



# 6329536 SPINDLE REPLACEMENT KIT INSTALLATION INSTRUCTIONS

## REPLACEMENT OF GRINDING HEAD SHAFT & BEARINGS

THIS SPINDLE REPLACEMENT KIT APPLIES TO THE FOLLOWING GRINDERS:

MODEL 6320910 S/N 1001 THRU 1109, MODEL 6320920 S/N 1001 THRU 1027

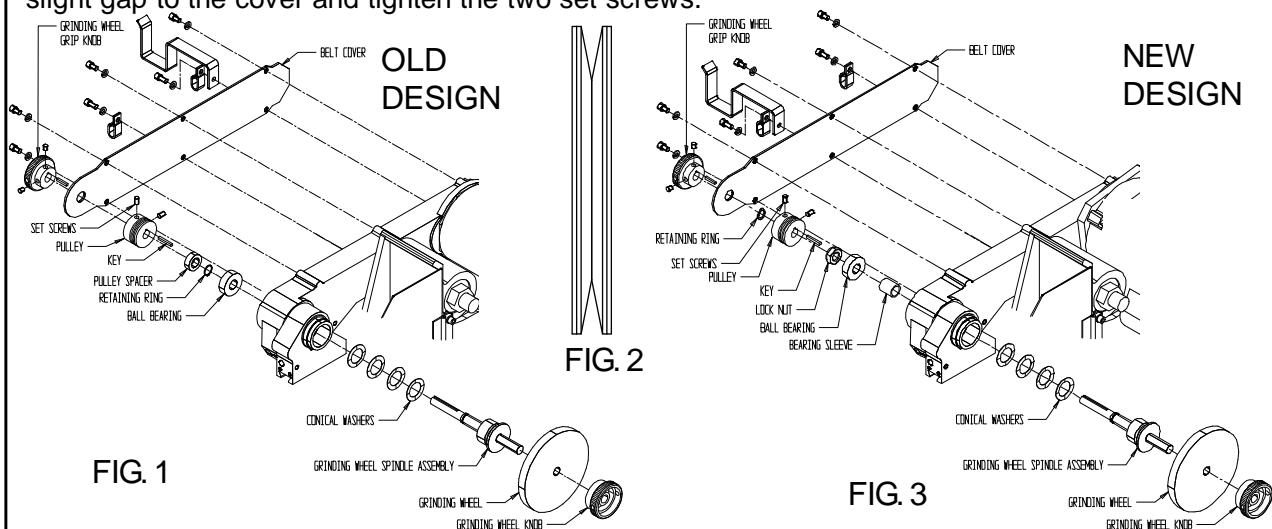
MODEL 6320930 S/N 1001 THRU 1014, MODEL 6320940 S/N 1001 THRU 1004

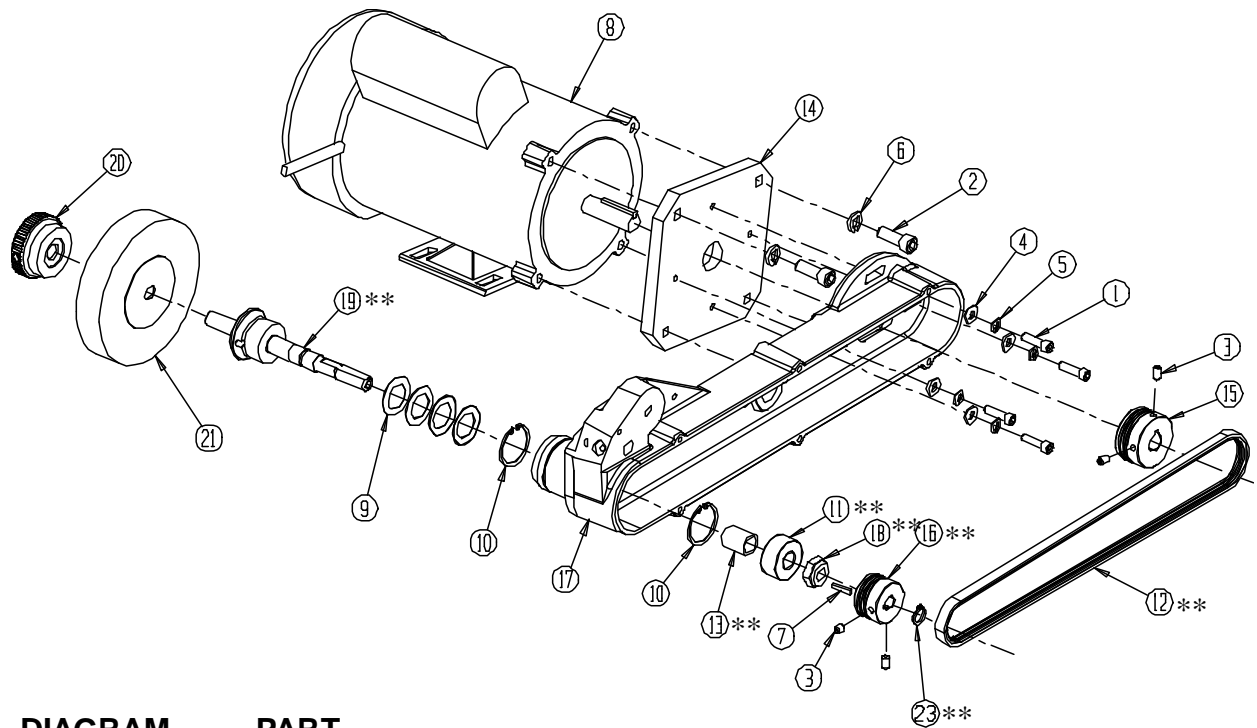
MODEL 6520910 S/N 1001 THRU 1038, MODEL 6520920 S/N 1001 THRU 1013

