5. Undo completely the three screws 2020.06020 securing the support 70-30.604 to the headstock frame and remove the entire quick-closing attachment.
6. Undo the four screws 2020.05016 and remove the cover 70-31.021.
7. Unlock the two stop screws 2037.05010 holding the nut 70-36.031 and unscrew this.
8. Undo the three screws 2020.05010 of the baffle plate 70-31.017.
9. Remove the screw 70-31.006 of the pulley 70-31.020.
10. Drive out the spindle 70-31.016 from the rear with a plastic hammer.
11. Remove the bearings.

SETTING THE BEARING PRELOAD

The fitting of the headstock with freshly lubricated or new bearings is carried out in the reverse order to dismantling (see previous section, items 11 to 7).

Turn the nut 70-36.031 until there is no more play between the bearings.

Then preload the bearings by advancing the nut by 10/1000 mm.

The rotation corresponding to this amount of advance is calculated as follows :

Pitch of nut = 1 mm

Preload = 10/1000 mm

Rotation of nut : $\frac{1 \times 360 \times 10}{1000} = \underline{3.6^{\circ}}$

Measured on the circumference of the nut, this gives a movement of :

$$\frac{\varnothing 45 \times \pi \times 3.6}{360} = \underline{\underline{1.41 \text{ mm}}}$$

Following this adjustment complete the fitting of the headstock. (See items 6 to 1).

SPINDLE LOCKING DEVICE

The piston 70-30.012 may be engaged in any of the holes in the side of the pulley 70-31.020 with the aid of the knurled knob 70-31.022 (or 70-37.002), thus allowing the spindle to be locked at will.