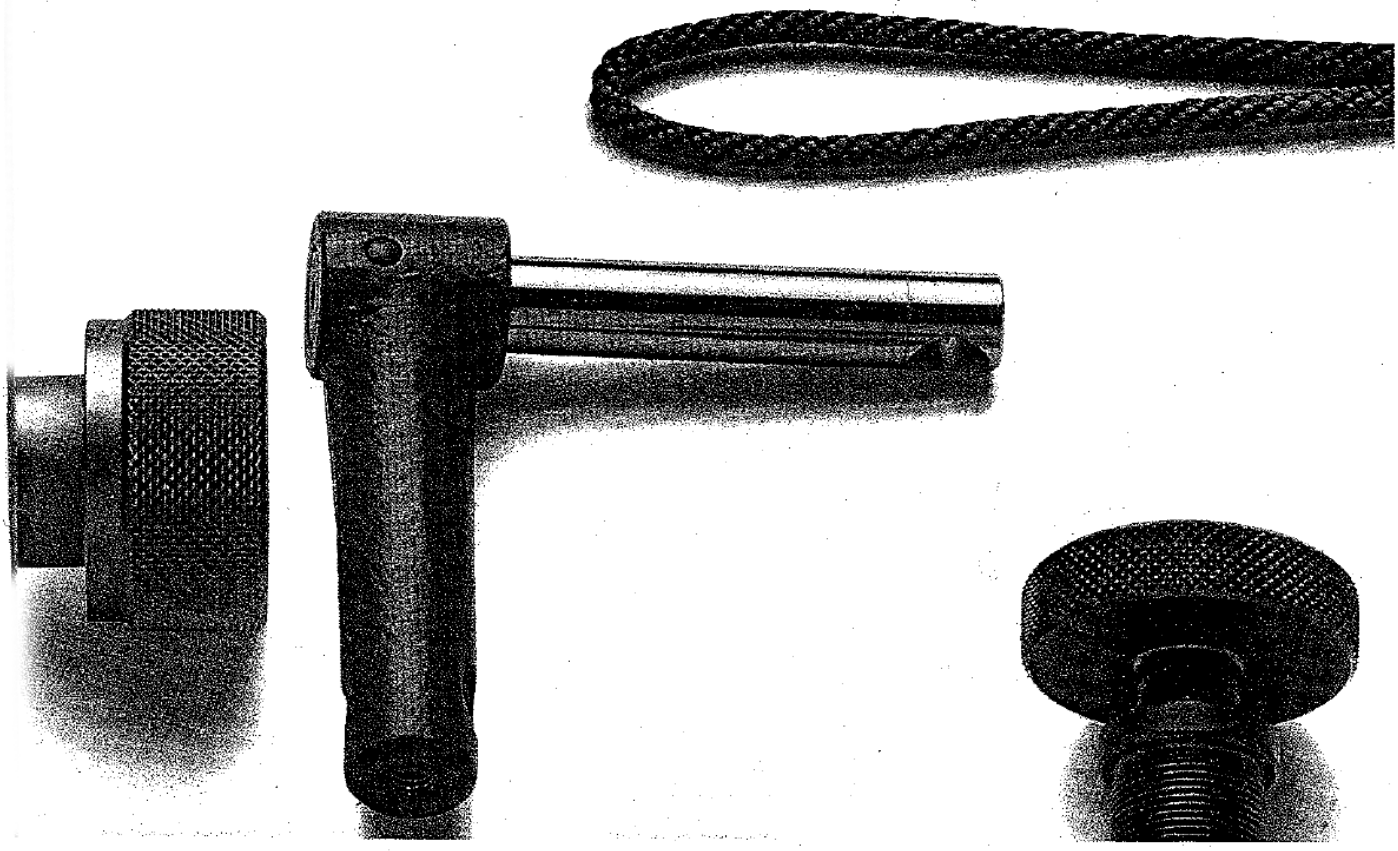
MICHAEL DECKEL

Spare Parts
Single Lip Cutter Grinder
S0



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A GTI Technologies Company
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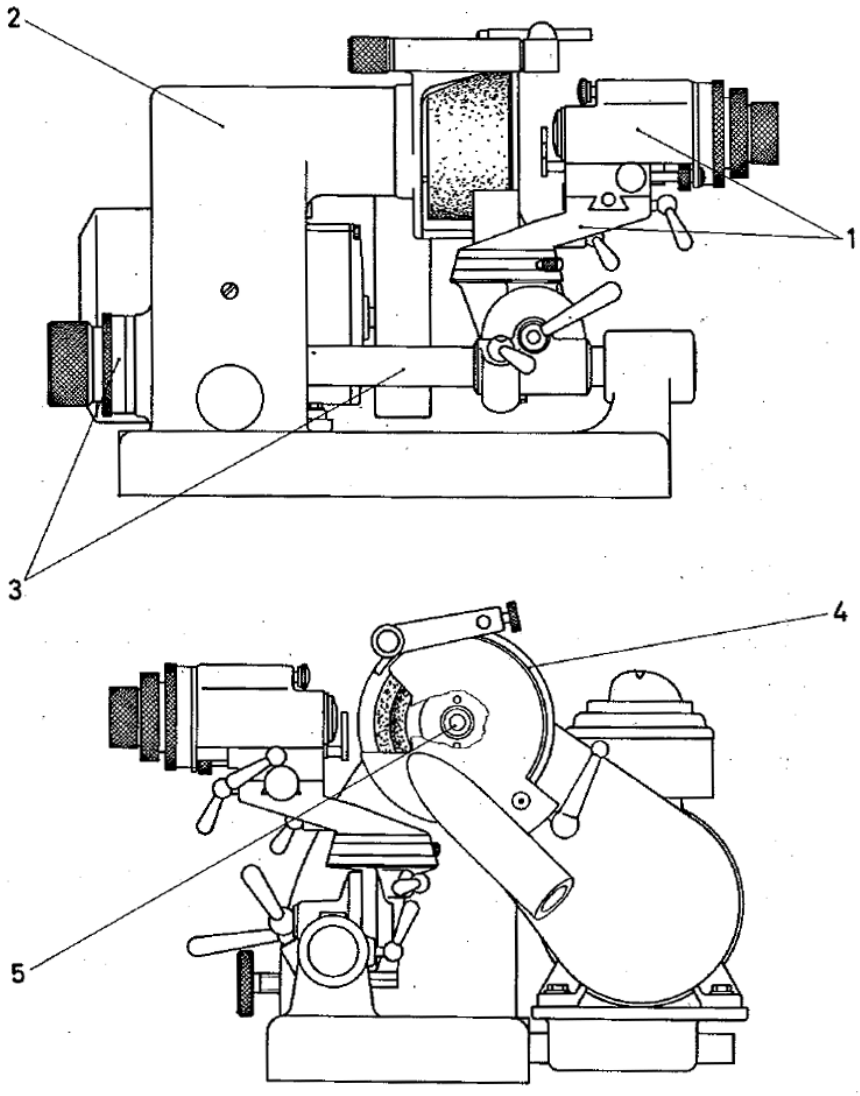
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THIS SPARE PARTS LIST IS FOR MACHINE NO _____

