

## Teknatool International Ltd

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### Frequently Asked Questions

## How to Replace bearings and/or belt on a TL1000 Headstock

Date Raised: 20/12/03

Safe practises should always be employed to ensure the Health and Safety of yourself, employees and customers (if applicable) Refer to product manuals, exploded drawings and our website if further assistance is required, or contact us on [service@teknatool.com](mailto:service@teknatool.com)

Date Amended:

The main thing to be aware of before you start is that the main case is Cast Aluminium and if not braced correctly when removing and replacing the spindle, can crack and damage the case beyond repair. In saying this all we used to do when we had our fixturing was to insert a frame slightly narrower than the width of the inside of the Headstock and shim the rest of until the frame was fully supported by the brace. You can use anything you have local to you, wood, steel etc.

#### Tools required:

Wooden/Plastic/Hide mallet

Later models had a circlip on the outboard end so a pair of 30mm circlip pliers may be required. Wooden drift 40mm diameter minimum or 75mm diameter maximum.

#### Parts required:

2 x 6306LLB bearings (Teknatool recommend NTN or NSK brand bearings)

1 x 6J 965 Belt

It is recommended that a Mechanical Engineer should perform this operation to ensure accuracy and that the correct tools and methods are used.

To remove the Headstock spindle from the casing and the Headstock secured to the bench/floor. Loosen the M8 grub screw/s on the headstock pulley and detach the belt from the motor pulley. With the headstock braced as above and the circlip removed from the Outboard end of the spindle (only on certain models) hit the spindle along the centreline so that the spindle and the front bearing come out of the headstock. Several blows may be required to remove then spindle. The headstock pulley can be put aside. Remove the front bearing from the spindle. Both bearings and belt should be discarded. Clean both bearing journals and bearing housings for re-assembly. Press front bearing onto the Front journal of the headstock spindle (RH thread end) Press the spindle with the front bearing on back into the headstock with the headstock pulley and new belt together. Press the rear bearing on while supporting the front bearing (to avoid it pressing out) Replace circlip. Release pre-load on either bearing if necessary. End of operation.