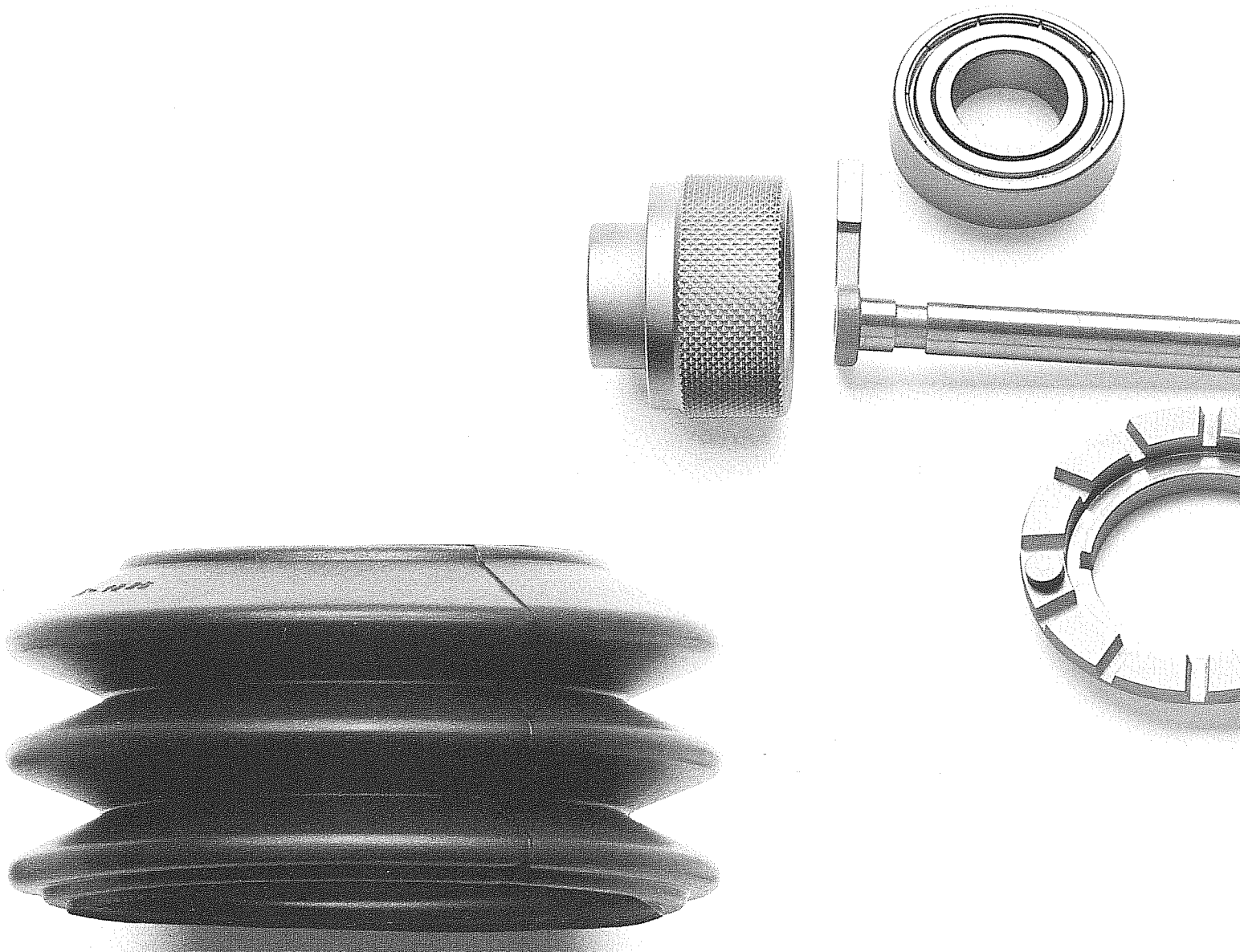


MICHAEL DECKEL

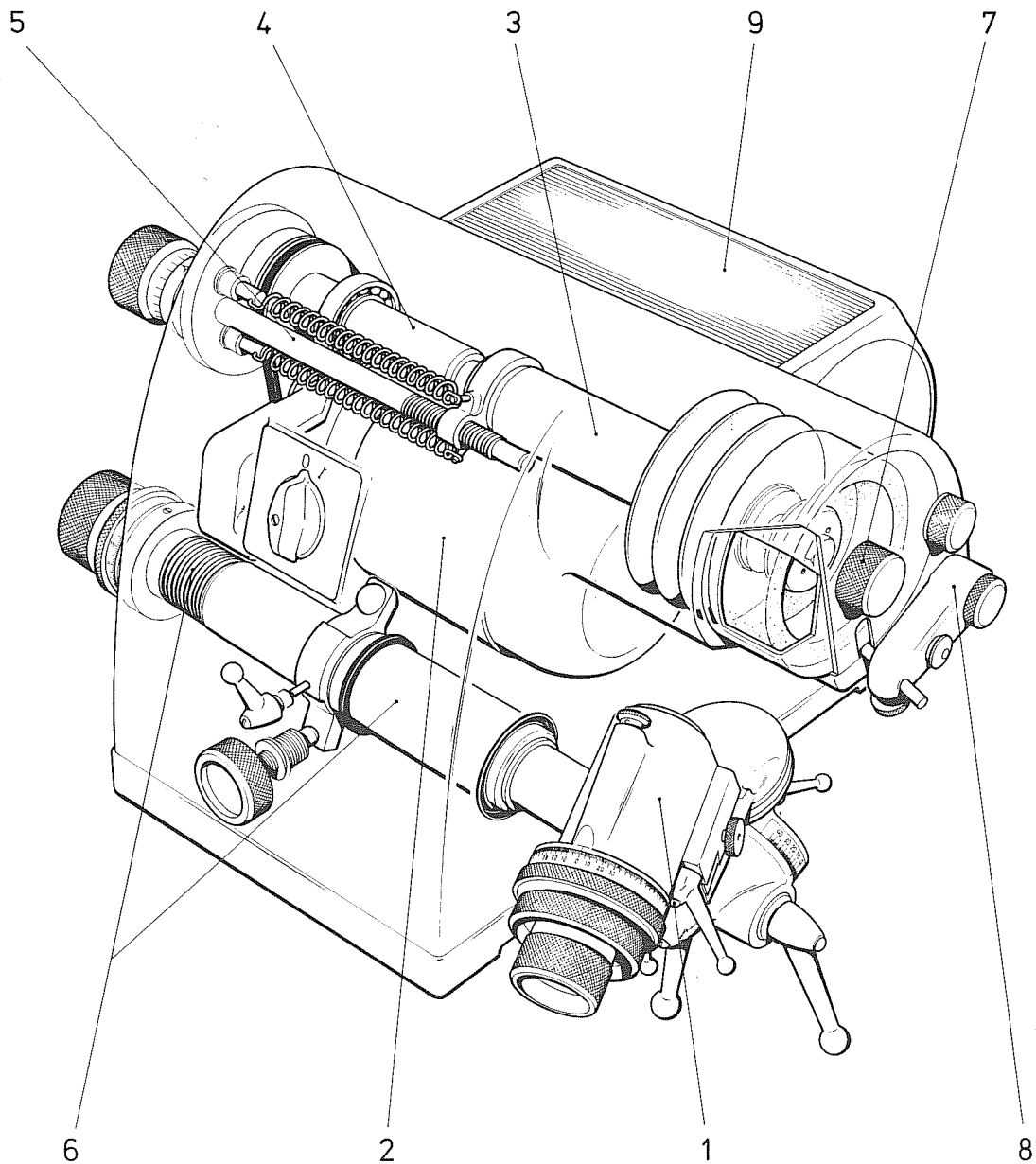
AMERICAN ROTARY TOOLS Co. (ARTCO)
250 West Duarte Road
Monrovia, California USA 91016-7464

Tel: +1 (626) 358-8466 Fax: +1 (626) 358-0076
Toll Free USA Tel: (800) 624-2212 Fax: (800) 624-2210
Email: info@artcotools.com

