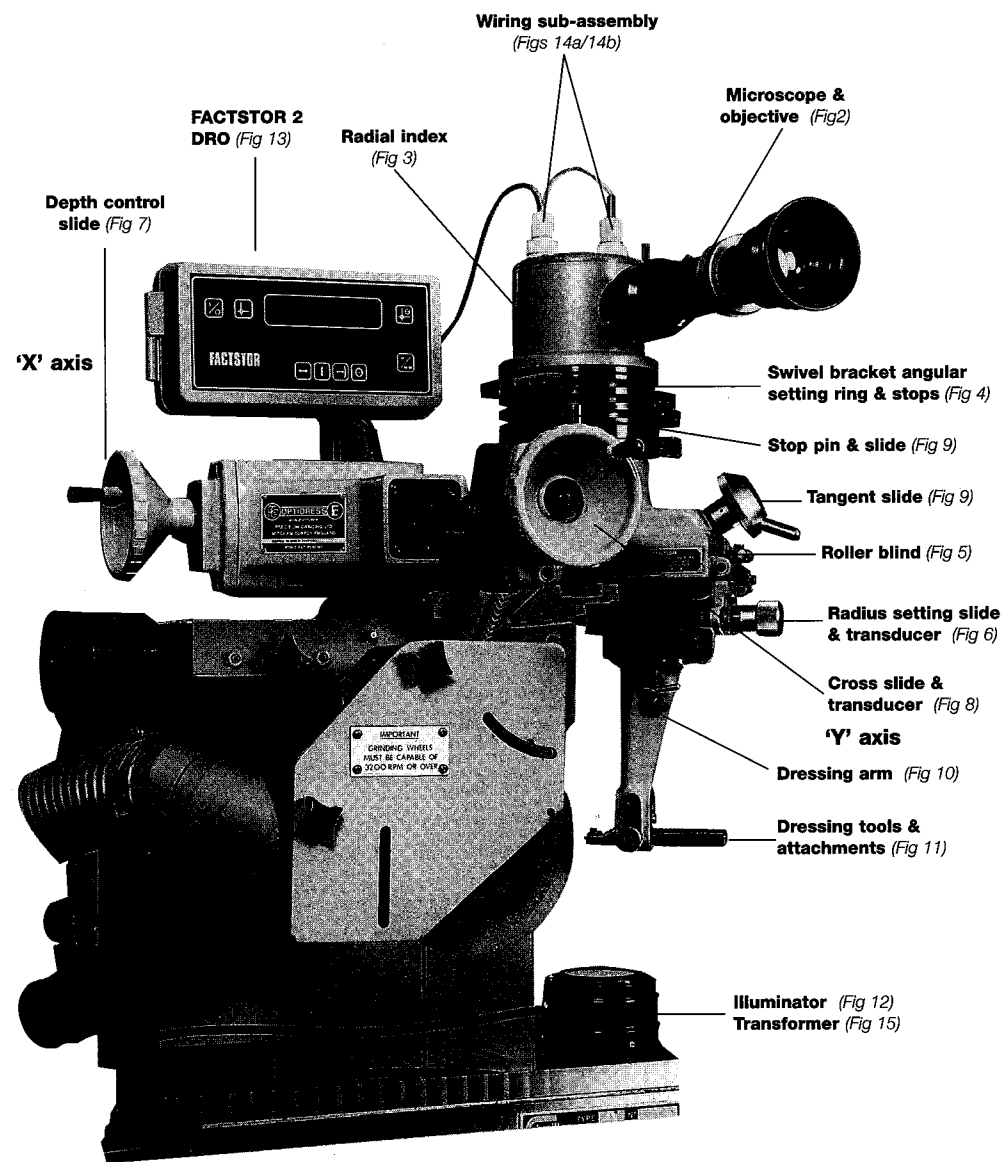
- 1 Optidress E serial number
- 2 Description of part
- 3 Part number

Separate details of the many types of adaptor brackets to suit individual machines are available upon request.