It should be placed at the disposal of those persons who are responsible for properly operating and servicing the machine.

Identification of Main Assemblies



1 Index head bracket

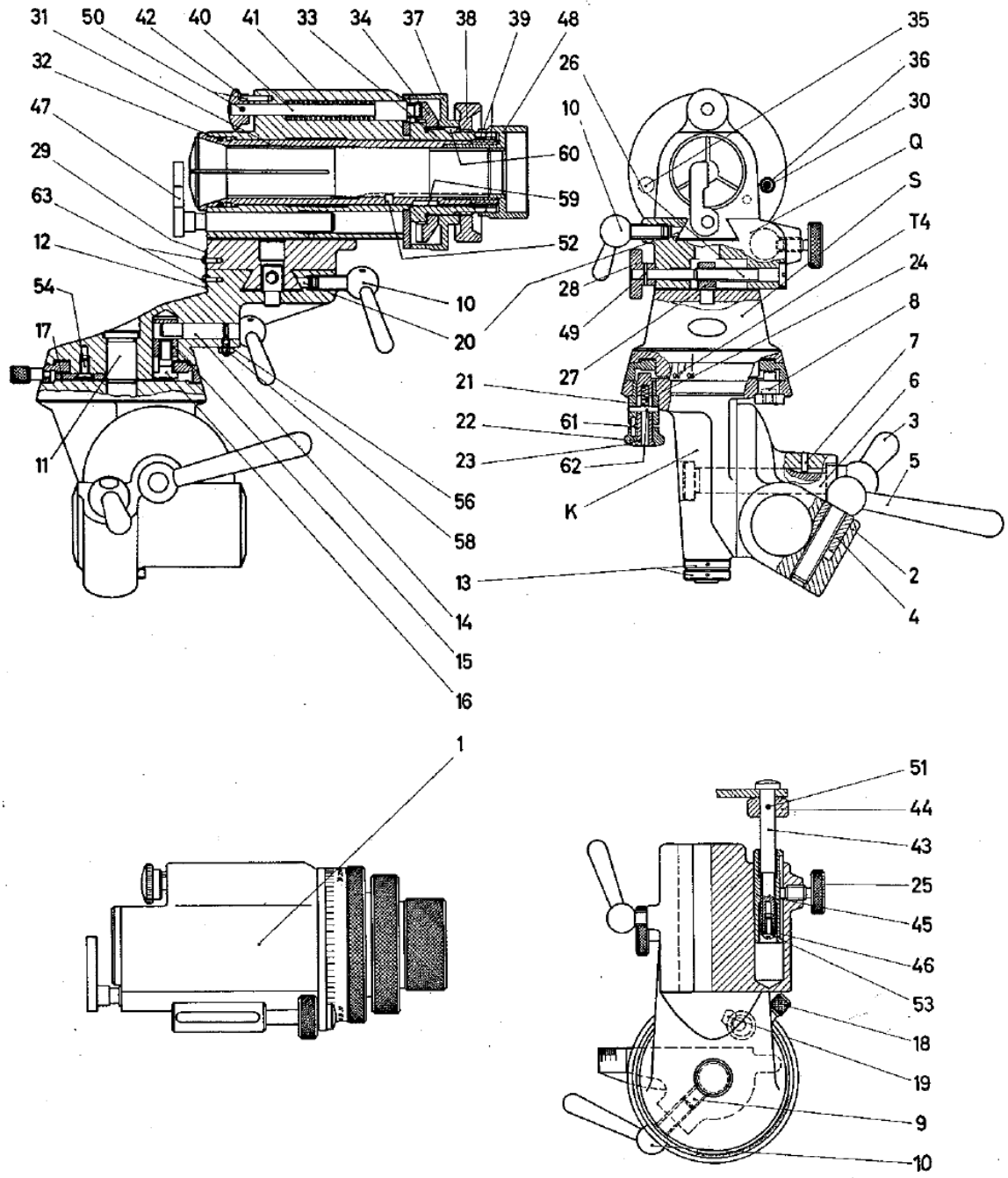
2 Housing

3 Main axle – fine adjustment mechanism

4 Wheel guard with wheel dressing attachment

5 Grinding wheel spindle

SO Index Head Bracket



Please quote serial number of machine when ordering spare parts

Index Head Bracket

Index head slide

Remove knurled screw 25 and take off index head slide 1.

Collet sleeve bearing

Screw off knurled nut 38, remove scale drum 37 and index plate 34. Screw off slotted nuts 39, pull off sleeve 33, remove key 59, and pull out collet sleeve 31 in a forward direction. To reassemble the parts, reverse the above procedure, eliminating play of 31 by means of nuts 39.

Index pin

Knock out pin 50, pull off knurled knob 42, remove index pin 40 and compression spring 41. To reassemble the parts, reverse this procedure. When replacing index pin 40, drill bore for pin 50 from 42, watching that 40 engages index plate 34 and that 42 is in engagement in a vertical position.

Fine adjustment mechanism

Remove screw 53 and washer 46, screw off nut 45, knock out pin 51, and force adjuster screw 43 out of knurled ring 44. To reassemble, reverse this procedure. When replacing 43, drill new hole for pin 51.

Cross slide

Knock out taper pin 49, pull off knurled knob 28, and screw out traversing screw 26. Do not knock out screw nut unless it has to be replaced. Push in new screw nut and tap from cross slide Q. To reassemble remaining parts, reverse the above procedure.

