



INSTRUCTION SHEET MODEL G1760 DIVIDING PLATES

The Model G1760 Dividing Plates are designed for the Model G1049 6" Rotary Table. Dividing plates can be installed onto the G1049 6" Rotary Table to achieve a higher precision of hole placement, spot facing and gear making.

Piece Inventory

1. 3 Dividing Plates
2. Crank Handle & Index Pin
3. 2 Piece Sector Arm Assembly w/Set Screw
4. Sector Spring
5. Allen Wrench

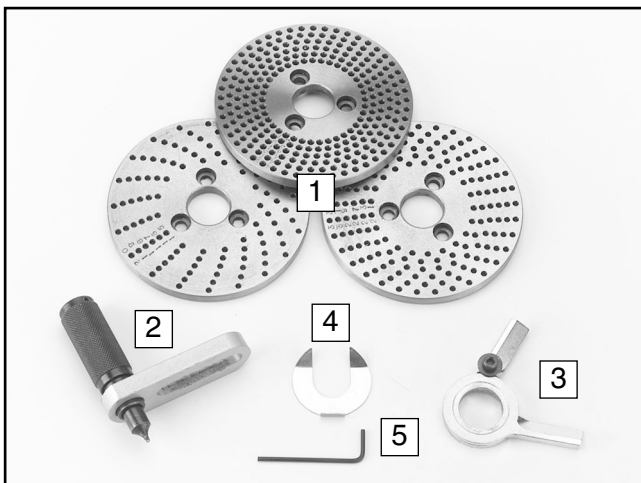


Figure 1. Dividing plate inventory

To install the Model G1760 Dividing Plate:

1. Remove the crank handle cap screw shown in **Figure 2**.
2. Gently tap the crank handle off the shaft with a rubber mallet and tape the key to the handwheel for safe keeping.

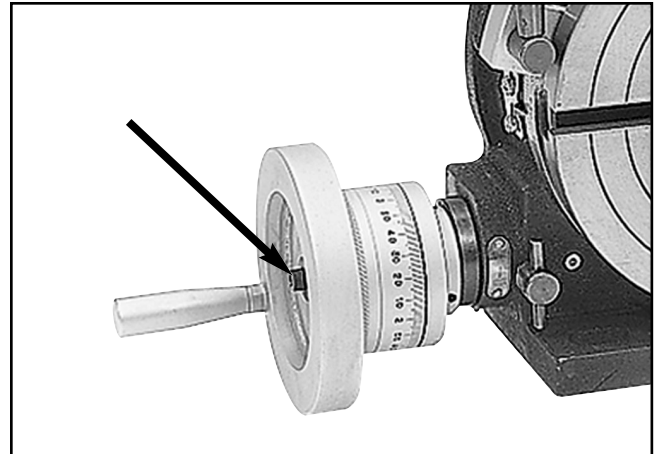


Figure 2. Crank handle cap screw.

3. Insert the dividing plate with the counter bores facing out and secure it with the provided screw.
4. Place the sector arm assembly over the shaft, then slide the sector spring into the slot on the shaft to secure the assembly.
5. Install the crank handle with the indexing pin and secure it with the cap screw.

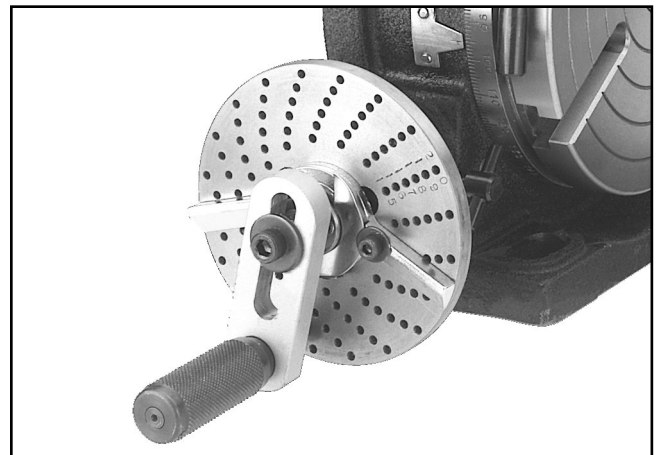


Figure 3. Completed assembly with dividing plate installed.

The Model G1760 has three plates with the following hole circles:

Plate A: 15, 16, 17, 18, 19, 20.

Plate B: 21, 23, 27, 29, 31, 33.

Plate C: 37, 39, 41, 43, 47, 49.

Basic Example:

You are making a bolt pattern that has a 13 hole bolt pattern.

$$\text{Crank turns} = \frac{90}{N}$$

N = the desired division number (13).

$$\frac{90}{13} = 6 \frac{12}{13}$$

1. Look up **13** in the spacing column on the index table to find the correct hole divisions.

Turns: 6

Holes: 36

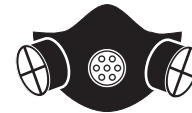
Hole Circle: 39

2. Install the "C" dividing plate onto the rotary table as described earlier, set the crank handle and the indexing pin to index the 39 hole circle.
3. Turn the handwheel before making the first hole to take up any play in the worm gears. It is important to always turn the handle the same way.
4. Set the sector arms so there are 36 holes plus the hole the indexing pin is located in, then tighten the screw.
5. Make your first hole, then turn the crank 6 full turns and move 36 holes on the 39 hole index plate to rotate exactly $\frac{12}{13}$ of a turn. The $6\frac{12}{13}$ revolutions are equal to the sector arm adjustment that was done in **step 4**.
6. Rotate the sector arm so that the arm locates on the pin once again, then crank the handle until the pin will drop into the last hole between the sector arms.
7. Repeat **step 6** for the remaining holes.