Index

	Figure	Page
Optidress E assembled	1	2
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Stop pin and slide	9	6
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Dressing tools and attachments	11	7
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Optidress E assembled

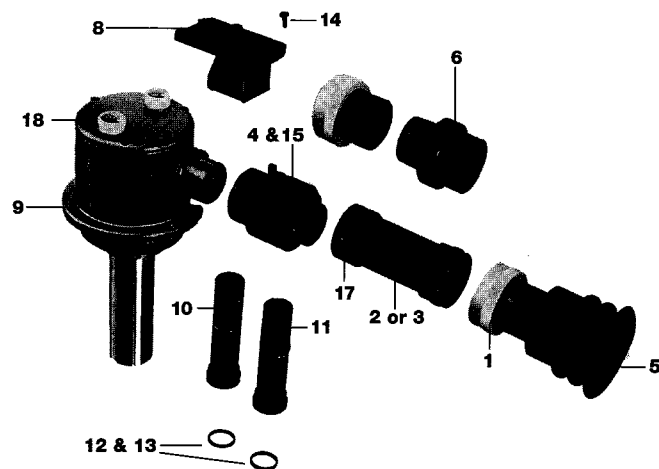


PVC instrument cover 675-0047C

Microscopes and Objectives

Figure 2

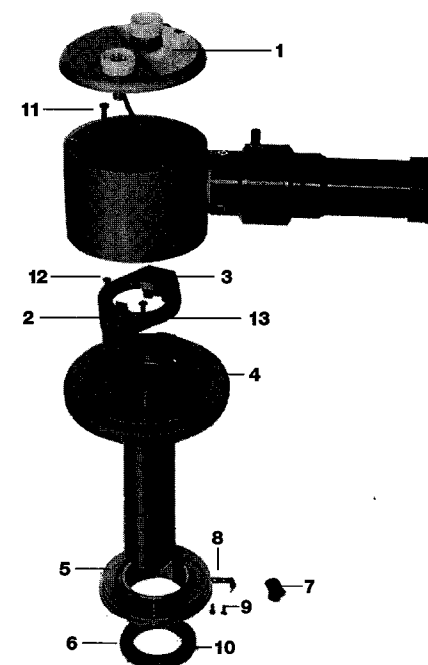
	Part Number	Qty
*1 Eyepiece complete (Metric or English)	711-SA18E or M	1
2 Optic tube	711-0251	1
3 Optic tube, extended	711-0251E	Not available
4 Reticule offset adj. complete	711-SA119	1
5 Eyepiece shield	711-0048	1
6 Field lens assy with eye shield	711-SA120	1
7 Reticule mount cmpt. (Metric or English)	711-SA121 Eor M	1
8 Prism assembly	711-SA122	1
9 Microscope body	711-0270	1
10 Objective 10x (standard)	711-SA123 Std.	1
11 Objective 10x (extended)	711-SA123 Ext.	1
12 Cover glass	G153	1
13 Cover glass locking ring	663-0123	1
14 Socket cap screw	X13-M4x10	3
15 Taptite cisk screw	X98-M4x10	3
16 Countersunk screw	X28-M2x5	1
17 Cone point set screw	X20-M3x5	1
18 Cheese head screw	X26-M4x10	3
7* 711-SA118E or M consists of: 711-SA120 Field Lens assy. with Shield 711-SA121E Grat and Mount		



