

Required Tools and Supplies

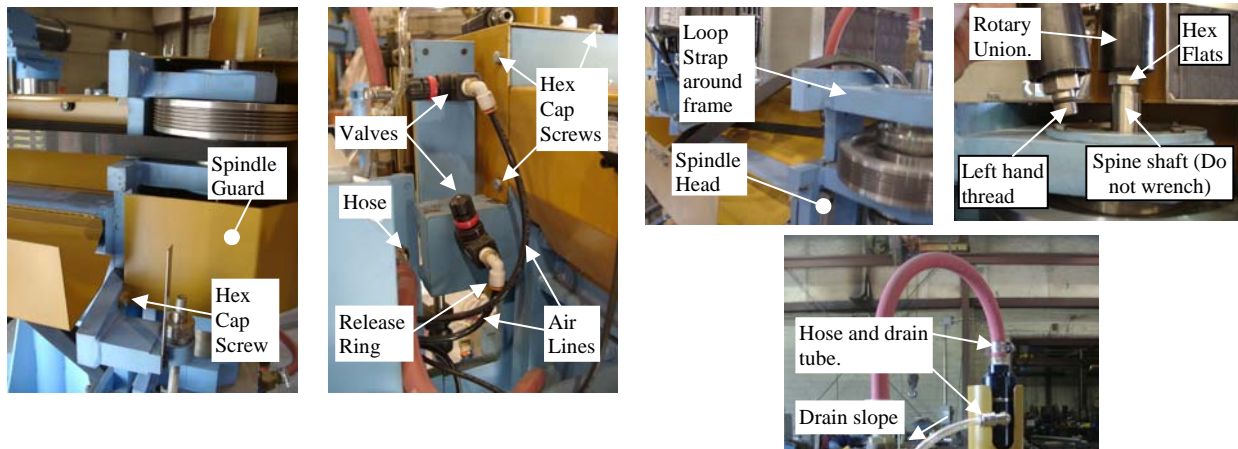
- Wrench set, box/open sizes: 5/16" (optional), 7/16", 9/16", 3/4", 15/16"
- Wrench, 1-1/4" adjustable (to hold spindle shaft)
- 1/4" flat screwdriver (for hose clamps)
- Heavy duty lifting straps (1000 lb capacity or more)
- Wire or twine (to hang machine handle)

Procedure

Open the long belt guard and remove the spindle guard. There are four 1/4" cap screws with 7/16" hex head on most machines.

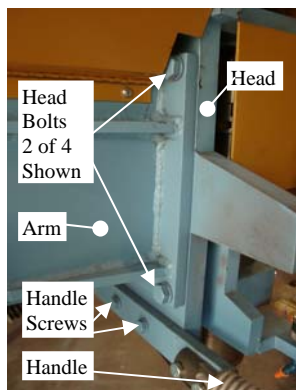
If returning the head to SSI for repair, DO NOT remove the rotary union from spline shaft. Send the rotary union back with the head.

Release belt tension (Lever behind motor) and remove the drive belt.



Remove the two plastic air lines and two valves connected to the air balance cylinder. To release the tubing, press and hold the release ring then pull out the tube.

Remove the water hose from the water manifold at the back of the head.



Remove the handle from the head and tie it from the arm of the front control panel so as to not put tension on the air line to the handle. Loop a strap around the head where shown above. Lift up on the strap with a hoist or fork truck to hold the weight of the head (about 200 lbs). Remove the four bolts that secure the head to the machine arm. The head is keyed into the arm. Push or pry the head away from the arm off the key. If returning the head to Sawing Systems for repair, wrap the head in plastic and set it backside down onto a pallet or preferably pack it into a sturdy wood box for transport. Be very careful to not hit or damage the rotary union. Send the front spindle guard, as this may require some rework to bring it to current standards. Secure all loose

parts.



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Reassembly

Reinstall components in reverse order.

Be sure to pitch the fitting and the drain tube slightly down from the outlet port of the rotary union as shown above and per TSB 05T09.

Break-In and Start-Up

New bearings require a break in procedure. When bearings are replaced at the factory, the customer is required to perform the following break-in procedure: Run the spindle at 2000 RPM for 5 minutes. Bearings should run smooth and quiet. Feel the metal area around the two pulley bearings (one over and one under pulley) and at each end of Spindle Housing. These areas must not get too hot to touch (about 140°F). Stop the spindle immediately and call SSI if the bearings get too hot to touch. After 5 minutes run time, stop for 10 minutes. Repeat this cycle and procedure at 4000, 6000, 8000, and finally at 10,000 RPM. Stop immediately and call SSI if any of the metal areas get too hot to touch.

Warranty

Sawing Systems will not warranty the bearings in this head assembly that are not installed by Sawing Systems. SSI will not warranty bearings that have not been broken in properly.