Clamping mechanism of index drum T4

Screw off ring nuts 13 and remove index head bracket from base K. Loosen nut 58, screw out set screw 56 and pull out eccentric pin 14, remove countersunk screw 54, take off stop plate 17, index drum T4 and locking screw 16 with locking pin 15. If required, advance 15 one-half turn clockwise, then reassemble by reversing the above procedure. Note: insert index drum T4 in such a way that stop pin 19 is positioned between 16 and 17. Swivel arm S must be parallel to the bore in 2 when mounted. Use 13 to eliminate play of index head bracket.

Adjusting the 90° swivel motion

Rotate eccentric sleeve 21 (with knurled knob 23 engaged) to correct the zero setting of swivel arm S. The 90° swivel motion can be adjusted by rotating eccentric pin 8.

Adjusting the clamping action of clamp 5

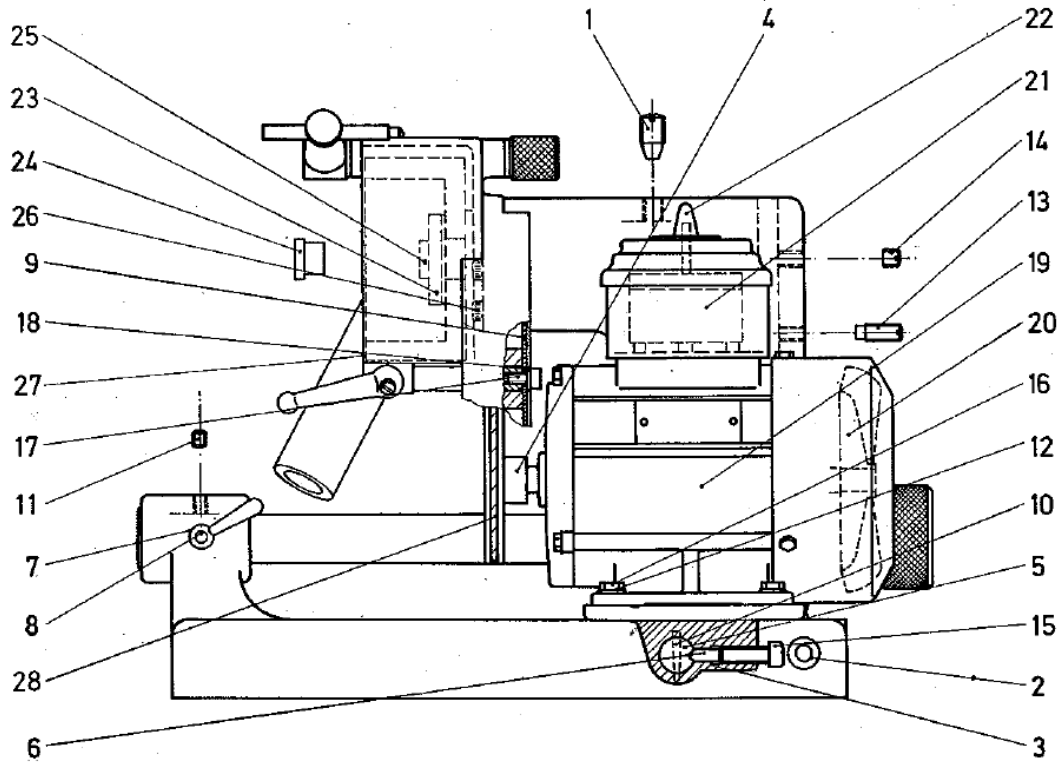
Loosen set screw 57, turn screw 3 clockwise, and reclamp by means of 57.

Parts not listed in the above table are not available as spare parts for technical reasons.

No.	Part Name	Stock No.	Remarks
	Index head bracket ass'y	0501100	green RAL 6011**
	Index head bracket ass'y	0501150*	green RAL 6011**
1	Index head slide ass'y	0506100	green RAL 6011**
1	Index head slide ass'y	0506150*	green RAL 6011**
2	Adapter plate	0501116	
3	Clamping lever	0501509	
4	Clamping sleeve	0501306	
5	Clamping lever	0501409	
6	Clamping screw	0501616	
7	Guide pin	8012330	
8	Eccentric pin	0502206	
9	Thrust pin	0502306	
10	Clamping lever	0502509	
11	Pin	0503206	
12	Scale	0503309	
12	Scale	0503359*	
13	Ring nut	0503406	
14	Excenter lever	0503509	
15	Locking pin	0503706	
16	Locking screw	0503806	
17	Stop plate	0503906	
18	Knob	0504206	
19	Stop pin	0504306	
20	Thrust pin	6007306	
21	Eccentric sleeve	1502506	
22	Stop pin	1502606	
23	Knurled knob	0502806	
24	Compression spring	0504809	
25	Knurled screw	0505206	
26	Traversing screw	0505306	without pin hole
27	Screw nut	0505409	w/o tapped hole
28	Knurled knob	0505506	without pin hole
29	Vernier	0505809	
29	Vernier	0505859*	
30	Plug	0506406	
31	Collet sleeve	0506608	State diameter, e.g. 25,993 mm or 1.0234"
32	Felt ring	0506709	
33	Sleeve	0506806	
34	Index plate	0506904	ass'ed with 35 & 36
35	Stop pin	0507106	
36	Stop pin	0507206	
37	Scale drum	0507306	
38	Knurled nut	0507406	
39	Slotted nut	0507506	
40	Index pin	0508006	without pin hole
41	Compression spring	0508109	
42	Knurled knob	0508206	without pin hole
43	Adjuster screw	0508506	without pin hole
44	Knurled ring	0508606	without pin hole
45	Nut	0508706	
46	Washer	0508806	
47	Locating gauge	0509004	
48	Draw-in screw	1507206	
49	Taper pin	8202020	1,5 x 8 DIN 1
50	Cylindrical pin	8204160	2 x 12 DIN 7
51	Cylindrical pin	8204200	2 x 16 DIN 7
52	Cylindrical pin	8204240	3 x 4 DIN 7
59	Key	8287040	4 x 3 x 10 DIN 6885
60	Woodruff key	8288020	2 x 2,6 DIN 6888
61	Cylindrical pin	8204140	2 x 8 DIN 7
62	Grooved pin	8269020	2 x 12 DIN 1472
63	Spring dowel pin	8271020	1,4 x 4 DIN 1476