Radial Index

Figure 3

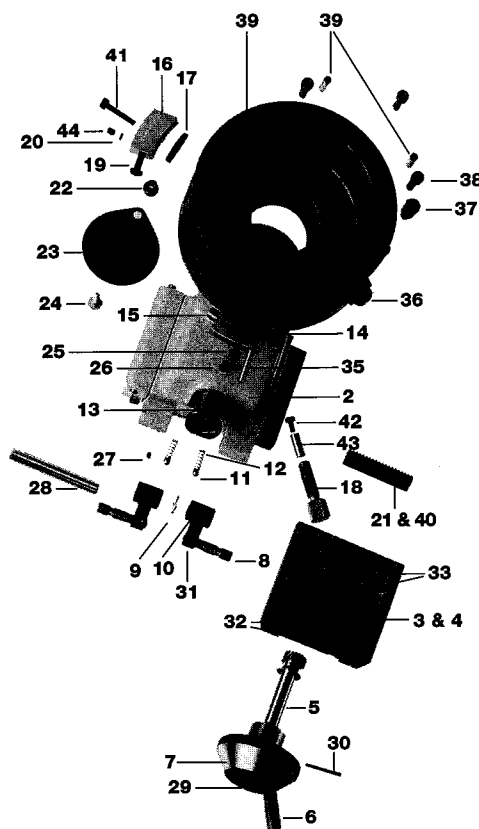
	Part Number	Qty
*1 Microscopic cover sub-assembly	711-SC65	1
2 PCB complete (not supplied on its own)		1
3 Radial index mount complete	711-SA125	1
+4 Microscope tube & base flange cplt.	711-0207B supply	1
Base	711-0271B oversize tubes	
5 Radial grating & mount complete	711-SA126	1
6 Retaining collar	711-0208	1
7 Dog (Annulus Mount)	711-0431B	1
8 Drive spring	711-0268	1
9 Pan head screw	X92-M2,5x6	2
10 Cone point set screw	X15-M3x12	3
11 Cheese head screw	X26-M4x50	4
12 Pan head screw	X92-M3x12	3
13 Pan head screw	X92-M1,6x5	2
14 Instrument head screw	X29-M1,6x5	2
15 Coiled pin	X19 Dia. 3 x 14	2
* See figures 14a and 14b – pages ?? and ??	(711-0207 x 5 + 711-0271B) less item 4 711-207 x 10 Assy.	
+ Oversize microscope tube and base flange	(711-0207 x 10 + 711-0271B) 711-207 x 10 Assy.	



Swivel Bracket, Angular Setting Ring & Stops

Figure 4

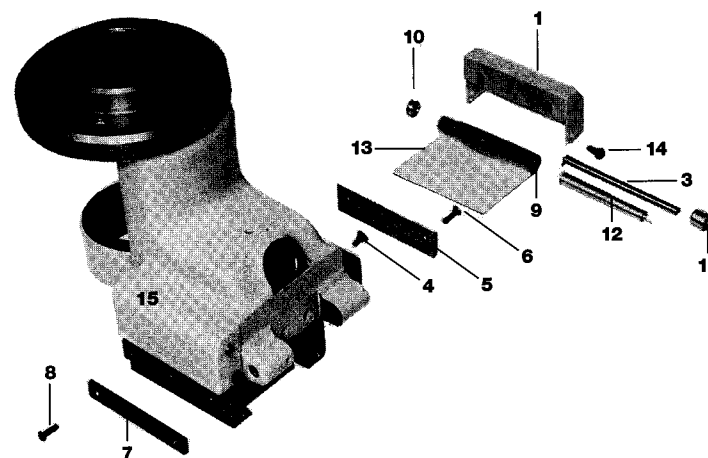
		Part Number	Qty
1	Angular setting ring	711-0008A	1
2	Swivel bracket	711-0004	1
3	Gib int. slide	691-0015	1
4	Intermediate slide	711-0034A	1
5	Pinion	663-0030C	1
6	Handle	663-0028D	1
7	Handle base	663-0028C	1
8	Stop adjusting screw	663-0035A	2
9	Spacer	663-0075	1
10	Stop	663-0010M	2
11	Ball	X86 Dia.187	2
12	Compression spring	663-0046	2
13	Bearing	663-0029C	1
14	Fixed stop	711-0222-Assy.	1
15	Fixed stop anvil	(711-0223)	1
16	Adjustable angular stop	711-0032	6
17	Stop nut	711-0031	6
18	Angular setting lock screw	663-0071A	1
19	Adjustable stop	663-0026A	6
20	Pad (pressure)	711-0049	6
21	Rack	691-0011	1
22	Collar	711-0046	1
23	Objective cover	711-0045	1
24	Objective cover screw	711-0047	1
25	Socket cap screw	X13-M4x20	1
26	Cone point set screw	X15-M5x10	1
27	Cup point set screw	X16-M3x3	1
28	Dowel	X37-Dia 250x2.5	1
29	Cup point set screw	X16-2BAx3/16	1
30	Taper pin	X41- Dia 3/32x7/8	1
31	Socket cap screw	X13-2BAx3/8	2
32	Cup point set screw	X16-4BAx3/8	2
33	Cup point set screw	X16-M4x8	2
34	Socket cap screw	X13-2BAx3/8	3
35	Dowel	X37-Dia 4x20	1
36	Instrument head screw for cover and cable support	X29-M3x14	2
37	Dog (swivel brkt)	711-0432	1
38	Socket cap screw	X13-M5x6	3
39	Dowel	X37-Dia 6x16	2
40	Socket cap screw	X13-M2, 5x6	2
41	Socket cap screw	X13-M4x20	6
42	Locking pad	663-0073	1
43	Locking rod	711-0038	1
44	Cup point set screw	X16-M6x6	6
45	Label	663-0082	1



