

Spindle Break-In Procedure

When installing new or reconditioned work spindles and bearings there is a break-in procedure that should be followed to insure proper bearing life.

Following this step by step procedure should be completed while the machine is NOT making parts.

- 1.** Install a CJB-4 Lube fitting Davenport part #2446-87.
- 2.** Install a 60 tooth feed gear to insure proper oiling to each work spindle at 75 cycle (2.4 seconds).
- 3.** Install 900 RPM spindle gears and run your machine for 2 hours.
- 4.** Install 1500 RPM spindle gears and run the machine for an additional 2 hours.
- 5.** Install 2000 RPM spindle gears and run the machine for 6 hours.
- 6.** Install spindle gears to run the machine between 2500 and 3000 RPM's for 6 more hours.

After this break-in procedure has been followed step by step, you can install the proper speed and feed gears for your job.

CAUTION!

During this procedure you SHOULD monitor the spindle temperature!

The spindles should run warm to work harden the bronze. Excessive heat will cause the spindle to seize.

Following this procedure will ensure longer spindle life and less maintenance downtime. Many customers are not aware that a break-in is recommended. Be sure to review this procedure with your maintenance department.

Our knowledgeable and courteous sales staff at National Manufacturing Supply Corporation (NATMAN) is ready to assist you. Please give us a call Toll Free: 800-345-5512