* Inch version ** special colour Aditinalprice

SO Housing - Tensioning and Replacing the Belt



No.	Part Name	Stock No.	Remarks
1	Set Screw	0511206	
2	Cable sleeve	0511309	
3	Motor base plate	0511606*	for 11 mm (7/16") motor shaft dia.
	Motor base plate	0511506*	for 14 mm (9/16") motor shaft dia.
4	Motor pulley	0512504	50 c/s; 11 mm shaft dia.
	Motor pulley	0512604	60 c/s; 11 mm shaft dia.
	Motor pulley	0612004	50 c/s; 14 mm shaft dia.
	Motor pulley	0612104	60 c/s; 14 mm shaft dia.
5	Rod	0513006	without pin hole
6	Thrust member	0513106	
7	Thrust pin	0518306	
8	Clamping lever	0518509	
9	Guard plate	0520606	
10	Taper pin	8202100	4 x 32 DIN 1
11	Set screw	8231260	M6 x 6 DIN 551
12	Washer	8213080	6,4 DIN 125
13	Set screw	8218040	M6 x 15 DIN 417
14	Set screw	8231260	M6 x 6 DIN 511
15	Hex socket screw	8246540	M8 x 25 DIN 912
16	Hexagon screw	8254140	M6 x 18 DIN 933
17	Hex socket screw	8246300	M6 x 12 DIN 912
18	Washer	8084060	
19	Motor	800xxxx	State voltage & frequency
	Ball bearing		State motor type
20	Fan		State motor type
21	Switch assembly		State motor type
	Relay		only for Siemens AC motor
22	Control handle		State motor type
28	Drive cord	0529509	50 c/s motor
	Drive cord	0529609	60 c/s motor

* green RAL 6011
special colour extra charge

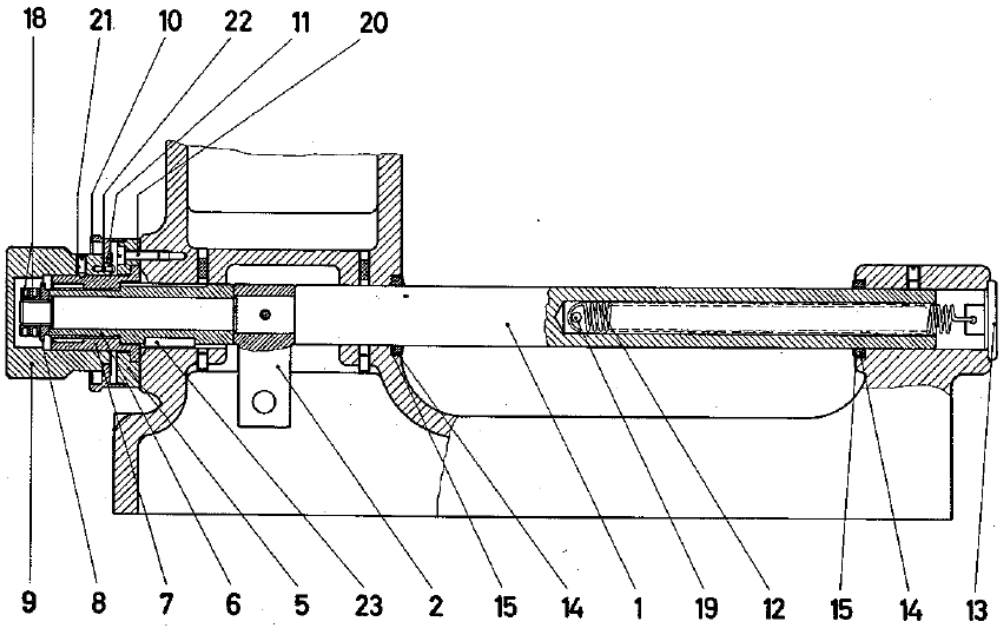
Tensioning the belt

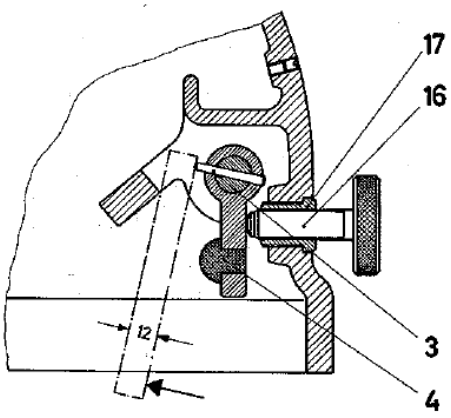
Loosen hex socket screw 15, tension the belt by moving motor base plate 3, then clamp 3 by means of 15.

Replacing the belt

Loosen 15 and 3. Screw off nut 25, loosen wheel mount 23 by means of extrator nut 21, remove 23. Remove hex socket screw 17 and remove guard plate 9.
Remove hex socket screw 26 and take off wheel guard 27.
Replace belt and reassemble the parts, reversing the above procedure.

