

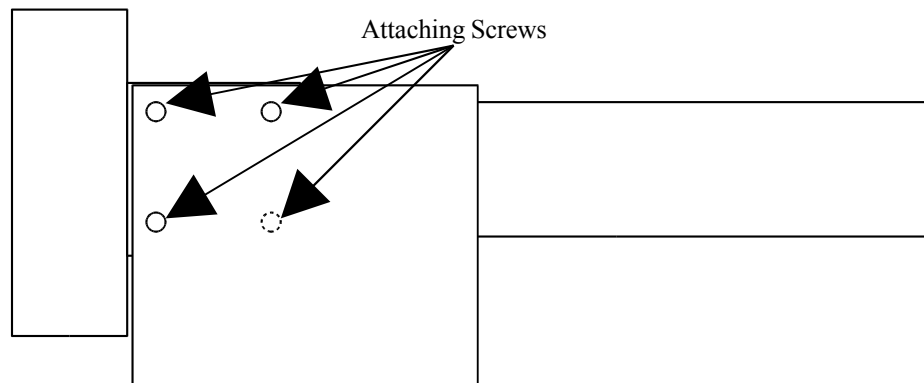
REPLACING THE BEVEL GEAR GN1324 & GN1339

To replace the bevel gear (G05-003), it is necessary to remove the mill head and column. These two sections are best removed together as one unit. 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.**

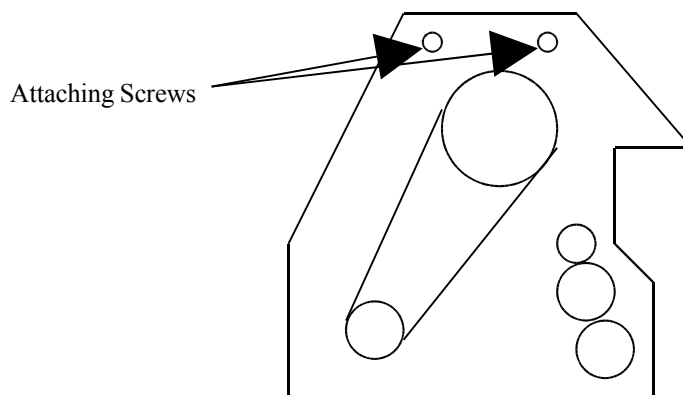
The mill head and column together weigh about 125 pounds. It is recommended that a hoist or other similar device be used to raise the assembly of the machine.

REMOVING THE HEAD AND COLUMN ASSEMBLY

1. Rotate the mill head 45 degrees from the centerline of the lathe to gain access to the 4 cap screws holding the column to the lathe head. **DO NOT REMOVE THESE SCREWS YET.**



2. Open the pulley box door and there are two screws at the top of the box on the inside that must be removed.



REMOVING THE HEAD AND COLUMN ASSEMBLY – CONTINUED-

3. Make sure the mill head is in the lowest position and securely locked in place. This will keep the bearings (G05-020) from slipping out of place if the head is tilted while being removed from the machine.
4. Place a lifting strap around the mill head.
5. Remove the four securing screws referenced in step 1 and lift the head and column off the machine.
6. The bevel gear is held onto the end of the column shaft by one screw, a washer and a square key.
7. After the gear is replaced, the assembly is the reverse of the above procedure. Rotate the column shaft while lowering the assembly onto the lathe head to assure the bevel gears line up properly.

ADJUSTING THE BEVEL GEAR CLEARANCE

Once the machine is reassembled, the clearance between the bevel gears must be adjusted. See the separate instruction sheet “Bevel Gear Adjustment-GN1324 & GN1339”.