



**SHERLINE
PRODUCTS**
INCORPORATED 1974

MASSO Optical Encoder Gap Correction

P/N 87813

Change to the Optical Encoder Gap Gauge

Our original gap setting for the optical encoder was .080" (2.032 mm). We have found that this gap works and is sufficient for our mills because they are not looking for the index mark, which is used on our chucker lathes for single point threading.

For our chucker lathes, and for any of our customers who have mills that are experiencing erratic RPM changes, we suggest that you change your gap width to .129" (3.27 mm). We are making new gap setting gauges (P/N 87813) that are .129" thick. You can also use a set of feeler gauges set to .120 - .130 thick.

CAUTION: Make sure that the power is turned off before you adjust your encoder gap.

Instructions

Instructions for setting your encoder gap can be found at the following links:

Written Instructions

Sherline/MASSO CNC Controller Initial Start Instructions (page 10): https://sherline.com/wp-content/uploads/2019/07/sher-masso_cnc_initial_inst.pdf

Video Instructions

Setting up the Optical Encoder (about the 2:38 mark): <https://youtu.be/ynfJ38QLMoE>

Installing the Optical Encoder (about the 6:50 mark): <https://youtu.be/p3kM3MEO1-w>

Thank you,
Sherline Products Inc.

CAUTION

Do not connect or disconnect the optical encoder connector or the ground wire with the power on or you will do irreparable damage to the optical encoder!