Main Axle - Fine Adjustment Mechanism





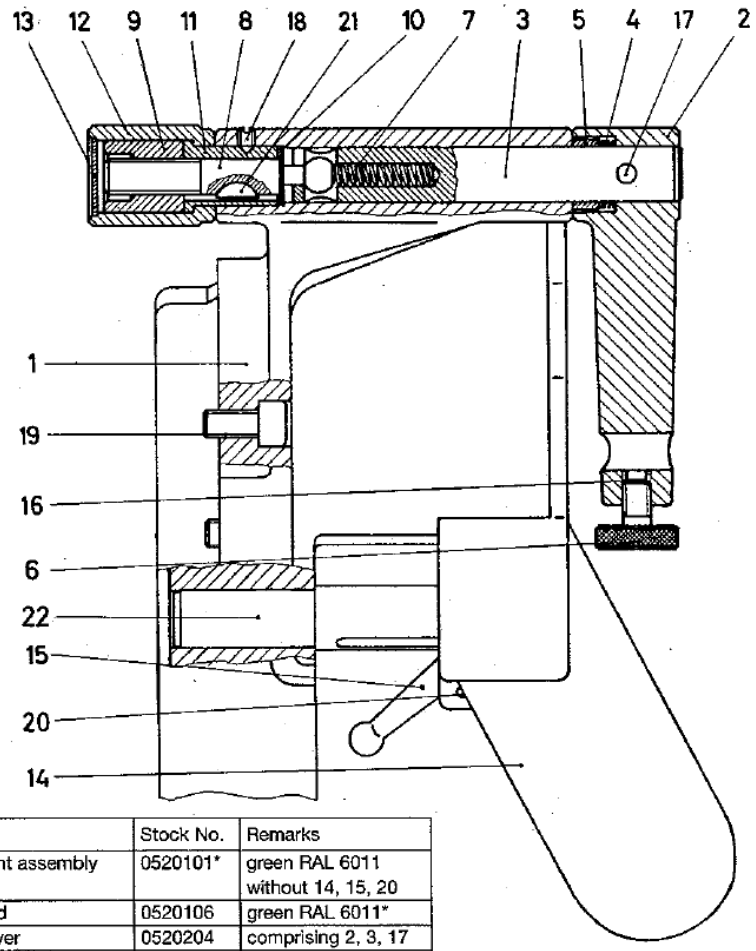
Fine adjustment mechanism

Screw off set screw 21 and pull off knurled knob 9 with scale ring 10. Screw off ring nuts 18 and remove washer 8. Remove rubber pad 4, loosen taper pin 3 by means of auxiliary tool (see detail above), then remove 3 downwards and push main axle 1 to the right. Remove cylindrical screws 20, take off retaining ring 5 and threaded pin 6 with nut 7. To reassemble the parts, reverse this procedure, using 18 to eliminate play in swivel motion of main axle.

No.	Part Name	Stock No.	Remarks
	Main axle assembly	0515104	comprising 1, 2, 3
1	Main axle	0515106	without pin hole
2	Driver	0515206	
3	Taper pin	8202080	4 x 28 DIN 1
4	Rubber pad	0515309	
	Retaining ring ass'y	0515504	comprising 5, 6, 7
	Retaining ring ass'y	0515554*	comprising 5, 6, 7.
5	Retaining ring		not available individ.
	Threaded pin ass'y	0515604	comprising 6, 7
	Threaded pin ass'y	0515654*	comprising 6, 7
6	Threaded pin		not available
7	Nut		individually
8	Washer	0515806	
9	Knurled knob	0516006	
10	Scale ring	0516106	
10	Scale ring	0516156*	
11	Spring	0516206	
12	Tension spring	0516509	
13	Cap	0516606	
14	Felt ring	0517109	
15	Felt ring cap	0517206	
16	Screw	0518006	
17	Collar sleeve	0518106	
18	Ring nuts	0503406	
19	Cylindrical pin	8292020	4 x 22 DIN 7343
20	Cylindrical screw	8206320	M4 x 16 DIN 84
21	Set screw	8232120	M4 x 8 DIN 553
22	Grooved pin	8271040	2 x 5 DIN 1476
23	Key	8287120	5 x 5 x 20 DIN 6885

* Inch version

SO Wheel Guard and Wheel Dressing Attachment



No.	Part Name	Stock No.	Remarks
	Wheel mount assembly	0520101*	green RAL 6011 without 14, 15, 20
1	Wheel guard	0520106	green RAL 6011*
2	Dressing lever	0520204	comprising 2, 3, 17
3	Axle	0520206	without pin hole
4	Compression spring	0520409	
5	Retaining ring	0520506	
6	Knurled screw	0520806	
7	Compression spring	0522009	
	Spindle	0522104	comprising 8, 9, 10, 11, 12, 13, 18
8	Spindle	0522106	
9	Nut	0522206	
10	Washer	0522309	
11	Collar sleeve	0522406	
12	Knurled sleeve	0522506	
13	End plate	0522606	
	Exhaust funnel assembly	0523504	comprising 14,15,20
14	Exhaust funnel	0523506	
15	Clamping lever	1504009	
16	Pressure pad	1522306	
17	Taper pin	8202060	4 x 20 DIN 1
18	Set screw	8232080	M4 x 5 DIN 553
19	Hex socket screw	8246360	M6 x 20 DIN 912
20	Cylindrical pin	8282100	4 x 10 DIN 6325
21	Woodruff key	8288040	2 x 3,7 DIN 6888
22	Pin	0522806	

* green RAL 6011
special colour extra charge

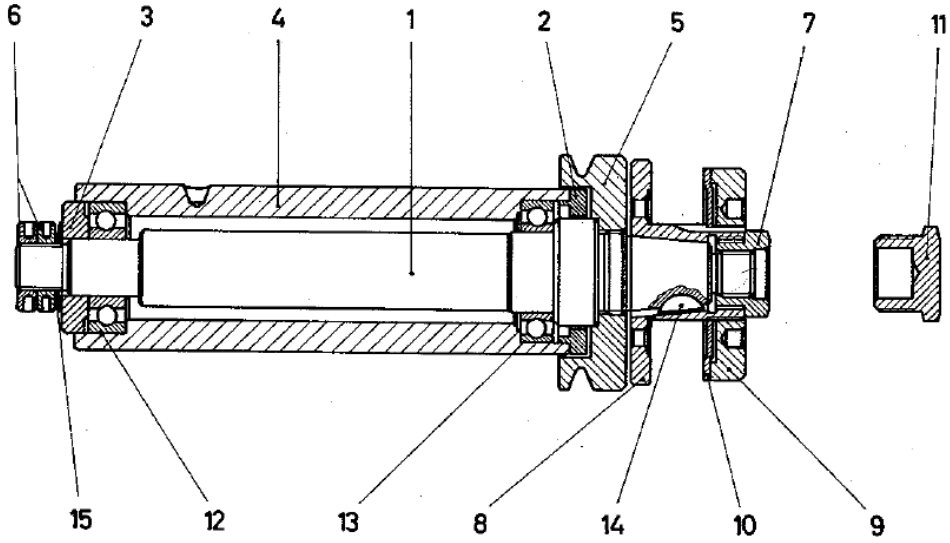
Disassembly

Remove set screw 16 and screw out knurled sleeve 12 with nut 9 and collar sleeve 11. Remove Woodruff key 18 and pull out dressing lever 2 with axle 3 and spindle 8 (watch for washer 10). Force end plate 13 and nut 9 out of knurled sleeve 12 by means of collar sleeve 11.