Spare Parts
Single Lip Cutter Grinder
SOE



SOE Identification of Main Assemblies



1 Index head bracket

2 Housing – drive motor

3 Grinding wheel spindle

4 Drive shaft

5 Feed screw

6 Main axle – fine adjustment mechanism

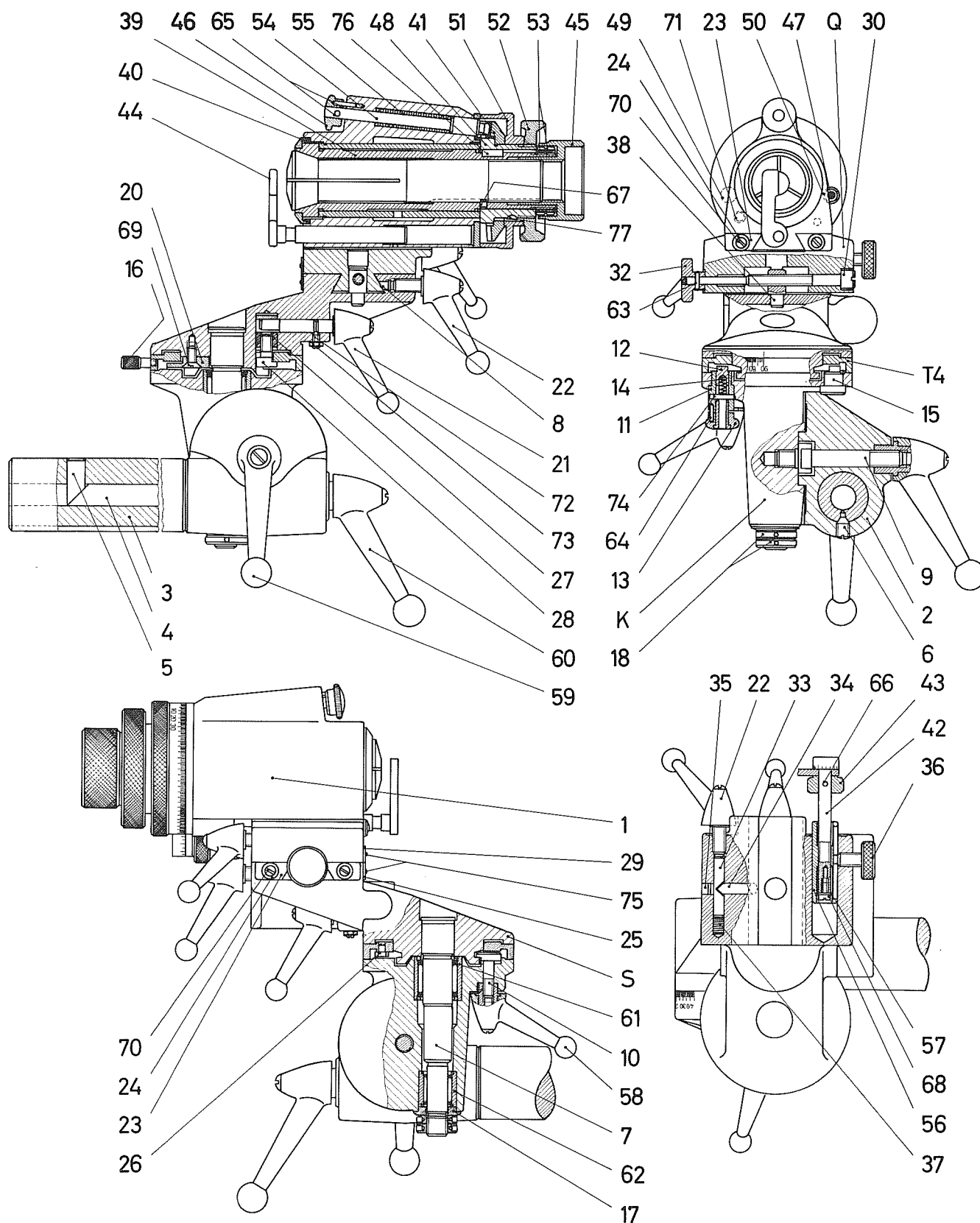
7 Wheel guard

8 Wheel dressing attachment

9 Dust exhaust unit

Index Head Bracket

SOE



Please quote serial number of machine when ordering spare parts.

SOE Index Head Bracket

Index head slide

Release clamp 22, screw out knurled screw 36 and take off index head slide.

Collet sleeve bearing

Screw off knurled nut 52, remove scale drum 51 and index plate 41. Screw off slotted nuts 53, pull off sleeve 48, pull out collet sleeve 39 in a forward direction. To reassemble the parts, reverse the above procedure, eliminating play of 39 by means of nuts 53.

Index pin

Knock out pin 65, pull off knurled knob 46, remove index pin 54 and compression spring 55. To reassemble the parts, reverse this procedure. When replacing index pin 54, drill hole for 65 through 46, watching that 54 engages index plate 41 and that 46 engages middle index hole.

Fine adjustment mechanism

Remove screw 68 and washer 57, screw off nut 56, knock out pin 66, force adjuster screw out of knurled ring 43. To reassemble the parts, reverse this procedure. When replacing 42, drill new hole for 66.

Cross slide

Knock out taper pin 63 and pull off knurled knob 32. Force off plug 31 by screwing out traversing screw 30. Do not knock out screw nut 38 unless it has to be replaced. Press in new screw nut 38 and tap thread M5 (metric, 5 mm dia) from cross slide Q. To reassemble the remaining parts, reverse the above procedure. When replacing 30, drill new hole for taper pin 63.

No.	Part Name	Stock No.	Remarks
	Index head bracket ass'y	1500100	green RAL 6011**
	Index head bracket ass'y	1500150*	green RAL 6011**
1	Index head slide ass'y	1506000	green RAL 6011**
1	Index head slide ass'y	1506050*	green RAL 6011**
2	Adapter plate	1501006	green RAL 6011**
3	Bearing pin	1501106	
4	Thrust pin	1501206	
5	Thrust pin	1501306	
6	Set screw	1501406	
7	Journal pin	1503104	comprising No. 7, 61, 62
8	Thrust pin	6007306	
9	Staybolt	1502206	
10	Clamping pin	1502306	
11	Eccentric sleeve	1502506	
12	Stop pin	1502606	
13	Knurled knob	1502706	
14	Compression spring	0504809	
15	Eccentric pin	0502206	
16	Knob	1503306	
17	Washer	1503406	
18	Ring nut	1503506	
20	Stop rail	1503706	
21	Excenter lever	1503809	
22	Clamping lever	1504009	
23	Wiper	1504206	
24	Washer	1504306	
25	Scale	1505109	
25	Scale	1505159*	
26	Stop pin	0504306	
27	Locking pin	0503706	
28	Locking screw	0503806	
29	Vernier	1504509	
29	Vernier	1504959*	
30	Traversing screw	1505206	without pin hole
32	Knurled knob	1505406	without pin hole
33	Pressure pad	1505506	
34	Pressure pad	1505606	
35	Plug	1505706	
36	Knurled screw	1504806	
37	Compression spring	1505909	
38	Screw nut	0505409	without tapped hole

* Inch version

**Surcharge for special colours

Please quote serial number of machine when ordering spare parts.

Index Head Bracket

No.	Part Name	Stock No.	Remarks
39	Collet sleeve	1506204	State diameter, e.g. 28.003 mm or 1.1025"
40	Felt ring	1506409	
41	Index plate	1506504	assembled with 49 & 50
42	Adjuster screw	1506706	without pin hole
42	Adjuster screw	1506756*	without pin hole
43	Knurled ring	1506806	without pin hole
44	Locating gauge	1507004	
45	Draw-in screw	1507206	
46	Knurled knob	1522006	
47	Plug	0506406	
48	Sleeve	0506806	
49	Stop pin	0507106	
50	Stop pin	0507206	
51	Scale drum	0507306	
52	Knurled nut	0507406	
53	Slotted nut	0507506	
54	Index pin	0508006	without pin hole
55	Compression spring	0508109	
56	Nut	0508706	
57	Washer	0508806	
58	Clamping lever	1502409	
59	Clamping lever	1501509	
60	Clamping lever	1501609	
61	Needle bearing - INA		see No. 7
62	Needle bearing - INA		see No. 7
63	Taper pin	8202020	1,5 x 8 DIN 1
64	Cylindrical pin	8204140	2 x 8 DIN 7
65	Cylindrical pin	8204160	2 x 12 DIN 7
66	Cylindrical pin	8204200	2 x 16 DIN 7
67	Cylindrical pin	8204240	3 x 4 DIN 7
68	Slotted head screw	8206120	M3x6 DIN 84
69	Countersunk screw	8259200	M4x10 DIN 963
70	Countersunk screw	8260040	M3x6 DIN 964
71	Set screw	8231200	M5x6 DIN 551
72	Set screw	8232060	M3x8 DIN 553
73	Nut	8255020	M3 DIN 934
74	Grooved pin	8269020	2 x 12 DIN 1472
75	Grooved pin	8271020	1,4 x 4 DIN 1476
76	Key	8287040	4 x 3 x 10 DIN 6885
77	Woodruff key	8288020	2 x 2,6 DIN 6888

* Inch version

Clamping mechanism of index drum T4

Screw off ring nuts 18 and clamping lever 58. Pull swivel arm S off base K. Loosen nut 73, screw out set screw 72 and pull out control lever 21. Remove countersunk screw 69 and take off stop rail 20, index drum T4 and locking screw 28 with locking pin 27. If required, advance 27 one-half turn (clockwise), then reassembly the parts in reverse order. Note: Insert index drum T4 in such a way that stop pin 26 is positioned between 28 and 20. When mounting swivel arm S make sure that 20 is positioned between stop pin 12 and eccentric pin 15. Insert clamping pin 10 into base K simultaneously with swivel arm S. Use 18 to eliminate play of swivel arm S, then screw in clamping lever 58.

Adjusting the 90° swivel motion

The zero position of swivel arm S can be corrected by rotating the eccentric sleeve 11 (knurled knob 13 engaged). To adjust the 90° swivel motion, rotate eccentric pin 15.