Roller Blind

Figure 5

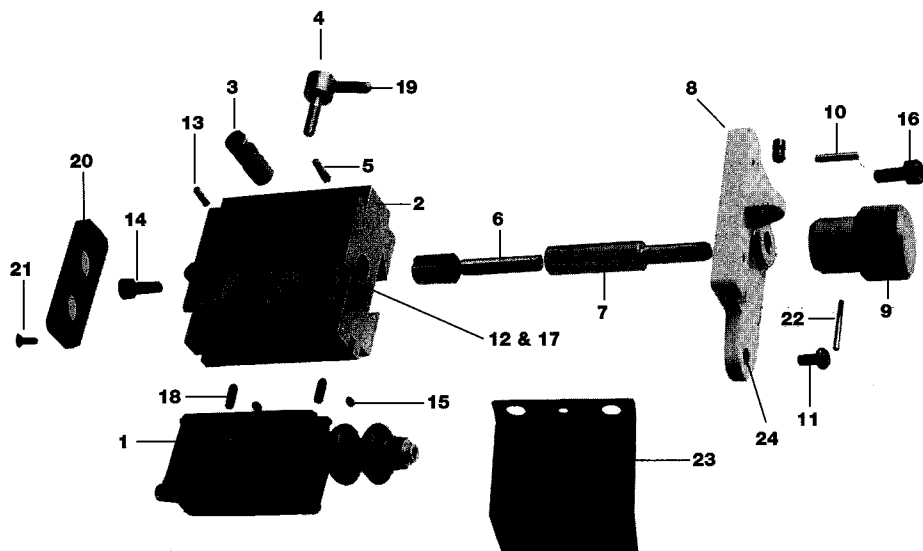
	Part Number	Qty	
1	Roller blind cover	663-0059A	2
2	Flat point set screw	X24-8BAx1/8	2
3	Roller pin	663-0061	2
4	Shoulder pin	711-0094	4
5	Limit stop	663-0063C	2
6	Countersunk head screw	X28-M3x10	4
7	Blind retaining plate	663-0064C	2
8	Pan head screw	X92-M2,5x6	6
9	Roller	663-65	2
10	Roller brush	663-66	2
11	Roller shoulder bush	663-67	2
12	Roller spring RH (shown)	663-68A)	1
	Roller spring LH	663-68B)	1
	Part number for this assembly is Supplied as an assembly only	711-SA112 LH & RH	1
13	Blind *	663-0069	2
14	Cheese head screw	X26-M3,5x8	4
15	Roller blind assembly (LH shown) complete with diecast cover	711-SA113 Com.	Pair
*	Roller & Blind LH & RH	Inst. Spares – 002	Pair