Reassembly

Insert 11 into 12. Press in 9 until 11 is seated free of play, but still easily rotatable. Then press in 13. To reassemble the other parts, reverse the above procedure.

Grinding Wheel Spindle



Removing the spindle

Screw off nut 7 and nut 9 and remove grinding wheel. Take off wheel guard, remove set screw 1 (see under "Housing") and pull spindle assembly out of bore in housing.

Removing the pulley

Clamp spindle assembly on a vice, gripping the pulley (use soft jaws). Turn wheel mount 8 anticlockwise by means of face pin spanner: this will loosen the pulley 5 (left-hand thread).

Disassembling the spindle assembly

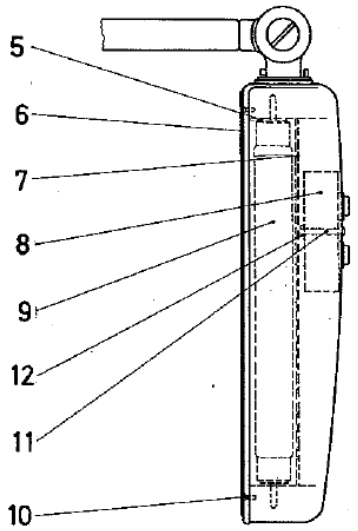
Screw off ring nuts 6, remove cup springs 15 and cap 3, and pull out wheel spindle in a forward direction. Push out ball bearings 12 and 13, applying pressure from the inside (handle with care, do not use hammer). Ring 2 will come off together with 13.

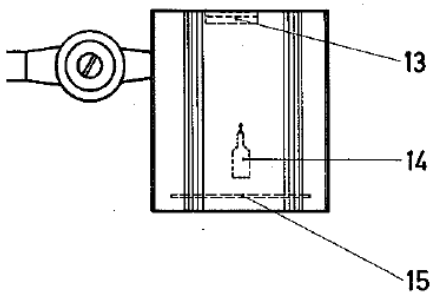
Reassembly

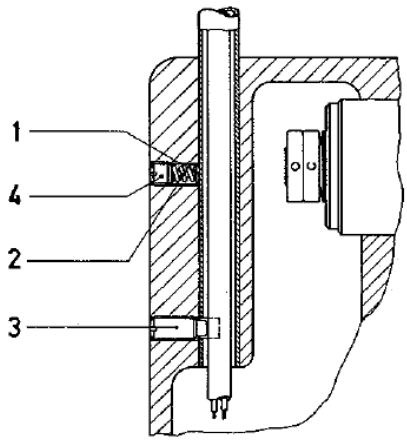
Clean and lubricate bearings 12 and 13. Push in bearings, applying pressure to outer races. Then reassemble by reversing the above procedure.
Note: advance first ring nut 6 up to contact with untensioned cup springs, then preload by advancing nut another 1/8 to 1/4 turn and lock by second ring nut 6.

No.	Part Name	Stock No.	Remarks
	Wheel spindle ass'y	0528100	complete
1	Wheel spindle	0528106	
2	Ring	0528206	
3	Cap	0528306	
4	Spindle sleeve	0528406	
5	Pulley	0528606	
6	Ring nut	0503406	
7	Nut	1512006	
	Wheel mount ass'y	1512504	comprising 8, 9, 10
8	Wheel mount	1512506	
9	Nut	1512706	
10	Tab washer	1512806	
11	Extractor nut	1512606	
12	Ball bearing	8233020	6001 DIN 625
13	Ball bearing	8233220	61903 DIN 625
14	Woodruff key	8288060	3 x 3,7 DIN 6888
15	Cup spring	8024110	CB 607 ng.

SO Machine Lamp - Articulated Machine Lamp - Halogen Machine Lamp







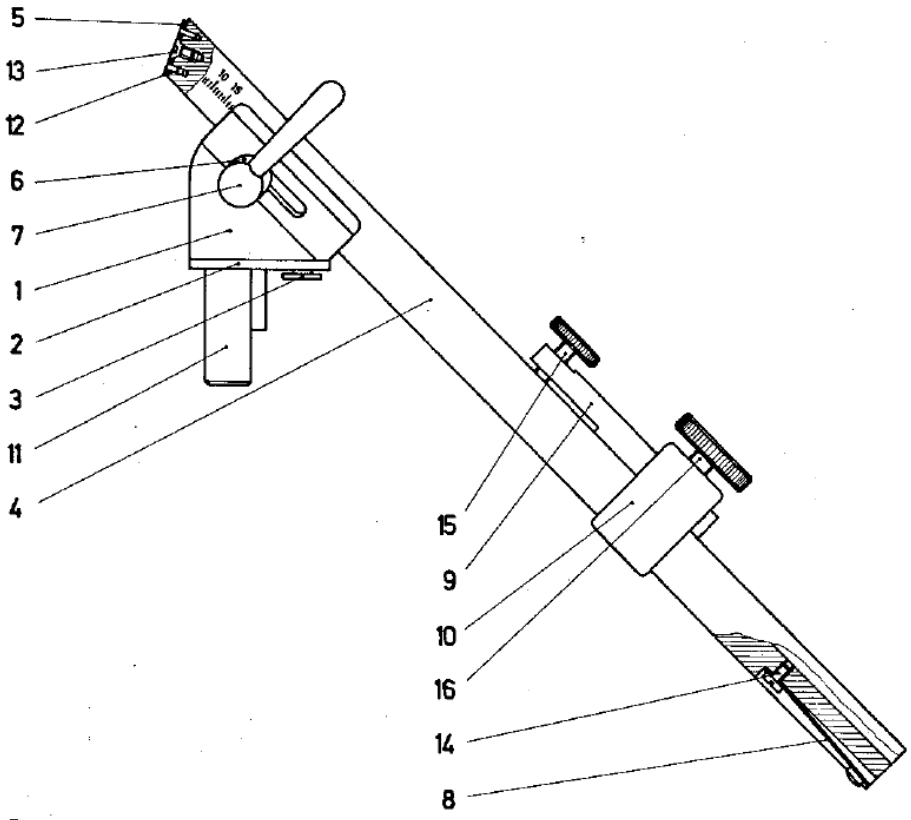
No.	Part Name	Stock No.	Remarks
1	Pressure pad	0535309	
2	Compression spring	0535409	
3	Set screw	8218040	
4	Set screw	8231260	
	Articulated machine lamp 220 Volt	0540300	
	Articulated machine lamp 110 Volt	0540100	
5	Retaining plate		for 0540300/0540100
6	Mask	8003010	
7	Reflector		for 0540300/0540100
8	Starting switch	8021280	
9	Flourescent lamp	8013130	
10	Flat head screw	8207020	M3 x 6 DIN 85
11	Cylindrical srew		M3 x 18 DIN 84
12	Nut	8255020	M3 DIN 934
	Halogen machine lamp 220 Volt 12 V	0540400	
	Halogen machine lamp 110 Volt 12 V	0540200	
13	Switch for halogen lamp	8021200	
14	Halogen filamint lamp 12 V 20 W	8013120	
15	HP-Substitute glass	8021910	