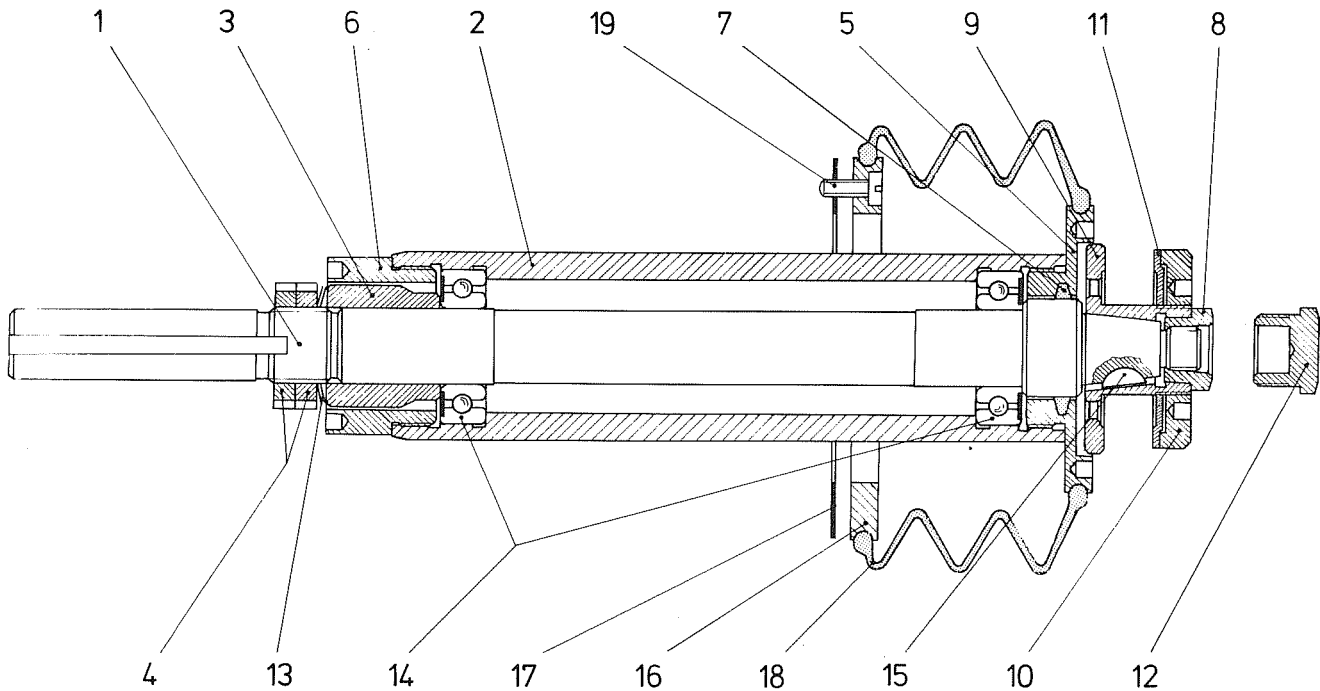
Parts not listed in the table are not available individually and cannot be supplied as spares.

Please quote serial number of machine when ordering spare parts.



Grinding Wheel Spindle

SOE



No	Part Name	Stock No.	Remarks
	Wheel spindle ass'y	1511000	comprising 1-15
1	Grinding wheel spindle	1511006	
2	Spindle sleeve	1511106	
3	Spacer sleeve	1511306	
4	Slotted nut	1511506	
5	Sealing ring	1511606	
6	Sealing sleeve	1511706	
7	Felt ring	1511809	
8	Nut	1512006	
	Wheel mount ass'y	1512504	comprising 9, 10, 11
9	Wheel mount	1512506	
10	Nut	1512706	
11	Tab washer	1512806	
12	Extractor nut	1512606	
13	Cup spring	8024120	CB 6001 n.g.
14	Radial ball bearing	8233080	6003/Z DIN 625
15	Woodruff key	8288060	3 x 3,7 DIN 6888
16	Sealing flange	1510406	
17	Gasket	1510809	
18	Bellows	1510909	
19	Slotted head screw	8206280	M4 x 10 DIN 84

Removing the grinding wheel spindle

CAUTION: do not remove grinding wheel spindle and drive shaft or feed screw at the same time, otherwise clamping member 2 (see "Feed Screw") cannot be refitted without major disassembly of the machine.

Remove protective cap, screw off nut 8, use extractor nut 12 to force off grinding wheel, remove wheel. Slide spindle into left-hand end position, screw off switch assembly and remove from its seat without disconnecting the cable. Loosen hex socket screw 12 (see notes on disassembly and reassembly for "Feed Screw"). Lift off bellows 18 from sealing ring 5 and remove wheel spindle assembly from machine housing.

Dismantling the wheel spindle

Screw off sealing ring 5 and sealing sleeve 6 (left-hand thread). Remove slotted nuts 4, cup springs 13 and spacer sleeve 3. Pull wheel spindle 1 out of spindle sleeve 2. Force off ball bearings 14 (handle with care, do not use hammer).

Reassembly

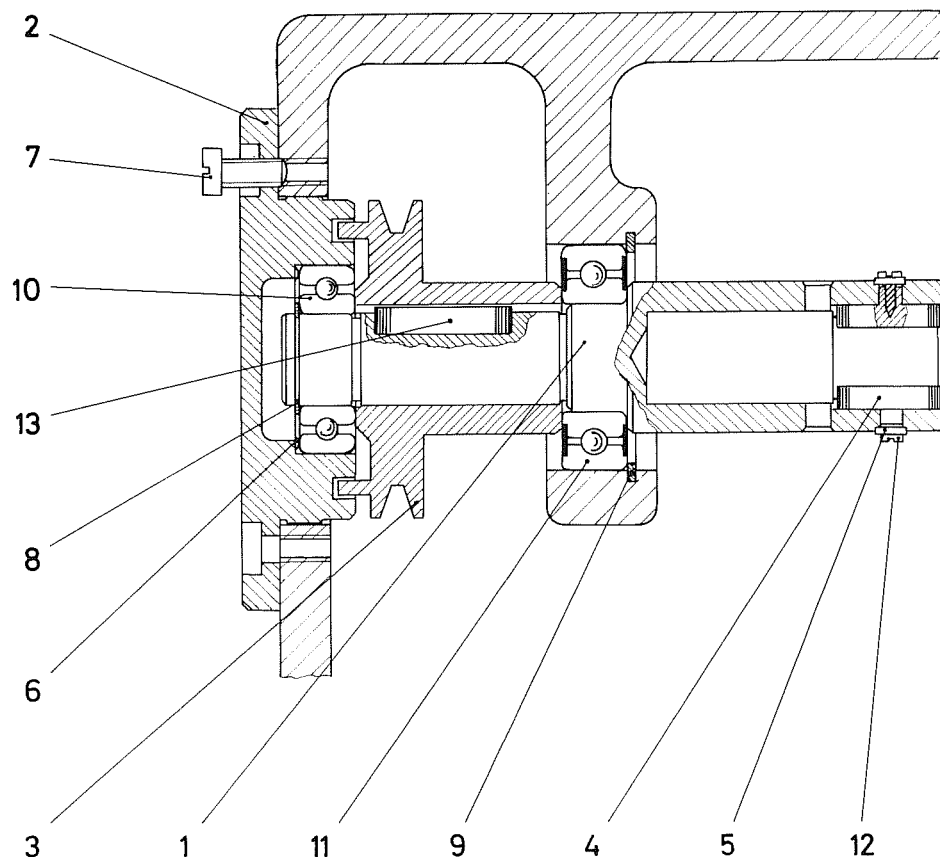
Reverse the above procedure. To preload bearings by means of cup springs 13, proceed as follows: use 4 to tighten 13 to block length, then return 4 approx. 1/3 revolution and lock by means of second slotted nut 4.

Re-installing the wheel spindle

Reverse the procedure described for removal, taking care that the springs 4 (see "Drive Shaft") are not damaged when the spindle is inserted into the housing, and that the clamping member 2 (see "Feed Screw") has been moved up to the stop on the wheel spindle.

Please quote serial number of machine when ordering spare parts.

SOE Drive Shaft



Removing the drive shaft

CAUTION: do not remove drive shaft or feed screw and grinding wheel spindle at the same time, otherwise clamping member 2 (see "Feed Screw") cannot be refitted without major disassembly of the machine. Remove V-belt from motor pulley (see notes on disassembly and reassembly for "Housing – Drive Motor"). Remove screw 7, detach cover 2 by turning out (turning right) feed screw. Remove drive shaft and V-belt from housing (ball bearing 11 has push fit).

Disassembling the drive shaft

Take off circlip 8, consecutively pull off ball bearing 10, pulley 3 and ball bearing 11 (press fit).

Reassembly and installation in reverse order.

No	Part Name	Stock No.	Remarks
	Drive shaft ass'y	1513001	green RAL 6011**
1	Coupling shaft	1513006	
2	Cover	1513106	green RAL 6011**
3	Pulley	1513206	
4	Spring	1513306	
5	Washer	0508806	
6	Spring	8028035	35 x 28 x 0,5
7	Slotted head screw	8206440 *	M5 x 12 DIN 84
8	Circlip	8227060	17 x 1 DIN 471
9	Circlip	8228040 *	42 x 1,75 DIN 472
10	Radial ball bearing	8233080	6003 DIN 625
11	Radial ball bearing	8233100	6004/2Z DIN 625
12	Sheet metal screw	8296040	2,2 x 6,5 DIN 7971
13	Key	8287140	5 x 5 x 25 DIN 6885

