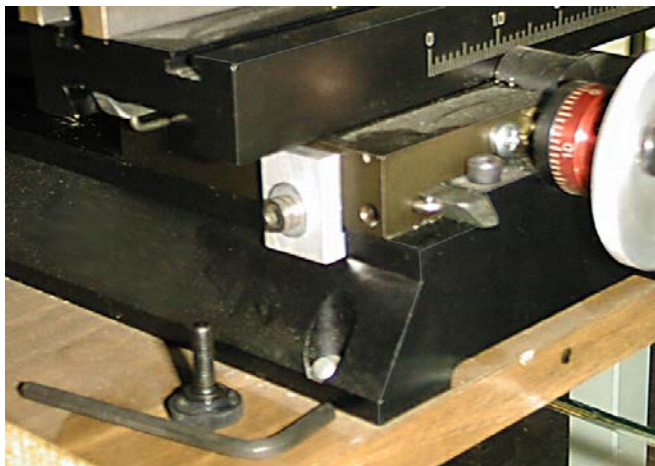
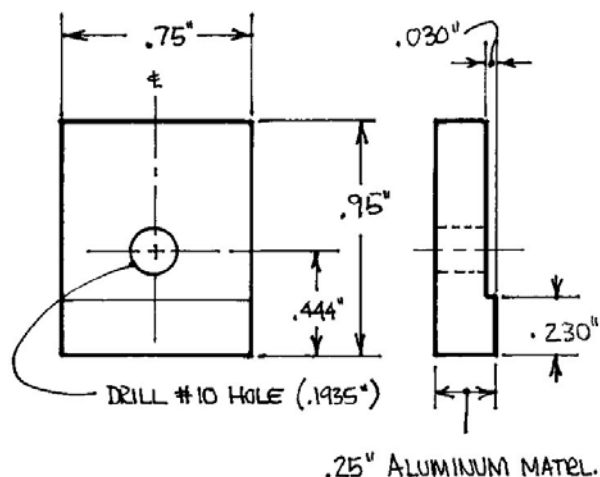


## TIP 28 — Making a More Positive Y-Axis Lock for the Mill/Larry Mortimer



The new y-axis lock installed in place of the thumbscrew.  
 (Click on photo for larger image.)

Larry Mortimer was not satisfied with the way the thumbscrew on the left side of the mill saddle locked the y-axis. When tightened, it pushes a tapered nylon plug against the gib, pulling the opposite side of the saddle tighter into the dovetail. To lock this axis more positively, he made a simple metal tab that uses the same hole in the mill saddle, but instead exerts pressure on the mill base to pull the saddle against the dovetail with more pressure. The drawing below gives all the size information you will need to make the part. It is attached to the mill saddle using a 1/2" or 5/8" long 10-32 socket head screw. A washer under the head of the screw is also recommended to spread out the pressure. Material used in the test example was .25" thick aluminum and it worked fine.



REPLACE P/N 40760 THUMB SCREW W/ 10-32 x 5/8 SHCS