



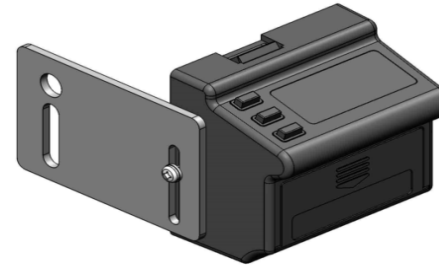
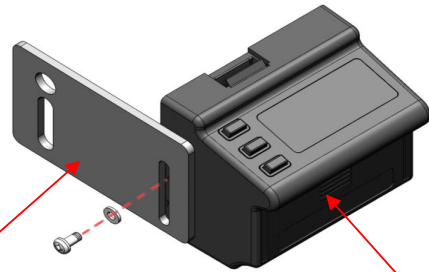
**A TRADITION  
OF INNOVATION**

**RETRO FIT INSTRUCTIONS FOR WIXEY DRO OLIVER  
MODEL 10014.201**

# Model 10014.201

Note: You may be able to use pieces that are already installed with the original DRO.

Step 1: Remove the screw from DRO, and fix the upper plate on the DRO as shown below.

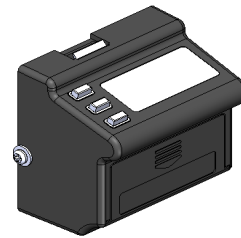


Wixey WR510S\*1pcs

174977-904 Upper positioning plate\*1pcs



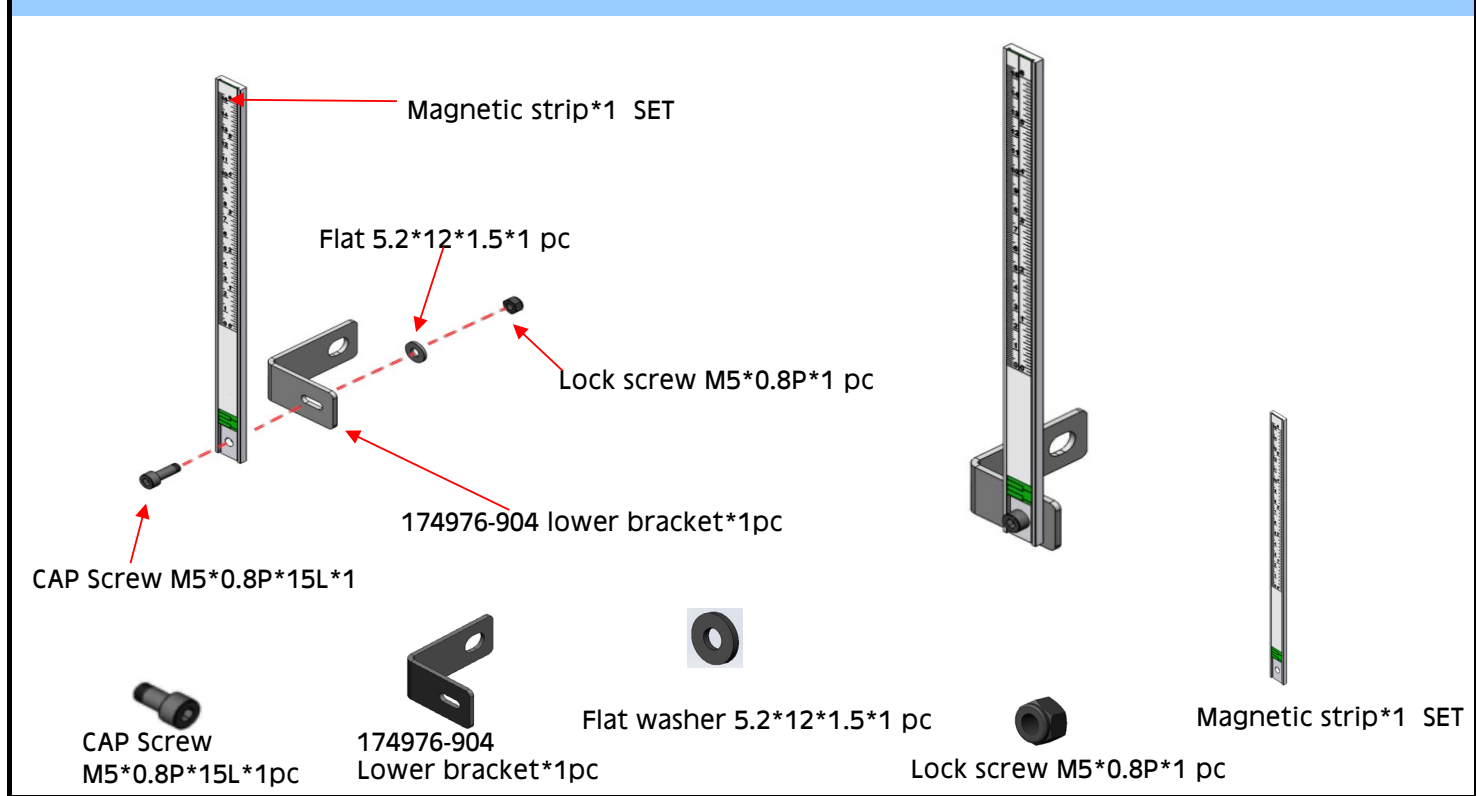
174977-904 upper positioning plate\*1pcs