Radius Setting Slide and Transducer

Figure 6

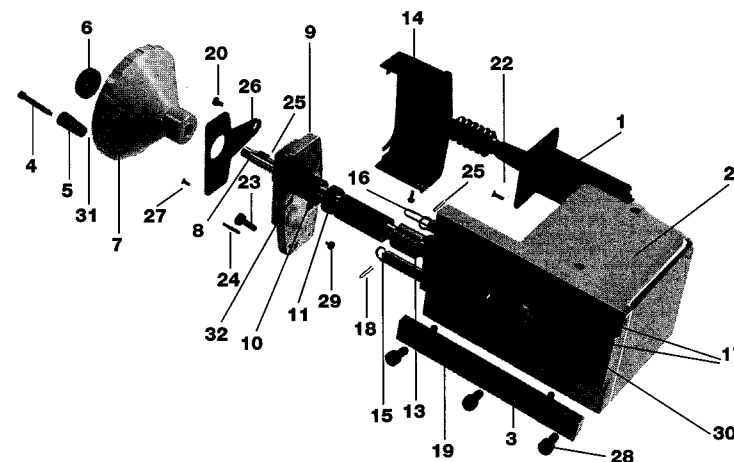
Part Number	Qty
1 Transducer complete (See fig. 14b for Assy)	1
2 Radius setting slide	1
3 Clamp (Rad setting slide)	1
4 Clamp screw	1
5 Stop pin	1
6 Feed screw (Rad setting slide)	1
7 Feed nut	1
8 Feed screw and push-rod support (711-100-93A)	1
9 Feed screw knob	1
10 Pin	2
11 Pan head screw	1
12 Gib	1
13 Dowel	1
14 Socket cap screw	1
15 Cone point set screw	2
16 Socket cap screw	2
17 Socket cap screw	3
18 Cup point set screw	2
19 Handle	1
20 Stop plate	1
21 Countersunk screw	2
22 Coil pin	1
23 Transducer cover	1
24 Rod locator dog	1
25 Shim	1



Depth Control Slide and Transducer

Figure 7

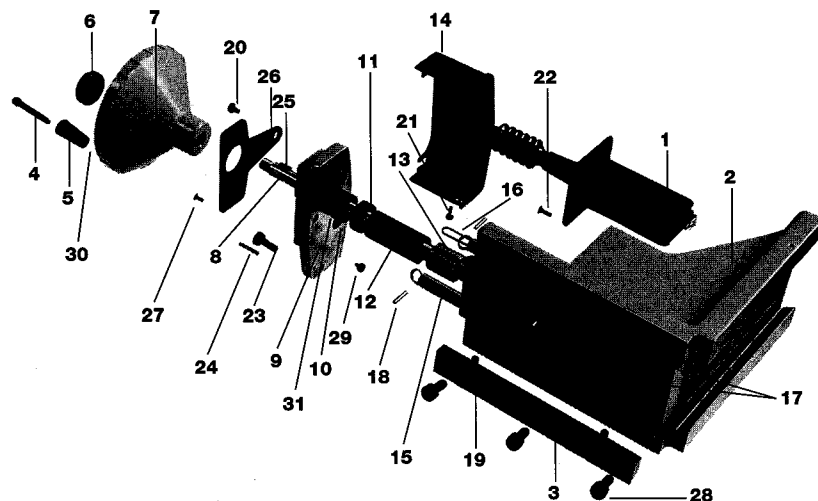
Part Number	Qty
1 Transducer complete was - SA54	1
2 Column	1
3 Gib	1
4 Handle screw	1
5 Handle	1
6 Nut (Feed)	1
7 Feed handle	1
8 Feed screw	1
9 Feed screw end plate	1
10 Lock nut	2
11 Sleeve nut	1
12 Sleeve	1
13 Feed nut (Handle)	1
14 Dust cover	1
15 Spring (Extension)	2
16 Stop wire loop	1
17 Spring pin	2
18 Dowel	2
19 Cup point set screw	2
20 Pan head screw	1
21 Pan head screw	2
22 Instrument head screw	4
23 Socket cap screw	3
24 Pin	2
25 Woodruff key	1
26 Push-rod end plate	1
27 Instrument head screw	3
28 Socket cap screw	3
29 Shoulder screw	2
30 Cheese head screw	1
31 Nut	1
32 Coated washer	1



Cross Slide and Transducer

Figure 8

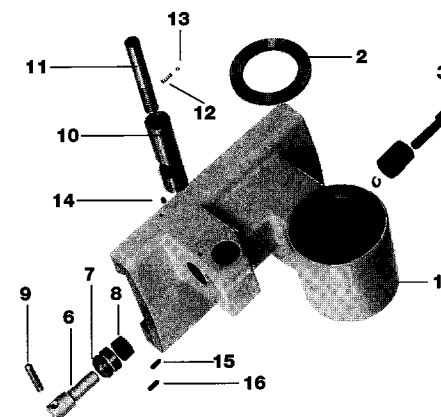
	Part Number	Qty
1	Transducer complete was - SA54	1
2	Slide bracket	1
3	Gib	1
4	Handle screw	1
5	Handle	1
6	Nut (Feed)	1
7	Feed handle	1
8	Feed screw	1
9	Feed screw end plate	1
10	Lock nut	2
11	Sleeve nut	1
12	Sleeve	1
13	Feed nut (Handle)	1
14	Dust cover	1
15	Spring (Extension)	2
16	Stop wire loop	1
17	Spring pin	2
18	Dowel	2
19	Cup point set screw	2
20	Pan head screw	1
21	Pan head screw	2
22	Instrument head screw	4
23	Socket cap screw	3
24	Pin	2
25	Woodruff key	1
26	Push-rod end plate	1
27	Instrument head screw	3
28	Socket cap screw	3
29	Shoulder screw	2
30	Nut	1
31	Coated washer	1



