

CONTROLS AND ADJUSTMENTS (cont.)

On re-assembly use the block of wood to roughly position the pulley (42) **before** fitting the key (33) to the spindle, ensure the key is at the top dead centre. Failure to do this may cause the key to pass straight through the pulley and drop out the other end.

Ensure that the inner race of the rear bearing (24) is located on the spindle as the spindle is pushed through the pulley, the dust cover (48) may come out of the headstock, if so do not re-fit dust cover (48) until all the adjustments have been carried out.

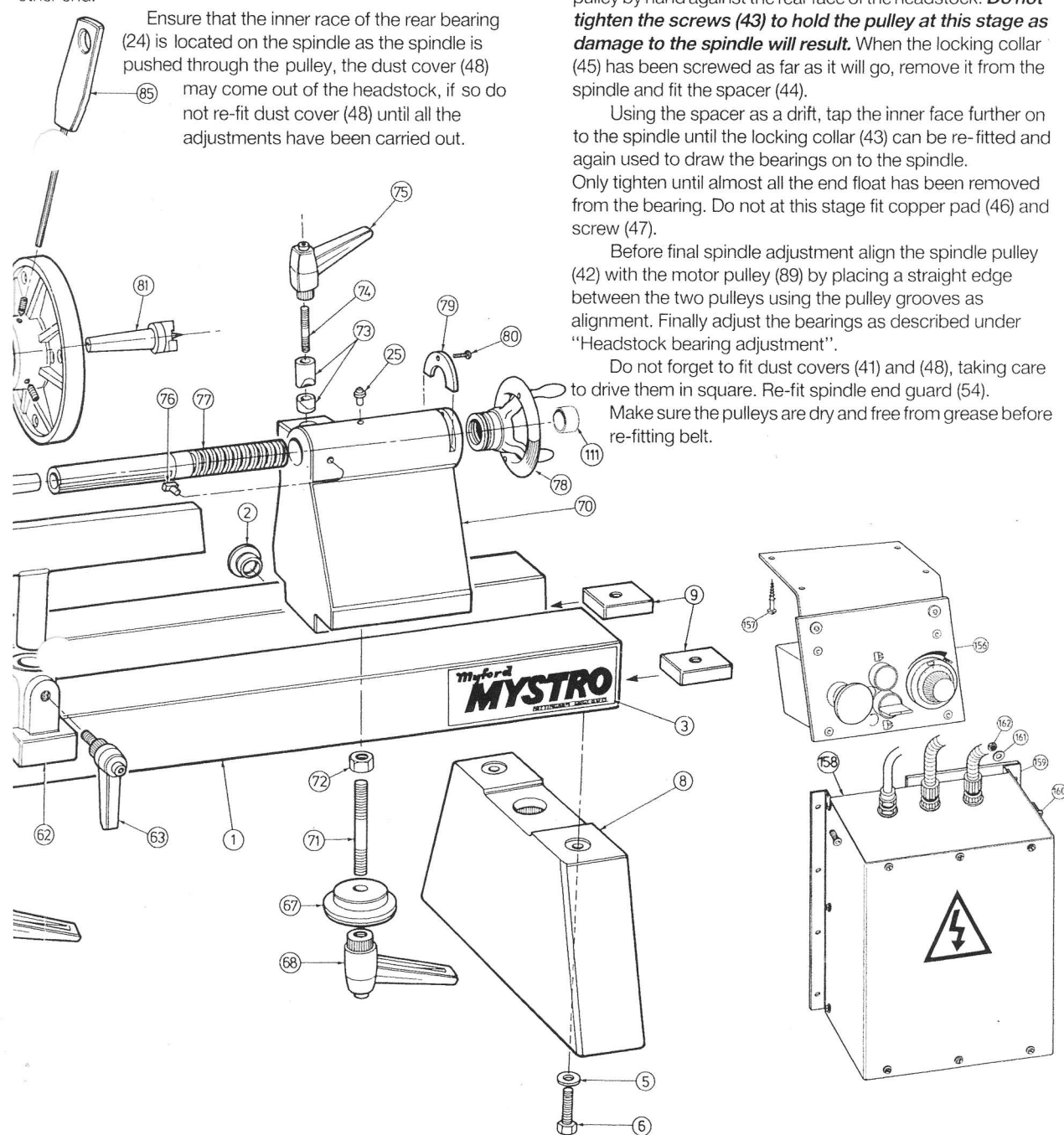
Do not initially fit the spacer (44) but use the locking collar (45) to draw the rear bearing on to the spindle, use the indexing plunger (57) to prevent spindle rotating, but as the pulley (42) is not yet secured to the spindle it will be necessary to hold the pulley by hand against the rear face of the headstock. **Do not tighten the screws (43) to hold the pulley at this stage as damage to the spindle will result.** When the locking collar (45) has been screwed as far as it will go, remove it from the spindle and fit the spacer (44).

Using the spacer as a drift, tap the inner face further on to the spindle until the locking collar (43) can be re-fitted and again used to draw the bearings on to the spindle. Only tighten until almost all the end float has been removed from the bearing. Do not at this stage fit copper pad (46) and screw (47).

Before final spindle adjustment align the spindle pulley (42) with the motor pulley (89) by placing a straight edge between the two pulleys using the pulley grooves as alignment. Finally adjust the bearings as described under "Headstock bearing adjustment".

Do not forget to fit dust covers (41) and (48), taking care to drive them in square. Re-fit spindle end guard (54).

Make sure the pulleys are dry and free from grease before re-fitting belt.



Ordering Replacement Parts

The following information should be supplied with the order:-

1. Type and Serial Number of the lathe. For location of numbers see page 2.
2. Quantity required.
3. Quote Part Number.

As it is the Company's policy to improve its products whenever opportunity occurs, designs are liable to modification at any time. In some cases, due to the nature of the part, it will be necessary for us to supply additional related parts, particularly if the item required has been altered.