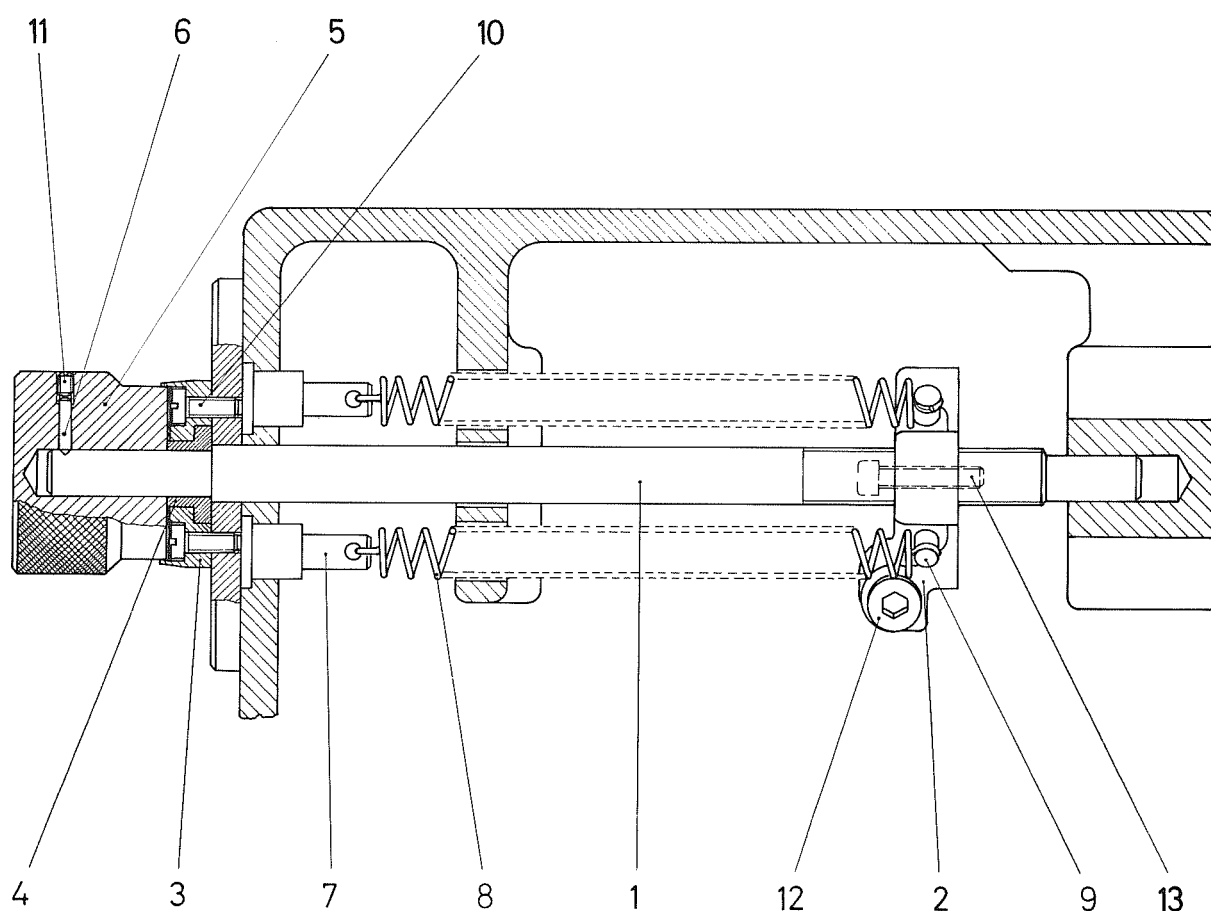
*Not included in no. 1513001

**Surcharge for special colours

Please quote serial number of machine when ordering spare parts.

Feed Screw

SOE



No	Part Name	Stock No.	Remarks
1	Feed screw	1514006	
1	Feed screw	1514056*	
2	Clamping member	1514106	
2	Clamping member	1514156*	
	Flange ass'y	1514204	comprising 3, 4
	Flange ass'y	1514254*	comprising 3, 4
3	Flange		not available
4	Sleeve		individually
5	Knurled knob	1514406	
5	Knurled knob	1514456*	
6	Thrust pin	1514506	
7	Pin	1514606	
8	Tension spring	0516509	
9	Grooved pin	8012340	5x22 Kerpin-S 7
10	Slotted head screw	8206440	M5x 12 DIN 84
11	Set screw	8231140	M4x 5 DIN 551
12	Hex socket screw	8246560	M8x 35 DIN 912
13	Hex socket screw	1514706	

* Inch version

Removing the feed screw

CAUTION: do not remove feed screw and grinding wheel at the same time, otherwise clamping member 2 cannot be refitted without major disassembly of the machine.

Remove set screw 11 and thrust pin 6, pull off knurled knob 5. Remove screws 10, take off flange 3 and screw out feed screw 1 (left-hand thread).

When feed screw 1 has to be replaced, pull sleeve 4 off screw 1 and press 4 on new feed screw.

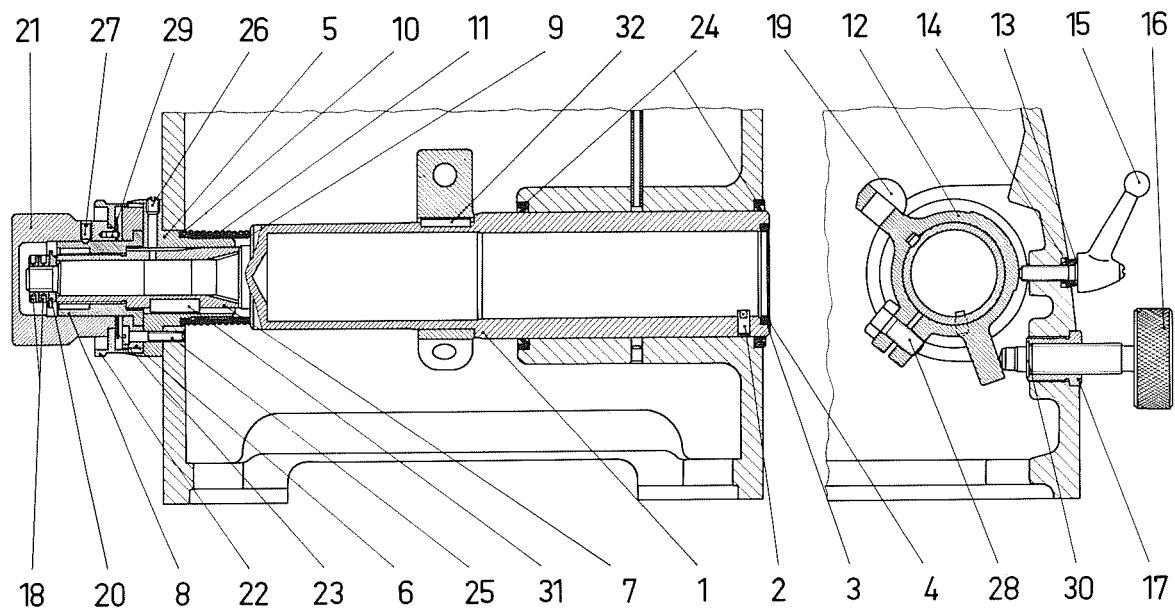
To reassemble the parts, reverse this procedure.

Removing the clamping member

Remove flanged electric motor (see "Housing – Drive Motor") and drive shaft (see "Drive Shaft"). Detach tension springs 8 from pins 9 and remove springs from housing together with pins 7. Loosen hex socket head screw 12 and remove clamping member 2 from grinding wheel spindle. To reassemble the parts, reverse this procedure.

Please quote serial number of machine when ordering spare parts.

SOE Main Axle – Fine Adjustment Mechanism



Fine adjustment mechanism

Back off set screw 27 and pull off knurled knob 21 with scale drum 22. Screw off ring nuts 18 and remove washer 20. Undo screws 25 (CAUTION: spring 11 will force out collar sleeve 5). Remove retaining ring 6 threaded pin 7 with nut 8, and collar sleeve 5 with ring 10. To reassemble the parts, reverse this procedure, using 18 to eliminate play in swivel motion of main axle.

Removing the main axle

Back off set screw 27 and pull off knurled knob 21 with scale drum 22. Screw off ring nuts 18 and remove washer 20. Detach base plate (see notes on disassembly and reassembly for "Housing – Drive Motor"). Loosen hex head screw 28 and pull off spider 12. Push out main axle 1 to the right. To reassemble the parts, reverse this procedure, taking care that protective tube 9, spring 11 and ring 10 are inserted in the correct order.

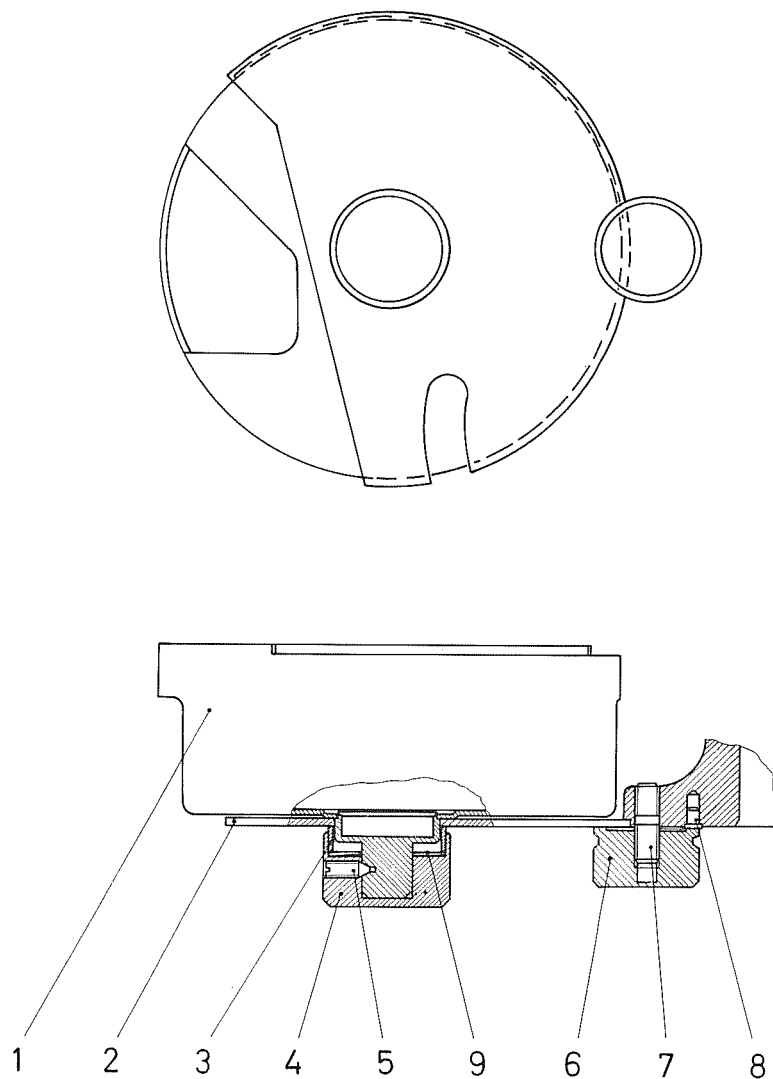
No.	Part Name	Stock No.	Remarks
	Main axle ass'y	1515000	
1	Main axle	1515006	
2	Guide pin	1515406	
3	Felt ring	1515609	
4	Felt ring cap	1515806	
5	Collar sleeve	1516006	
5	Collar sleeve	1516056*	
	Retaining ring ass'y	1516104	comprising 6, 7, 8
	Retaining ring ass'y	1516154*	comprising 6, 7, 8
6	Retaining ring		not available individually
	Threaded pin ass'y	1516204	comprising 7 and 8
	Threaded pin ass'y	1516254*	comprising 7 and 8
7	Threaded pin		not available
8	Nut		individually
9	Protective tube	1516309	
10	Ring	1516409	
11	Spring	1516509	
12	Spider	1516606	
13	Cap	1516706	
14	Compression spring	1516809	
15	Clamping lever	1516909	
16	Screw	1517006	
17	Collar sleeve	0518106	
18	Ring nut	0503406	
19	Rubber pad	0515309	
20	Washer	0515806	
21	Knurled knob	0516006	
22	Scale drum	0516106	
22	Scale drum	0516156*	
23	Annular spring	0516206	
24	Sealing ring	8005020	G50 x 58 x 4
25	Slotted head screw	8206380	M4 x 22 DIN 84
26	Set screw	8231200	M5 x 6 DIN 551
27	Set screw	8232120	M4 x 8 DIN 553
28	Hex head screw	8254160	M8 x 18 DIN 933
29	Grooved pin	8271040	2 x 5 DIN 1476
30	Circlip	8285040	7 Ø DIN 6799
31	Key	8287120	5 x 5 x 20 DIN 6885
32	Key	8287080	5 x 3 x 20 DIN 6885