Stop Pin and Slide

Figure 9

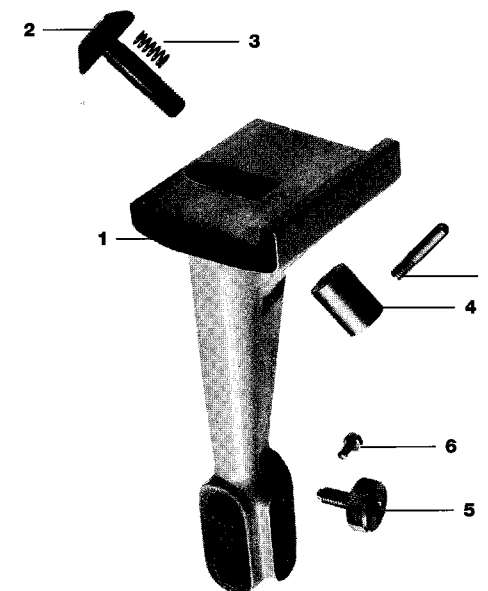
	Part Number	Qty
1	Front slide	1
2	Spacing washer	1
3	Microscope clamp screw	1
4	Microscope clamp	1
5	Hex lock nut m6	2
6	Pinion shaft	1
7	Pinion shaft bush	1
8	Pinion	1
9	Handle	1
10	Stop pin sleeve	1
11	Stop pin rack	1
12	Spring	1
13	Steel ball	1
14	Cone point set screw	1
15	Cup point set screw	1
16	Cone point set screw	1