Fluorescent tube lamp 0540300/0540100

Remove screws 10, mask 6, retaining plate 5, fluorescent tubes 9, and reflector 7. Remove screw 11, mark lead wires, and take out starter switch 8. For reassembly, reverse this procedure.

Twist Drill Grinding Attachment

SO

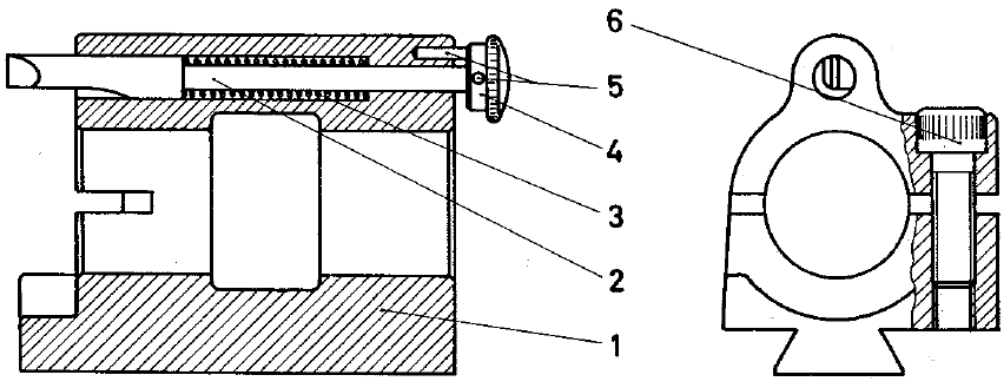


For replacement of stop plate 2, pull out stop pin 3 (press fit).

No.	Part Name	Stock No.	Remarks
	Twist drill grinding attachment assembly	0545100	
	Twist drill grinding attachment assembly	0545150*	
1	Holder	0545206	
2	Stop plate	0545404	
3	Stop pin	0545606	
4	Swivel-mounted V-guide	0545706	
4	Swivel-mounted V-guide	0545756*	
5	Gauge plate	0545806	
6	Ball socket	0546009	
7	Clamping lever	0546109	
8	Leaf spring	0546504	
9	Stop	0546806	
10	Ring	0546906	
11	Cylindrical pin	8204800	12 x 50 DIN 7
	Cylindrical pin	0547056*	
12	Cylindrical pin	8204020	1,2 x 4 DIN 7
13	Countersunk screw	8259060	M3 x 6 DIN 963
14	Flat head screw	8206100	M3 x 5 DIN 84
15	Knurled screw	8235020	M4 x 16 DIN 653
16	Knurled screw	8235040	M6 x 16 DIN 653

* Inch version

SO Spindle Assembly Locating Fixture

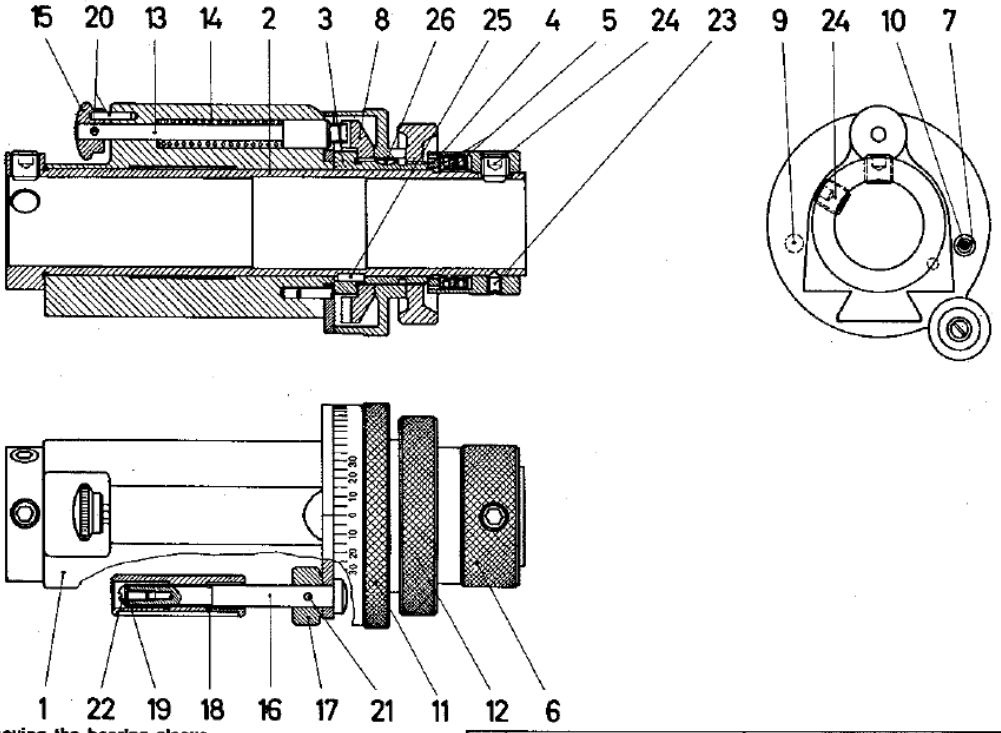


No.	Part Name	Stock No.	Remarks
	Spindle locating fixture assembly	0541100	green RAL 6011*
1	Bracket	0541106	green RAL 6011*
2	Index finger	0541506	
3	Compression spring	0508109	
4	Knurled knob	0508206	
5	Cylindrical pin	8204160	2 x 12 DIN 7
6	Hex socket screw	8246540	M8 x 25 DIN 912

* special colour Aditinalprice

Spindle Assembly Special Locating Fixture

SO



Removing the bearing sleeve

Loosen set screws 23 and 24, pull off clamping ring 6. Remove nuts 5 and thrust ring 4. Pull off sleeve 3 with index plate 8, scale ring 11 and knurled nut 12. Take out key 25 and pull out bearing sleeve 2 in a forward direction. To reassemble the parts, reverse the above procedure, eliminating play of 2 by means of 5.