Remove grinding wheel and grinding wheel knob. The Grinding Head Spindle Assembly consists of the grinding head spindle and a ball bearing press fit together. The left side ball bearing is slip fit on the opposite end. To replace the spindle assembly remove the left side grinding wheel grip knob, square key and belt cover. See FIG. 1. Loosen the 4 socket head cap screws on the motor plate to remove the poly-V belt. Loosen the 2 set screws on the spindle pulley and remove the pulley, square key and pulley spacer. Push on the right hand side of the spindle assembly to compress conical washers so there is no pressure on the shaft retaining ring. Using a retaining ring pliers remove the small external retaining ring from the spindle assembly. You can now remove the spindle assembly out the right side by lightly tapping on the left end with a rubber mallet. The second ball bearing can be removed from the belt side of the Grinding Head Housing.

To reassemble place the 4 conical washers (2 Pair nested and then place the 2 pairs back to back) against the ball bearing on the new spindle assembly. See FIG. 2. Thoroughly clean the housing bore and the outside diameter of both bearings. **APPLY BLUE LOCTITE #243 TO THE OUTSIDE DIAMETER OF THE TWO BEARINGS.** Slide the spindle assembly into the right side of the Grinding Head Housing. Install the bearing sleeve against the bearing on the spindle assembly. Slip fit the new left side ball bearing onto the spindle assembly and into grinding head housing. Install the 9/16-18 Locknut onto the spindle shaft and using a spanner wrench on the right side of the spindle and a 7/8 deepwell socket on the left side, torque the locknut to 15 Ft. Lbs.

Replace the square key and install the new pulley pushing the counterbore side of the pulley against the locknut with no end play. **APPLY BLUE LOCTITE #243 TO THE BORE OF THE PULLEY BEFORE INSTALLATION. NEXT INSTALL BLUE LOCTITE #243 ON THE PULLEY SETSCREWS AND TIGHTEN THE TWO PULLEY SET SCREWS.** Then install the new external retaining ring on the spindle shaft. Next mount the new poly-V belt. (See Grinding Head Belt Tension and Alignment Adjustments in the adjusting section of the manual). Install the new belt cover gasket on the belt cover and install the belt cover and square key. Mount the left side grinding wheel grip knob with a slight gap to the cover and tighten the two set screws.





<u>DIAGRAM NUMBER</u>	<u>PART NUMBER</u>	<u>DESCRIPTION</u>
1 .....	B251411 .....	REF. Socket Head Cap Screw 1/4-20 x 7/8 Long
2 .....	B371611 .....	REF. Socket Head Cap Screw 3/8-16 x 1 Long
3 .....	C250620 .....	REF. Socket Set Screw Cup Point 1/4-20 x 3/8 Lg
4 .....	K250001 .....	REF. 1/4 Flat Washer SAE
5 .....	K251501 .....	REF. 1/4 Split Lockwasher
6 .....	K371501 .....	REF. 3/8 Split Lockwasher
7 .....	R000376 .....	REF. Square Key 1/8 x 3/4 Long
8 .....	3707690 .....	REF. 1 HP 120 VAC Motor
9 .....	3708193 .....	REF. Conical Washer 1.36 OD x .88 OD
10 .....	3708194 .....	REF. Internal Retaining Ring
11 .....	3708204 .....	**KIT Double Row Ball Bearing
12 .....	3708202 .....	**KIT Poly-V Belt
13 .....	6329089 .....	**KIT Bearing Sleeve
14 .....	6329041 .....	REF. Motor Mount Plate
15 .....	6329042 .....	REF. Pulley - Poly V 1.80 Diameter
16 .....	6329043 .....	**KIT Pulley - Poly V 1.44 Diameter
17 .....	6509018 .....	REF. Grinding Head Housing
18 .....	J567200 .....	**KIT 9/16-18 Locknut Nylon Insert Jam
19 .....	6329523 .....	**KIT Grinding Head Spindle Assembly
20 .....	6509237 .....	REF. Grinding Wheel Knob
21 .....		REF. Grinding Wheel (see manual)
22 .....	6509210 .....	**KIT Belt Cover Gasket (Not Shown)
23 .....	3708870 .....	**KIT Retaining Ring - External .50 Shaft
24 .....	3708892 .....	**KIT Loctite #243 - 0.5 ML Capsule (Not Shown)