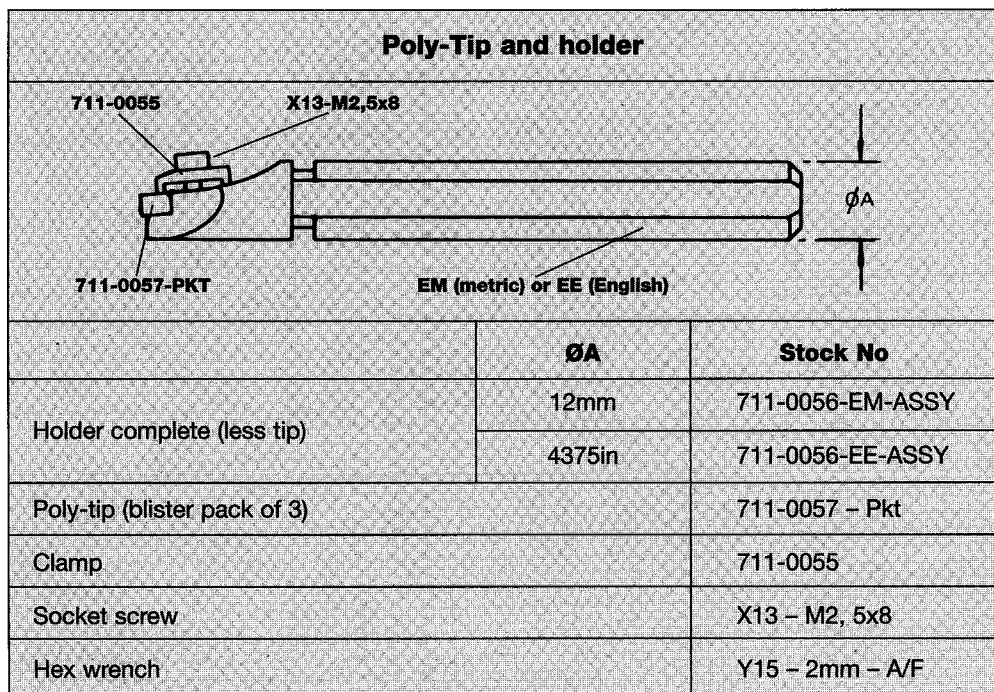


Dressing Arm

Figure 10

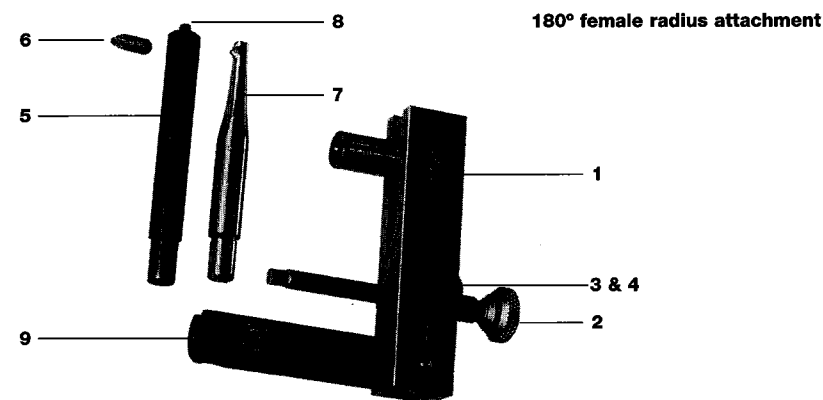
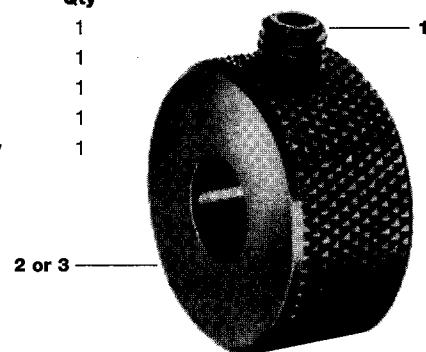
	Part No.	Qty
1	Dressing arm (Metric)	1
	(English)	1
2	Clamp (for dressing arm)	1
3	Clamp spring	1
4	Clamp nut	1
5	Dressing tool clamp screw	1
6	Anvil	2
7	Handle	1
8	Dressing arm assy.	1
9	English or Metric	1





Dressing Tool Setting Ring

		Part Number	Qty
1	Cup point set screw	X16-M6x8	1
2	Setting ring (Metric bore)	711-0035M	1
3	Setting ring (English bore)	711-0035	1
4	Assembly (English)	711-0035 Assy	1
5	Assembly (Metric)	711-0035M Assy	1



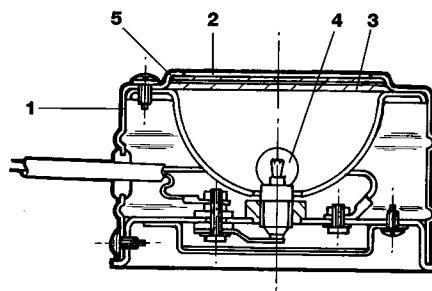
		Part Number	Qty
1	Body Spigot	711-0039) 711-0040)	Together
	Body and spigot assembly (Metric)	711-AT01M	1
	(English)	711-AT01E	1
2	Screw steady and insert complete	691-0048A & 663-0409	1
3	Bias screw	663-0410	1
4	Bias screw pad	663-0411	1
5	Dressing tool post	663-0270	1
6	Chisel point diamond	663-0271	1
7	Rat-tail diamonds	663-0256B	1
		663-0256C	1
		663-0256D	1
8	Cup point screw	X16-4BAx3/16	1
9	Socket head cap screw	X13-2BAx1/2	1

Rat Tail Diamonds	R	
	0.87mm 0.034in	663-0256B
	1.98mm 0.078in	663-0256C
	2.95mm 0.117in	663-0256D
	6.35mm 0.25in	663-0271