* Inch version

Please quote serial number of machine when ordering spare parts.

Wheel Guard

SOE

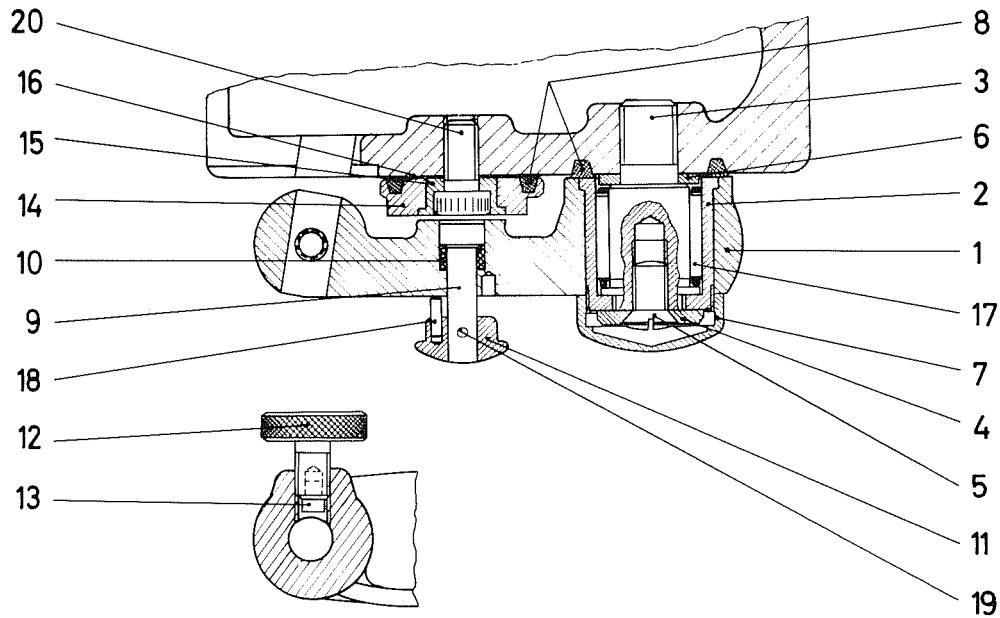


No.	Part Name	Stock No.	Remarks
	Wheel guard ass'y	1519001	green RAL 6011*
1	Wheel guard	1519004	
2	Plate	1519306	green RAL 6011*
3	Sleeve	1519506	
4	Knurled cap	1519606	
5	Set screw	1519706	
6	Knurled nut	1520006	
7	Stud bolt	1520106	
8	Stop pin	1520306	
9	Cup spring	8024100	CB 6001 g.

*Surcharge for special colours

Please quote serial number of machine when ordering spare parts.

SOE Wheel Dressing Attachmet



Dismantling the dressing lever

Screw off cap 7 and countersunk screw 5, remove washer 4. Screw out pin 3 (first screw in metric screw, 6 mm dia, lock by means of lock nut, then remove 3 by means of spanner), remove washer 6. Force pin 3 out of needle bearing and remove needle cage 17. To reassemble the parts, reverse this procedure.

Removing the stop pin

Knock out cylindrical pin 19, pull off knurled knob 11, take off stop pin 9 and compression spring 10. Reassemble in the reverse order. When stop pin 9 has to be replaced, drill pin hole in 19 and 11.

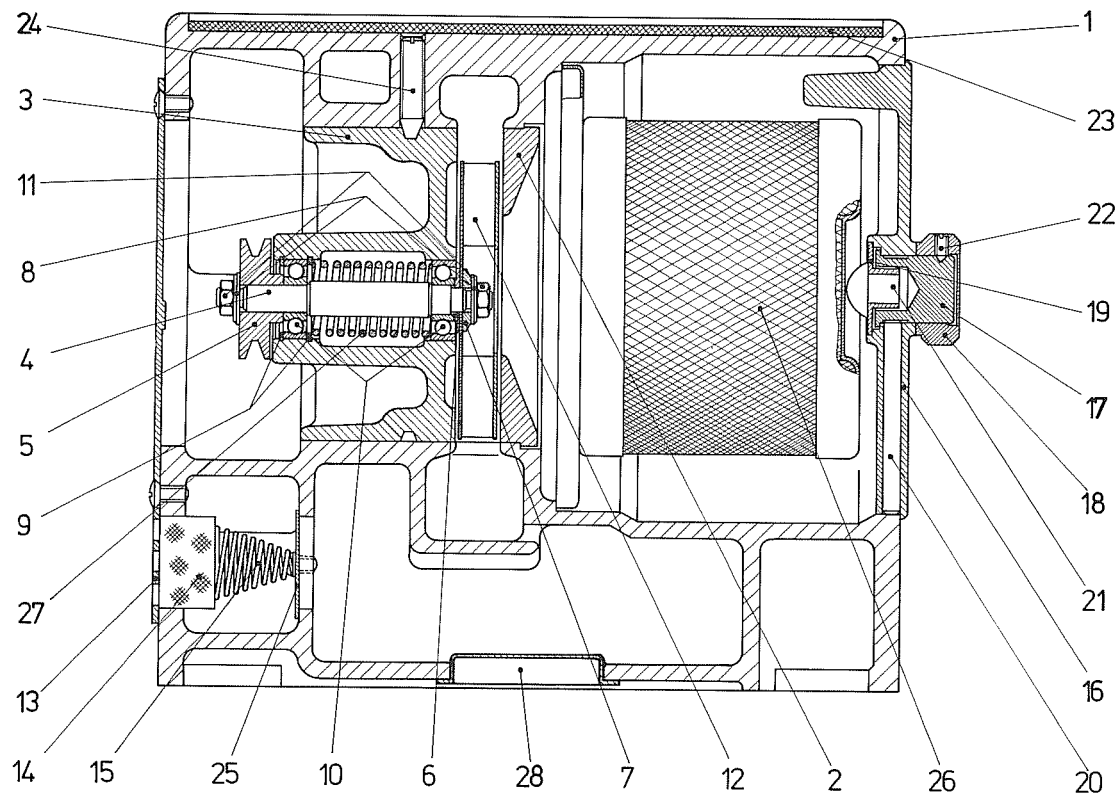
No	Part Name	Stock No.	Remarks
	Wheel dressing attachment ass'y	1521001	green RAL 6011*
1	Dressing lever	1521006	green RAL 6011*
	Needle race ass'y	1521204	comprising 2, 3, 4, 5
2	Needle race		not available
3	Pin		individually
4	Washer	1521406	
5	Countersunk screw	8260080	M6 x 10 DIN 964
6	Washer	1521506	
7	Cap	1521606	
8	Felt ring	1521709	
9	Stop pin	1521806	without pin hole
10	Compression spring	1521909	
11	Knurled knob	1522006	without pin hole
12	Knurled screw	1522206	
13	Pressure pad	1522306	
14	Eccentric disc	1522506	
15	Sleeve	1522606	
16	Cover plate	1522806	
17	Needle cage	8015010	INA - K14/17
18	Cylindrical pin	8204140	2 x 8 DIN 7
19	Cylindrical pin	8204160	2 x 12 DIN 7
20	Hex socket screw	8291080	M6 x 12 DIN 6912

*Surcharge for special colours

Please quote serial number of machine when ordering spare parts.

