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515 Spindle Base Alignment

Refer to: Service Parts Guide, Model 515C Diamond Gantry Saw booklet, Spindle Base Assembly diagram, page 2, and the photograph below.

1. Raise the Spindle Base with the manual or power raise/lower actuator as equipped.
2. Check Spindle Base Clearance
   a. Check the clearance between the Spindle Base and the Carriage Assembly on the blade side as shown in the photo. Measure at the near end as shown and at the far end. The clearance should be about 3/16". It is more important that the two measurements be equal than precisely 3/16". At assembly, we use a piece of 3/16" key stock (square steel bar) as a gauge.
   b. It is normal for the clearance between the Base and Carriage to be greater on the opposite side away from the blade.
   c. To change the clearance, slide the pivot shaft of the Base in the pillow block bearings, which support the shaft. Loosen the bearing collars to enable the shaft to slide.
   d. To make the clearance at the near and far end equal, crack loose the anchor bolts of one or both of the pillow block bearings and slide the bearing(s) forward or back as required to correct the alignment.
3. Check the flatness of the Spindle Base. The spindle shaft should be parallel to the pivot shaft. Lay a straight edge on the underside of the Base approximately where the white lines are sketched in. The straight edge should lay flat and not rock nor have a gap in the center. It is possible in the event of a severe "crash" (saw blade runs up on top of stone and lifts entire main rail off tram rails and then "crashes" back down) that the Spindle Base is warped.