For your safety it is important! Please follow the warnings below:

⚠ WARNING

Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a respirator and hearing protection while using this equipment. Make sure proper filter is worn while wearing respirator.



⚠ WARNING



Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from moving machinery.

NOTICE

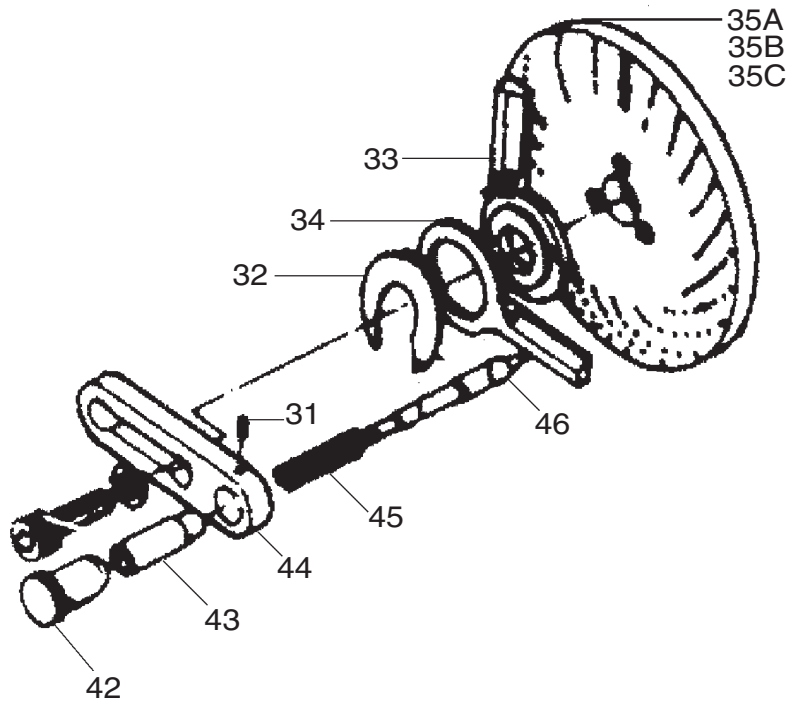
The previous section was designed to give instructions on the basic operations of this equipment. However, it is in no way comprehensive of all of the equipment applications. **WE STRONGLY RECOMMEND** that you read books, trade magazines, or get formal training to maximize the potential of your equipment.



Spacing	Turns	Holes	Hole Circles
4	22	8	16
4	22	9	18
4	22	10	20
7	12	18	21
7	12	42	49
8	11	4	16
8	11	5	20
11	8	6	33
12	7	8	16
13	6	36	39
14	6	9	21
14	6	21	49
16	5	10	16
17	5	5	17
19	4	14	19
20	4	8	16
21	4	6	21
21	4	14	49
22	4	3	33
23	3	21	23
24	3	12	16
24	3	15	20
25	3	9	15
25	3	12	20
26	3	18	39
27	3	5	15
27	3	6	18
27	3	7	21
27	3	9	27
27	3	11	33
27	3	13	39
29	3	3	29
31	2	28	31
32	2	13	16
33	2	24	33
34	2	11	17
35	2	12	21
35	2	28	49
36	2	8	16
37	2	16	37
38	2	7	19
39	2	12	39
40	2	4	16
41	2	8	41
42	2	3	21
42	2	7	49
43	2	4	43
46	1	22	23
47	1	43	47
48	1	14	16
49	1	41	49
50	1	12	15
50	1	16	20
51	1	13	17
54	1	10	15
54	1	12	18
54	1	14	21
54	1	18	27
54	1	22	33
54	1	26	39
55	1	21	33
57	1	11	19
58	1	16	29
60	1	8	16

Spacing	Turns	Holes	Hole Circles
62	1	14	31
63	1	9	21
65	1	15	39
66	1	12	33
69	1	7	23
70	1	6	21
72	1	4	16
74	1	8	37
75	1	3	15
75	1	4	20
78	1	6	39
80	1	2	16
81	1	2	18
81	1	3	27
82	1	4	41
85	1	1	17
86	1	2	43
87	1	1	29
93	0	30	31
94	0	45	47
95	0	18	19
96	0	15	16
98	0	45	49
99	0	30	33
100	0	18	20
102	0	15	17
105	0	18	21
108	0	15	18
110	0	27	33
111	0	30	37
114	0	15	19
115	0	18	23
117	0	30	39
120	0	12	16
123	0	30	41
126	0	15	21
126	0	35	49
129	0	30	43
130	0	27	39
135	0	10	15
138	0	15	23
141	0	30	47
144	0	10	16
145	0	18	29
147	0	30	49
150	0	9	15
153	0	10	17
155	0	18	31
160	0	9	16
162	0	10	18
162	0	15	27
165	0	18	33
170	0	9	17
171	0	10	19
174	0	15	29
180	0	8	16
185	0	18	37
186	0	15	31
189	0	10	21
190	0	9	19
195	0	18	39
198	0	15	33
200	0	9	20

G1760 Dividing Plate Parts



REF	PART #	DESCRIPTION
31	PSS02M	SET SCREW M6-1.0 X 6
32	P1760032	SECTOR SPRING
33	P1760033	SECTOR ARM
34	P1760034	SECTOR ARM
35A	P1760035-A	INDEX PLATE A 15-20 HOLE
35B	P1760035-B	INDEX PLATE B 21-33 HOLE
35C	P1760035-C	INDEX PLATE C 37-49 HOLE
42	P1760042	HANDLE
43	P1760043	SLEEVE
44	P1760044	CRANK
45	P1760045	SPRING
46	P1760046	LOCK INDEX PIN