Dust Exhaust Unit

SOE



No	Part Name	Stock No.	Remarks
1	Housing	1525006	green RAL 6011*
2	Disc	1525106	
	Bearing ass'y	1525204	comprising 3-12
3	Bearing	1525206	
4	Shaft	1525306	
5	Pulley	1525406	
6	Spacer	1525506	
7	Washer	1525606	
8	Washer	8213080	6,4 DIN 125
9	Circlip	8228020	26x1,2 DIN 472
10	Radial ball bearing	8233360	629/2RS DIN 625
11	Nut	8255080	M6 DIN 934
12	Turbine rotor	8024310	
13	Cover plate	1525706	green RAL 6011*
14	Filter mat	1525806	
15	Compression spring	1525909	
	Cover ass'y	1526004	comprising 16-22
16	Cover	1526006	green RAL 6011*
17	Eccentric pin	1526106	
18	Knurled knob	1526206	
19	Washer	1626306	
20	Pin	1526406	
21	Rubber pad	0515309	
22	Set screw	8232120	M4x8 DIN 553
23	Tray	1526606	
24	Set screw	1526706	
25	Cover plate	1526909	
26	»Delbag« filter cartridge	8007050	LK Mod. 1HL
27	Spring	1526509	
28	Plug	8009050	

*Surcharge for special colours

Dismantling the bearing assembly

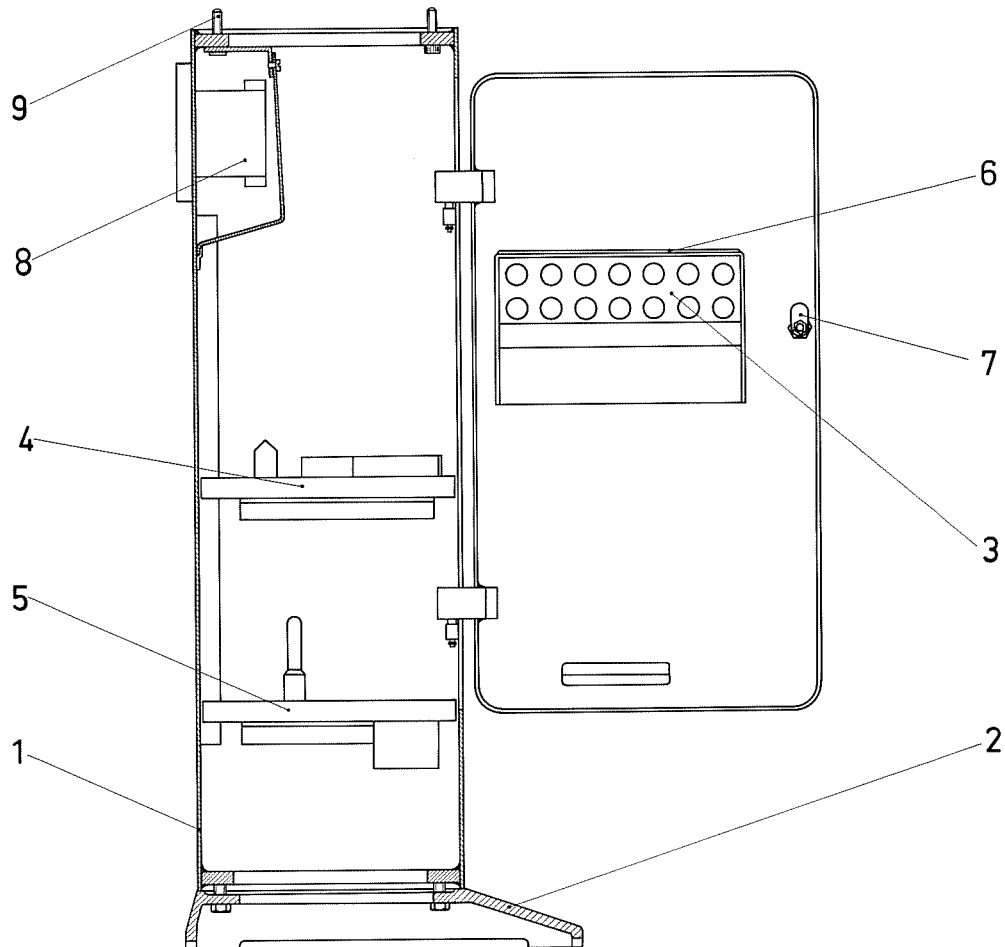
Screw off cover plate 13, remove V-belt, screw out set screw 24 and remove bearing assembly 3 from housing. Remove nut 11 (on pulley side), pull off pulley 5, and force shaft 4 (with turbine rotor 12) off bearing 3. Remove circlip 9 and force off ball bearing 10. Screw off nut 11 (on rotor side), remove washer 8, washer 7, turbine rotor 12 and spacer 6. Pull off ball bearing 10 from shaft 4. To reassemble the parts, reverse this procedure.

Cover assembly

Remove pin 20, screw off set screw 22 and take off knurled knob 18. Use eccentric pin 17 to force off washer 19. Reassembly: insert 17, slide on 18 and screw in set screw 22. Press in washer 19 with rubber pad 21 and insert pin 20.

Please quote serial number of machine when ordering spare parts.

SOE Machine Pedestal



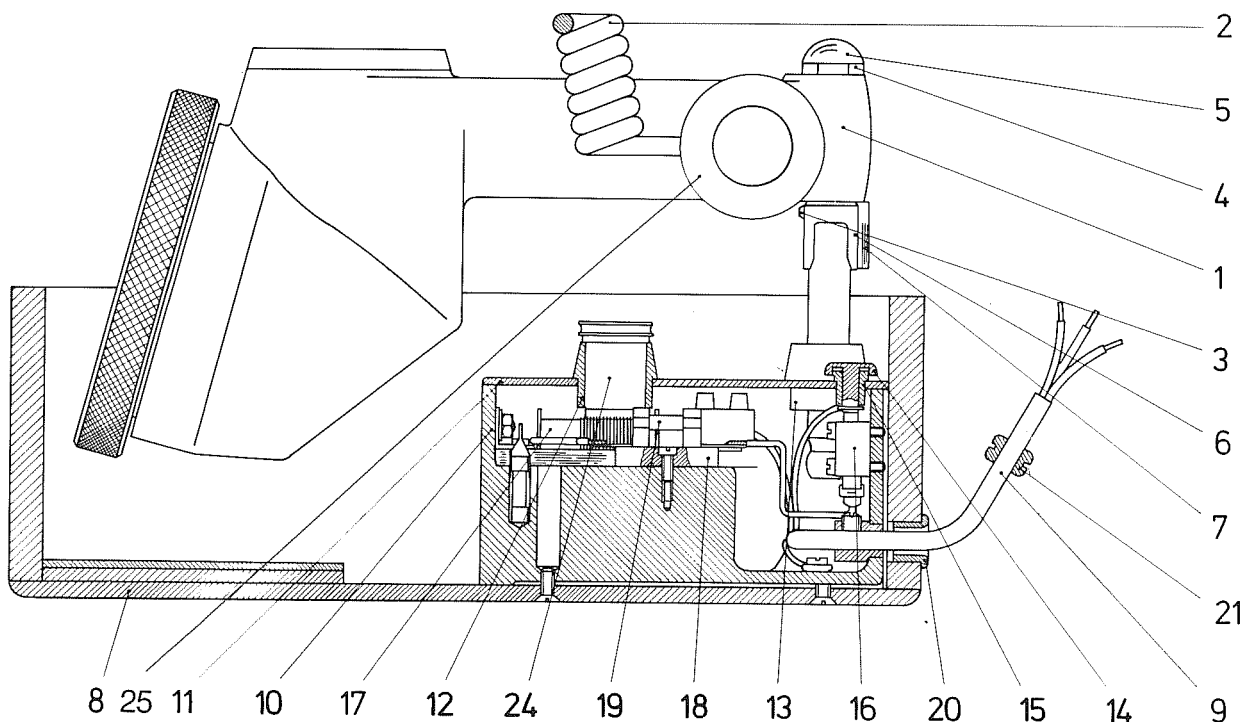
No.	Part Name	Stock No.	Remarks
	Machine pedestal, complete	153000xx	State voltage & frequency of drive motor.
1	Pedestal ass'y	1530009	
2	Base	1530206	green RAL 6011*
3	Collet holder	1530809	
4	Shelf	1531509	
5	Shelf	1531609	
6	Tray	1532206	
7	Cylinder lock	8031170	DOM - N° 316
8	Protective motor switch	80xxxx0	State voltage & frequency.
9	Hex socket screw	8246560	M8 x 35 DIN 912

*Surcharge for special colours

Please quote serial number of machine when ordering spare parts.

Measuring Projector

SOE

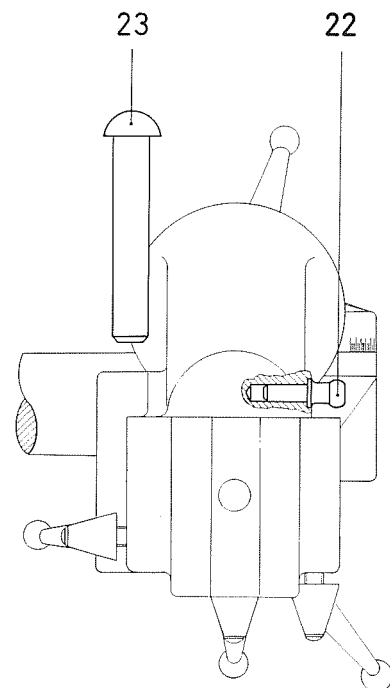


No.	Part Name	Stock No.	Remarks
	Measuring projector**	1535001	
	Measuring projector**	1534901	
	Measuring projector**	1534951*	
1	Projector proper	1535009	only available with part 2
1	Projector proper	1535059*	only available with part 2
2	Helix cord	1535109	
3	Hex nut	1535406	CAUTION (see below)***
4	Hex nut	1535506	CAUTION (see below)***
5	Protective cap	1535609	
6	Locating fork	1535806	CAUTION (see below)***
7	Protective segment	1535909	
8	Wooden case, pedestal model	1537109	
9	Cable, pedestal model	1537504	
	Transformer box 220 V	1538004	comprising 10-19 State voltage.
	Transformer box 110 V	1537904	
10	Transformer box	1538006	
11	Cover	1538106	
12	Bulb housing	1538206	
13	Protective sleeve	1538306	
14	Plug	1538406	
15	Bearing sleeve	1538506	
16	Microswitch	8021360	
17	Transformer	80xxxx0	State voltage.
18	Fuse mount	80xxxx0	State voltage.
19	Microfuse	80xxxx0	State voltage.
20	Cable sleeve	0511309	
21	Cable sleeve	8012255	Pedestal model only.
22	Round head pin	1539206	CAUTION (see below)***
23	Protective pin	1539404	
24	Spare light bulb	8013140	6V/15W
25	Lamp cap complete	8018056	incl. part 2

