

REMOVING THE APRON AND LEADSCREW FROM THE GN1324 & GN1339

The apron and leadscrew can be removed from the machine as individual items or as a single unit then separated later. Have the owner's manual available when doing any machine maintenance. The items referenced in these instructions can be found in the parts section of the owner's manual. MAKE SURE THE MACHINE IS UNPLUGGED BEFORE ANY DISASSEMBLY IS STARTED.

LEADSCREW REMOVAL

1. Disengage the half nut and place all powerfeed controls on neutral.
2. Position the carriage close to the center of the machine bed.
3. Remove the two screws (G01-016) from the right hand leadscrew support (G01-022).
4. Drive the taper pin out of the left end of the leadscrew. This pin is larger on one end than it is on the other, be sure to drive it out from the small end toward the large end.
5. Rotate the leadscrew so the key slot is facing downward. This will keep the wormgear key (G09-006) from falling out of place when the leadscrew is pulled from the apron.
6. Pull the leadscrew out of the apron. If the leadscrew is stuck in the apron, the apron and leadscrew can be taken off together.

APRON REMOVAL

The crossfeed table covers the screws that hold the apron to the carriage. Part of this section involves moving the table back to gain access to these screws.

1. Remove the two screws (G08-007) that mount the front crossfeed screw support (G08-034) to the table.
2. Separate the table from the support and push the table back far enough to expose the four screws that hold the apron to the carriage.
3. Remove the four mounting screws and drop the apron off the bottom of the carriage.

INSTALLATION

It is best to put the leadscrew into the apron before installing the apron on the machine because it is easier to make sure the worm gear drive key (G09-006) is in place while inserting the leadscrew. A coating of grease on the key and the inside of the worm gear will also help hold the key in place during assembly. The remainder of the installation is a reversal of the removal instructions above.