Wixey WR510S\*1pcs

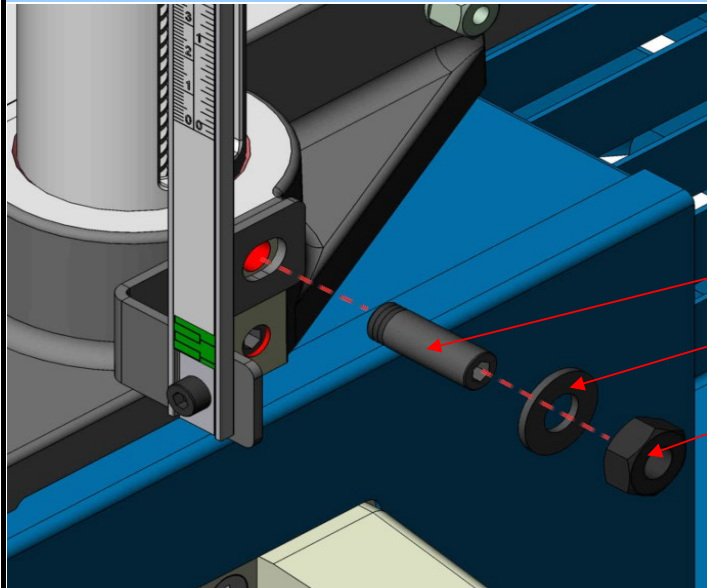
# Model 10014.201

Step 2: Use a 4mm hex wrench and attach the magnetic strip, lock screw, flat washer and CAP screw on the bracket in the order as below.



# Model 10014.201

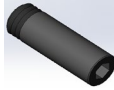
**Step 3: Use 5mm hex wrench to lock the assembly from step 2 on the machine as below.**



