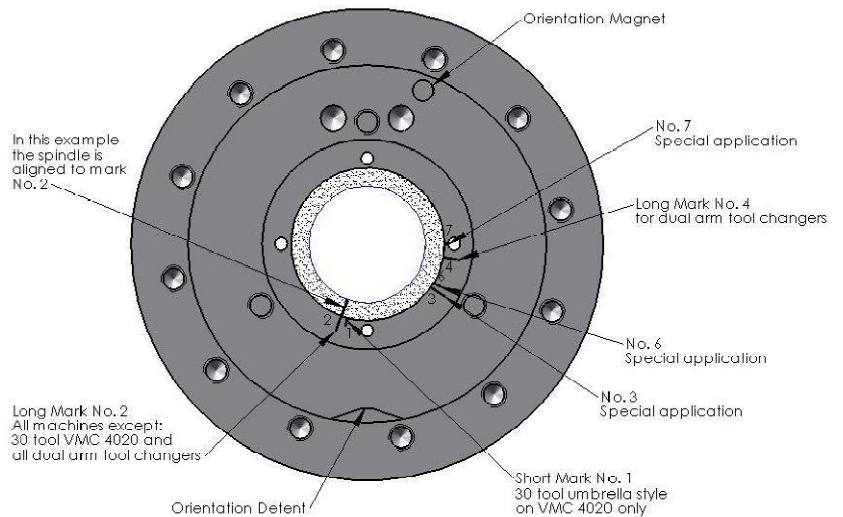


Replacing the Pozi Drive Spindle Pulley

All standard and practical safety rules and guidelines apply to this procedure.

- 1) Position head at Tool Change position. Disconnect the air/power supply from the machine. Remove Z axis head cover, orientation bridge, belt guards and belts.

Note: Record the current alignment noting the mark on the spindle shaft to the alignment mark on the pulley. Refer to Figure 1 for reference. (your old pulley may have only one or two marks rather than what is show to the right.)



- 2) Heat the pulley evenly with either 2 handheld plumbing torches that use either MAP gas, or Propane. (See Figure 2) If these are not available, you can use an Oxy Acetylene torch with a rose bud tip (be very careful not to overheat the pulley in one area). Do not use a brazing, or cutting tip for this procedure.
- 3) Once the pulley is at a sufficient temperature 2-5 minutes depending on torch selection (pulley will drop slightly when hot enough). Keep the torch on the pulley for an additional 15-30 seconds after it drops to ensure ease of removal.



Figure 2

4) **The pulley is now hot!!!** Remove the pulley from the machine using heat insulated gloves.

5) To install a pulley back on the spindle shaft, reverse the steps from number 3, back to number 2. Ensure to align the timing mark as close as possible before heating the pulley and dropping onto the spindle shaft. Then also pay attention to the height offset as depicted in Figure 3. This is critical for proper alignment of the belts to the spindle motor pulley. If possible, utilize the service tool SVT-0078 as the set gage for proper height alignment.

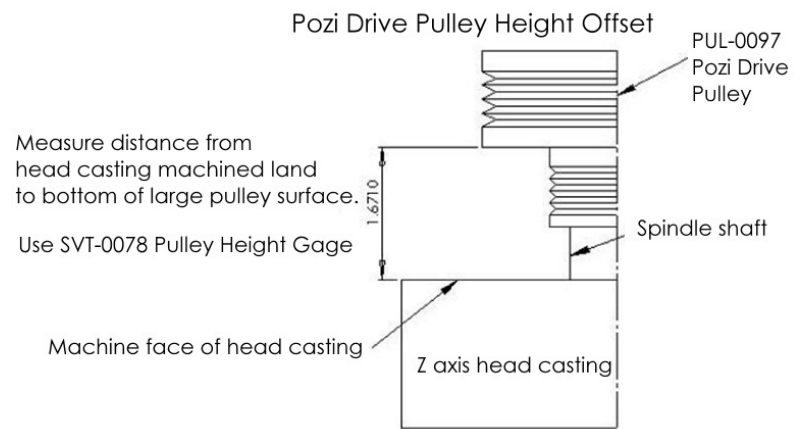


Figure 3

6) After everything has cooled sufficiently, it is safe to reinstall the belts and reassemble the rest of the system. Happy Machining!