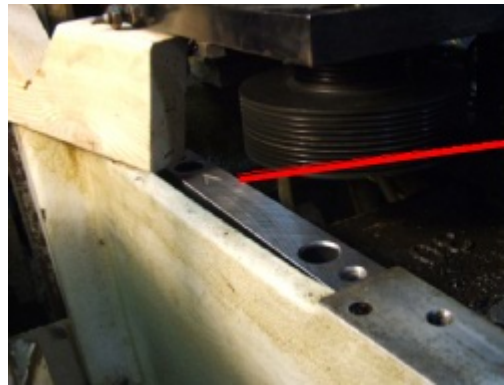


Changing Motor Mounts

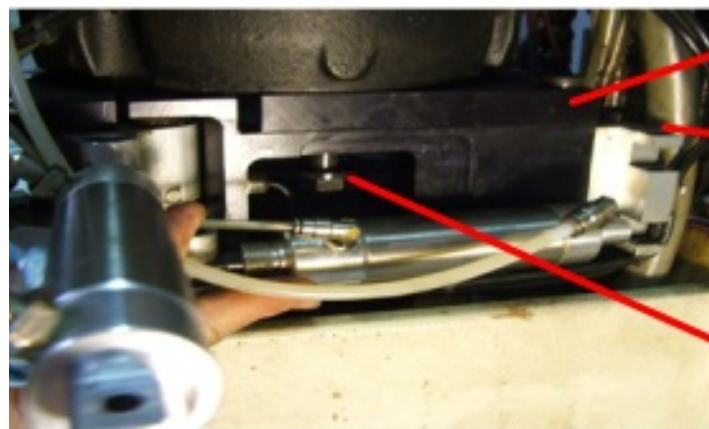
Fadal spindle motor mounts are made in two configurations: Solid steel mounts acceptable to most machines not capable of rigid tapping, or mounts made with vulcanized rubber between for rigid tapping and higher HP/load applications to damper vibrations. The procedure to replace is as follows:

Safety: Remove air and power from the machine.

- 1) Remove head cover.
- 2) Start with the left side mount and remove the left rear motor stand-off. Support motor with a piece of 2 X 4 wood. Now remove from stand-off as shown below.
- 3) Remove the 2 bolts (SOCAPS) holding the mount in place.
- 4) Slide out old mount noting the orientation of stamped letter.
- 5) Clean casting mounting area very thoroughly. Now slide in new mount in place being sure to face stamped letter towards the back of the machine.
- 6) Bolt into place and re-install stand offs.
- 7) Move to the right side.
- 8) Remove bolt holding back of idler cylinders. Swing it forward.
- 9) Remove the large bolt in the middle of cylinder mount and large bolt to the rear of motor plate as shown.



STAMPED LETTER FOR ORIENTATION



BOLT HOLDING BACK OF IDLER BRACKET

BOLT HOLDING IDLER CYLINDERS

BOLT HOLDING FRONT OF IDLER BRACKET

- 10) You may need help now from another person. Push motor to the left to remove idler assembly. Hang it to the side using wire being careful not to damage the air/oil lines and at the same time support rear of motor with 2 X 4.
- 11) Remove the motor mount noting the orientation of the stamped letter.
- 12) Clean surface thoroughly
- 13) Re-install mount in correct orientation and bolt in place.
- 14) Once again hold up motor and slide idler assembly under motor.
- 15) Bolt idler assembly back into place.
- 16) Double check that all bolts & wire connectors are tight.
- 17) Power up, apply shop air to the machine and test.



The job is now complete!