SET screw M10\*1.5P\*30L\*1pc

Flat washer 10.3\*22\*2.0t\*1 pc

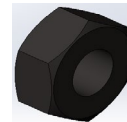
Hex nut M10\*1.5P(17B\*8H)\*1 pc



Set Screw  
M10\*1.5P\*30L\*1pc



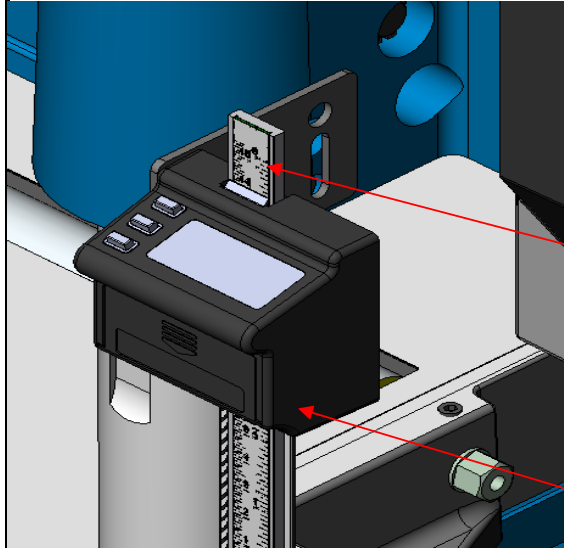
Flat washer 10.3\*22\*2.0t\*1 pc



Hex nut M10\*1.5P(17B\*8H)\*1 pc

# Model 10014.201

Step 4: Slide the DRO onto the magnetic strip

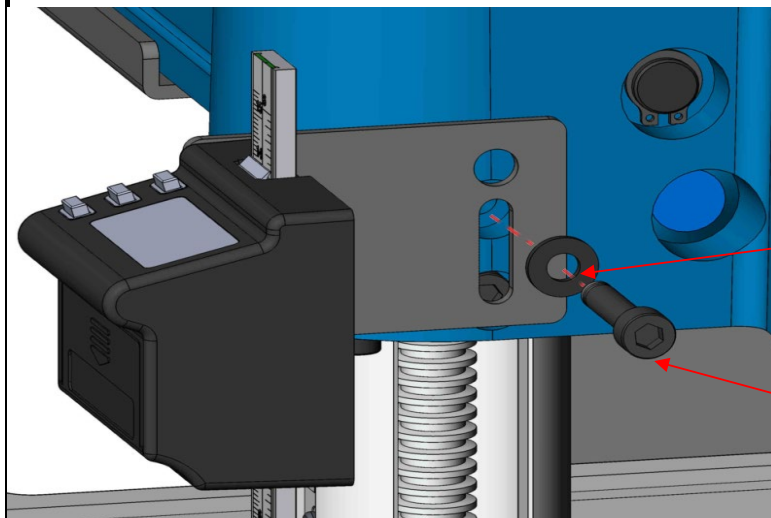


Magnetic strip assembly\*1 SET

DRO (Wixey WR510S)\*1pc

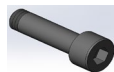
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Step 5: Use a 5mm hex wrench to fix the upper position plate on the machine



Flat washer 6.2\*13\*1.5t\*1 pc

CAP screw M6\*1.0P\*30\*1pc



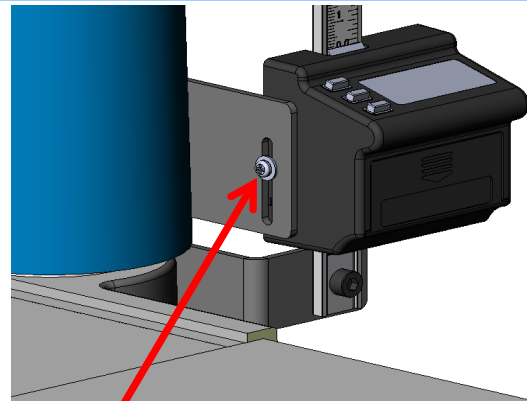
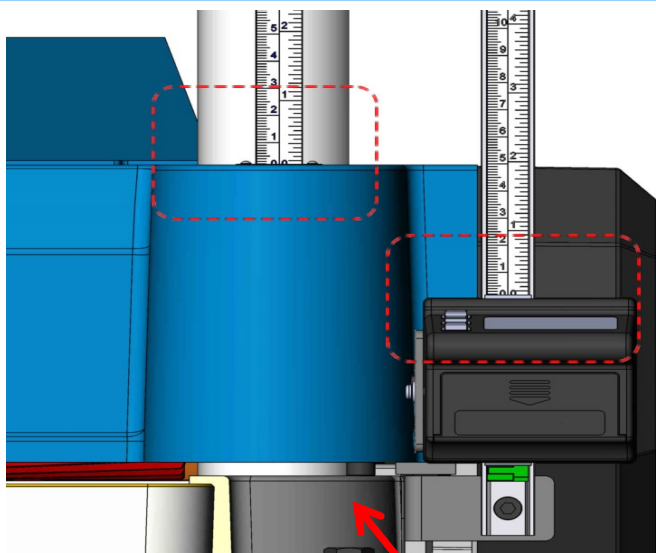
CAP screw M6\*1.0P\*30\*1pc



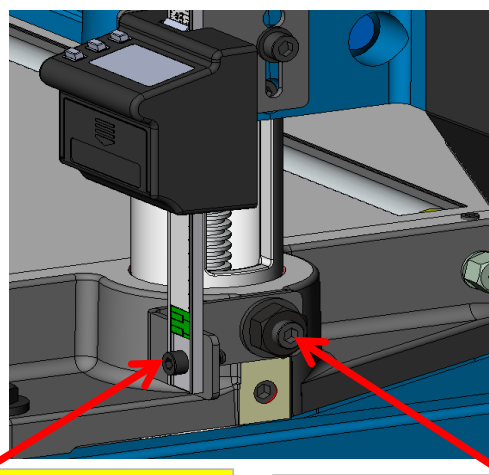
Flat washer 6.2\*13\*1.5t\*1 pc

# Model 10014.201

Step 6: lower the head down to its lowest point (6mm), and adjust the DRO to correspond with 6mm on the scale by adjusting the screw. When the DRO shows zero (As the scale), tighten the screw.



Adjusting DRO up/down



Adjusting magnetic strip

Adjust magnetic strip

To calibrate cutterhead arc to table, see instructions #CALWR510S.