* Inch version

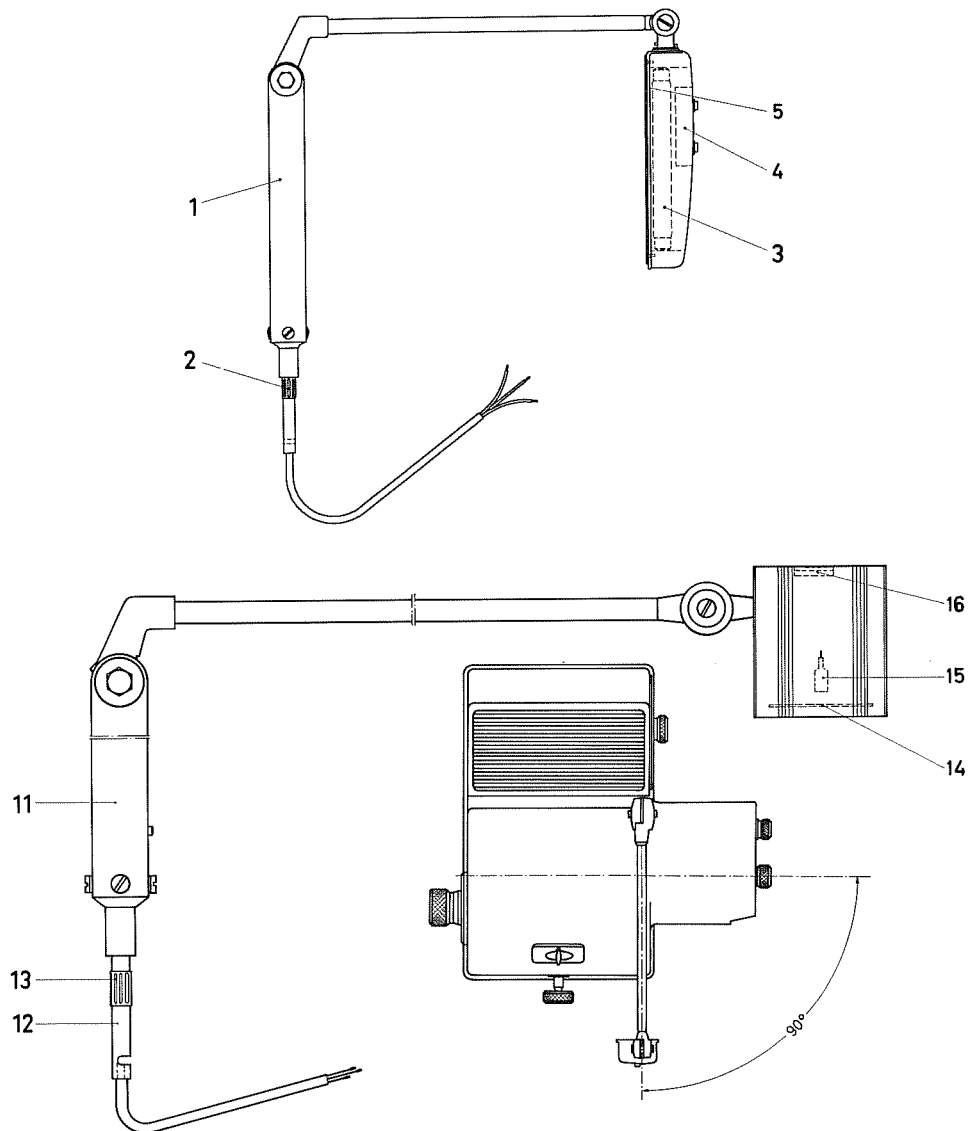
** Index head to be returned to factory.

*** Replacement of this part requires new adjustment of measuring projector.



Please quote serial number of machine when ordering spare parts.

SOE Machine Lamp / Halogen Machine Lamp



Removing the machine lamp

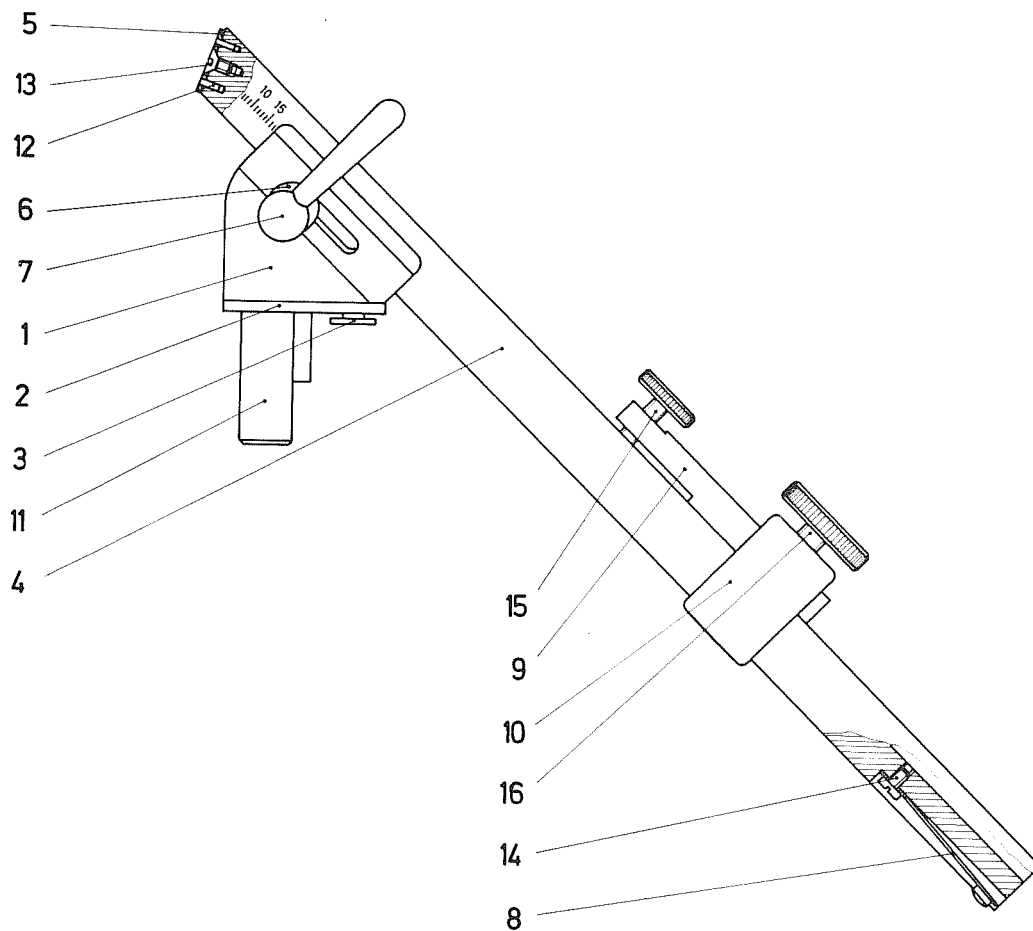
Disconnect cable from ballast (remove plate 11 from base plate 10, see notes on disassembly and reassembly for "Housing – Drive Motor"). Pull out lamp assembly in an upward direction while positioned at right angles to the wheel spindle (see drawing above). For reassembly, reverse this procedure.

No.	Part Name	Stock No.	Remarks
	Machine lamp, 220 V	1540000	comprising 1 + 2
	Machine lamp, 110 V	1540080	comprising 1 + 2
1	Machine lamp, 220 V	1540019	
1	Machine lamp, 110 V	1540109	
2	Connector	8022380	AN 10 x 18 K
3	Spare fluorescent tube	8013130	LR4-4W-white
4	Spare starter	8021280	
5	Spare mask	8003010	
11	Halogen machine lamp 220 V / 12 V / 20 W	1540400	
11	Halogen machine lamp 110 V / 12 V / 20 W	1540300	
12	Lamp stand	8013143	
13	Connector	8022380	AN 10 x 18 K
14	HP-Substitute glass	8021910	
15	Halogen filament lamp 12 V 20 W	8013120	
16	Switch for halogen lamp	8021200	

Please quote serial number of machine when ordering spare parts.