Index finger

Knock out pin 20, pull off knurled knob 15, remove index finger 13 and compression spring 14. For reassembly, reverse this procedure. When replacing index finger 13, drill pin hole for 20 through 15, taking care that 13 is in engagement with index plate 8 and that 15 is engaged in a vertical position.

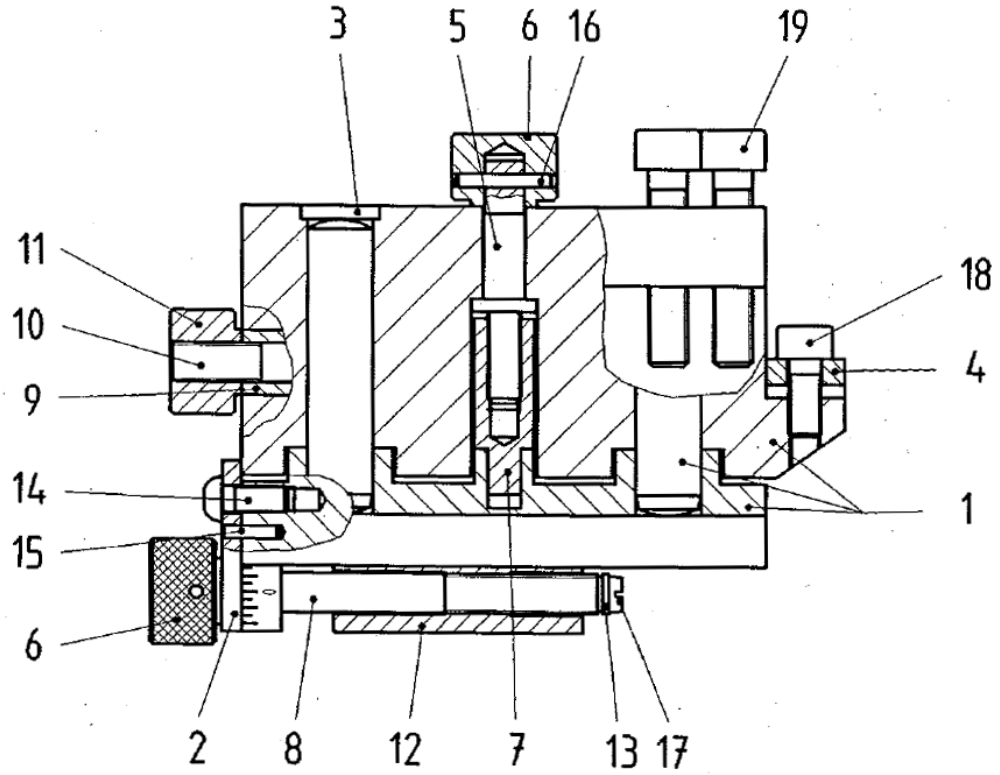
Fine adjustment mechanism

Remove screw 22 and washer 19, screw off nut 18, knock out pin 21, and pull off knurled 17. For reassembly, reverse this procedure. When replacing adjuster screw 16, drill pin hole for 21 through 17.

No	Part Name	Stock No.	Remarks
	Sp. spec. locating fixture ass'y	0542100	green RAL 6011**
	Sp. spec. locating fixture ass'y	0542150*	green RAL 6011**
1	Bracket	0542106	green RAL 6011**
2	Bearing sleeve	0542306	
2	Bearing sleeve	0542356*	
3	Sleeve	0542406	
4	Thrust ring	0542506	
5	Nut	0542606	
6	Clamping ring	0542706	
7	Plug	0506406	
8	Index plate	0506904	ass'd with 9 & 10
9	Stop pin	0507106	
10	Stop pin	0507206	
11	Scale ring	0507306	
12	Knurled nut	0507406	
13	Index finger	0508006	without pin hole
14	Compression spring	0508109	
15	Knurled knob	0508206	without pin hole
16	Adjuster screw	0508506	without pin hole
17	Knurled ring	0508606	without pin hole
18	Nut	0508706	
19	Washer	0508806	
20	Cylindrical pin	8204160	2 x 12 DIN 7
21	Cylindrical pin	8204200	2 x 16 DIN 7
22	Cylindrical screw	8206120	M3 x 6 DIN 84
23	Set screw	8232100	M4 x 6 DIN 553
24	Set screw	8247060	M8 x 8 DIN 913
25	Key	8287020	A3 x 3 x 8 DIN 6885
26	Woodruff key	8288020	2 x 2,6 DIN 6888

* Inch version ** special colour Aditinalprice

SO Tool Holder



No.	Part Name	Stock No.	Remarks
1	Tool Holder	1508004	
2	Shett	1508506	
3	Cover sheet	1508606	
4	Clamping pad	1508706	
5	Spindle	1508806	
6	Knurled knob	1508906	
7	Screw nut	1509006	
8	Adjuster screw	1509106	
9	Preassure pad	1509206	
10	Clamping pin	1509306	
11	Cnurled nut	1509406	
12	Nut	0508706	
13	Washer	0508806	
14	Oval head screw	8013300	Hex socket M4 x 10
15	Cylindrical pin	8204140	DIN 7 2 x 8
16	Cylindrical pin	8204180	DIN 7 2 x 14
17	Cylindrcal screw	8206120	DIN 84 M3 x 6
18	Hexagon screw	8246160	DIN 912 M5 x 10
19	Hexagon screw	8246400	DIN 912 M5 x 30