Illuminator

Figure 12

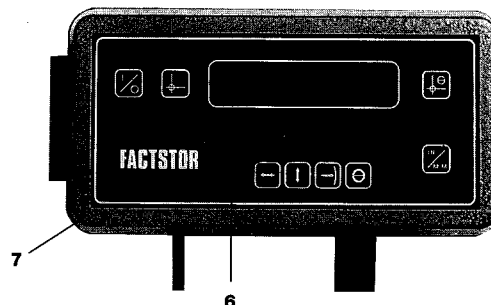
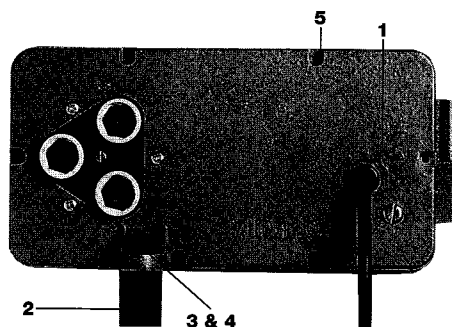
	Part Number	Qty
1 Illuminator complete	711-SA128CHEM	1
2 Ground glass	G113	2
3 Filter glass	G114	1
4 Bulb 6V3W MES 11mm	663-L10	
5 Paper gasket	663-L09	1



Factstor 2 Digital Read-out

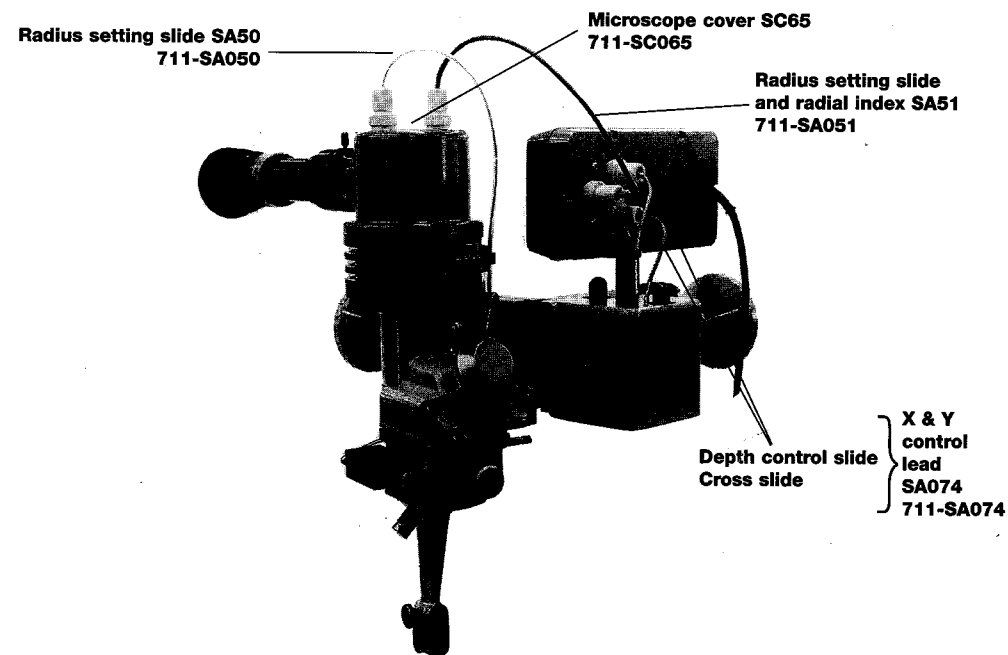
Figure 13

	Part Number	Qty
1 DRO unit complete (2 micron unit)	711-SA135	1
2 Space pillar (32 mm LG)	711-0296	1
3 Socket cap screw	X13-M8x50	1
4 Washer	X34-Dia .312	1
5 Cap head screw	X13-M3x25	7
6 Touch sensitive panel (membrane switch)	711-0580	1
7 DRO case front	711-0578	1
8 Factstor 2 PCB	711-SA136	1
9 Ribbon lead assembly	711-SA133	1
10 Bracket to extend DRO	711-0454	1



Wiring Sub-assembly

Figure 14



Transformer

Figure 15

	Part Number	Qty
1 Transformer 110V	711-SA130V110	1
or		
Transformer 240V	711-SA130V240	1
or		
Transformer 240V Switch	711-SA130V240A	1
2 Illuminator connector	663-L13	1
3 DRO connector (Twist lock midget cap)	711-0422	1