Twist Drill Grinding Attachment

SOE



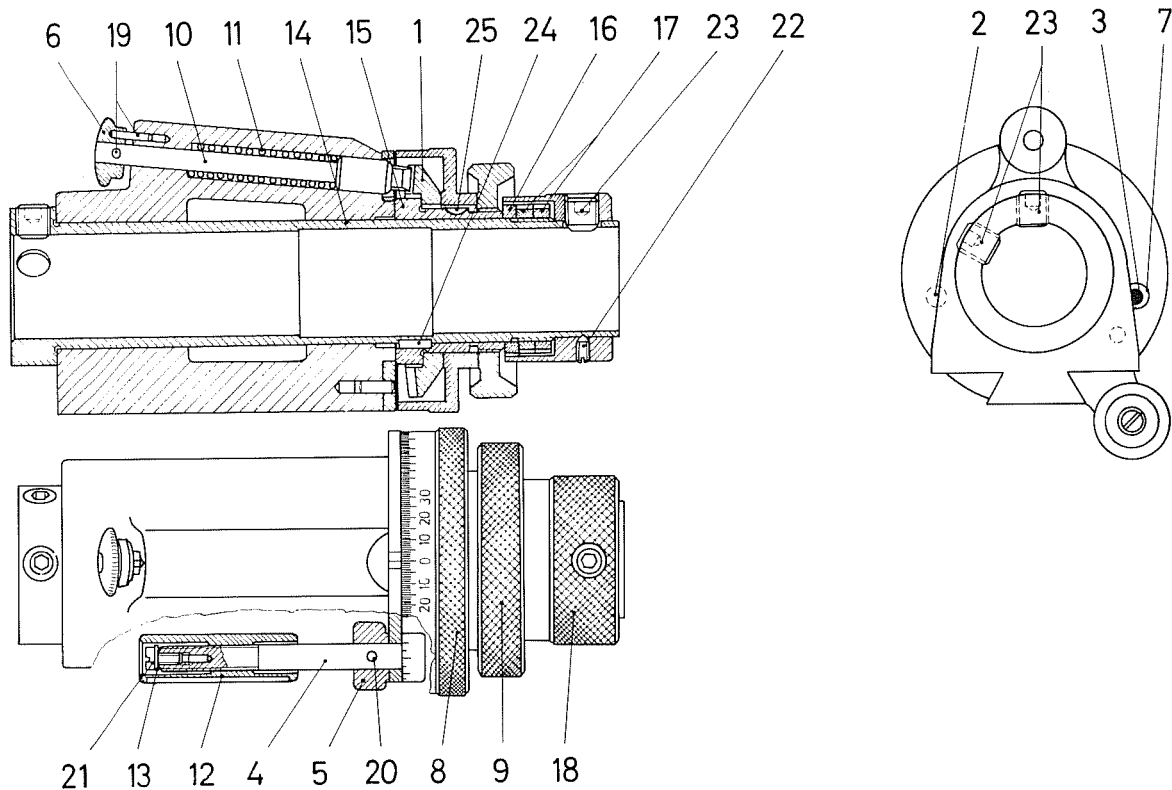
No	Part Name	Stock No.	Remarks
	Twist drill grinding attachment	1545000	
	Twist drill grinding attachment	1545050*	
1	Holder	0545206	
2	Stop plate	1545204	
3	Stop pin	0545606	
4	Swivel-mounted V-guide	0545706	
4	Swivel-mounted V-guide	0545756*	
5	Gauge plate	0545806	
6	Ball socket	0546009	
7	Clamping lever	0546109	
8	Leaf spring	0546504	
9	Stop	0546806	
10	Ring	0546906	
11	Cylindrical pin	8204800	12 x 50 DIN 7
	Cylindrical pin	0547056*	For inch version.
12	Cylindrical pin	8204020	1,2 x 4 DIN 7
13	Countersunk screw	8259060	M3 x 6 DIN 963
14	Slotted head screw	8206100	M3 x 5 DIN 84
15	Knurled screw	8235020	M4 x 16 DIN 653
16	Knurled screw	8235040	M6 x 16 DIN 653

*Inch version

For replacement of stop plate 2, pull out stop pin 3 (press fit).

Please quote serial number of machine when ordering spare parts.

SOE Spindle Assembly Special Locating Fixture



Removing the bearing sleeve

Back off set screws 22 and 23, pull off clamping ring 18. Remove nuts 17 and thrust ring 16. Pull off sleeve 15 with index plate 1, scale drum 8 and knurled nut 9, take out key 24, and pull out bearing sleeve 14 in a forward direction. To reassemble the parts, reverse this procedure, eliminating play of 14 by means of 17.

Index pin

Knock out cylindrical pin 19, pull off knurled knob 6, remove index pin 10 and compression spring 11. For reassembly reverse this procedure. When index pin 10 has to be replaced, drill pin hole for 19 through 6, making sure that 10 engages index plate 1, and 6 engages middle index hole.

Fine adjustment mechanism

Remove screw 21 and washer 13, screw off nut 12, knock out cylindrical pin 20 and pull off knurled ring 5. For reassembly reverse this procedure. When replacing adjuster screw 4, drill pin hole for 20 through knurled ring 5.

No	Part Name	Stock No.	Remarks
	Spindle spec. locating fixture ass'y	1542000	green RAL 6011**
	Spindle spec. locating fixture ass'y	1542050*	green RAL 6011**
1	Index plate	1506504	assembled with 2 & 3
2	Stop pin	0507106	
3	Stop pin	0507206	
4	Adjuster screw	1506706	without pin hole
4	Adjuster screw	1506756*	
5	Knurled ring	1506806	without pin hole
6	Knurled knob	1522006	without pin hole
7	Plug	0506406	
8	Scale drum	0507306	
9	Knurled nut	0507406	
10	Index pin	0508006	without pin hole
11	Compression spring	0508109	
12	Nut	0508706	
13	Washer	0508806	
14	Bearing sleeve	0542306	
14	Bearing sleeve	0542356*	
15	Sleeve	0542406	
16	Thrust ring	0542506	
17	Nut	0542606	
18	Clamping ring	0542706	
19	Cylindrical pin	8204160	2 x 12 DIN 7
20	Cylindrical pin	8204200	2 x 16 DIN 7
21	Slotted head screw	8206120	M3 x 6 DIN 84
22	Set screw	8232100	M4 x 6 DIN 553
23	Set screw	8247060	M8 x 8 DIN 913
24	Key	8287020	A3 x 3 x 8 DIN 6885
25	Woodruff key	8288020	2 x 2,6 DIN 6888

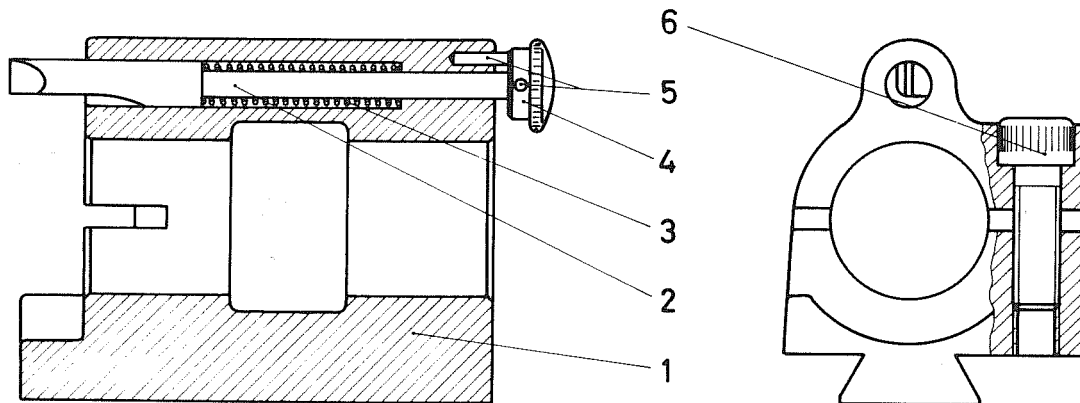
*Inch version

**Surcharge for special colours

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Spindle Assembly Locating Fixture

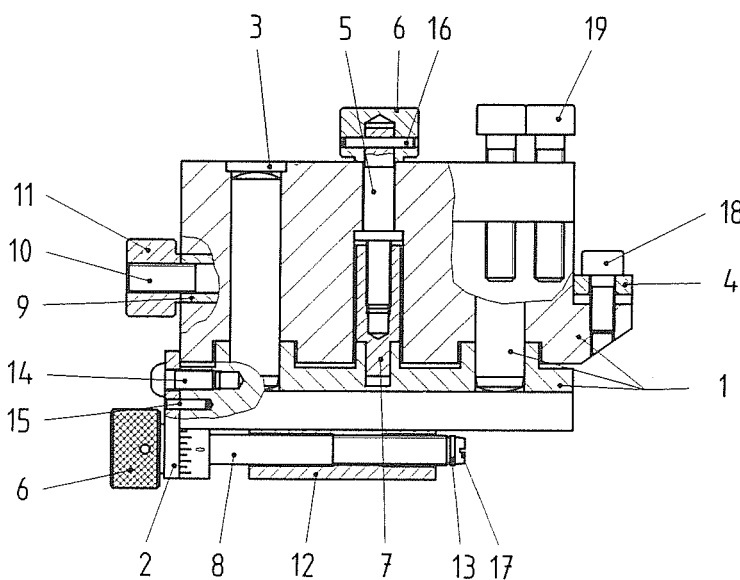
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No.	Part Name	Stock No.	Remarks
	Spindle locating fixture ass'y	0541100	green RAL 6011*
1	Bracket	0541106	green RAL 6011*
2	Index pin	0541506	without pin hole
3	Compression spring	0508109	
4	Knurled knob	0508206	without pin hole
5	Cylindrical pin	8204160	2 x 12 DIN 7
6	Hex socket head screw	8246540	M8 x 25 DIN 912

*Surcharge for special colours

Tool Holder



No.	Part Name	Stock No.	Remarks
1	Tool Holder	1508004	
2	Shett	1508506	
3	Cover sheet	1508606	
4	Clamping pad	1508706	
5	Spindle	1508806	
6	Knurled knob	1508906	
7	Screw nut	1509006	
8	Adjuster screw	1509106	
9	Preassure pad	1509206	
10	Clamping pin	1509306	
11	Cnurled nut	1509406	
12	Nut	0508706	
13	Washer	0508806	
14	Oval head screw	8013300	Hex socket M4 x 10
15	Cylindrical pin	8204140	DIN 7 2 x 8
16	Cylindrical pin	8204180	DIN 7 2 x 14
17	Cylindrical screw	8206120	DIN B4 M3 x 6
18	Hexagon screw	8246180	DIN 912 M5 x 10
19	Hexagon screw	8246400	DIN 912 M5 x 30

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