



Setting Spindle Oiler - Collet

- 1) Make sure the area around the nose of the spindle is clear of material or obstructions.
- 2) Remove the collet nut, collet and cutter from spindle.
- 3) Make sure 80-100 psi of air is at the machine.
- 4) Jog spindle to the center of the table.
- 5) Using MDI mode enter a spindle speed of 3600 rpm.
- 6) Manually turn spindle on.
- 7) Set air pressure going to the spindle oiler at 40 psi.
- 8) On top of the spindle oiler there are (2) adjustment screws, (1) on either side of the bulb.
 1. Oil Feed – located on left side of bulb.
 2. Air By-pass – located on right side of bulb.
- 9) Use an allen key to adjust the oil feed to 25-30 drops of oil per minute (a drop every 2 seconds).
- 10) Use an allen key to adjust the air by-pass so the oil drop falls straight down.

Checking Oil at Spindle

- 1) With the spindle still running, jog spindle to a position that you can safely reach the oil line.
- 2) The oil line is located on the right side of the spindle and is a black, 3/8" line.
- 3) Compress the push lock fitting and remove the line.
- 4) Hold the line up to a light and look for an oil mist coming from the end of the line.
 1. Another way is to direct the line to a piece of paper. The oil will lightly wet the paper.
- 5) If no air or oil are coming out make sure there is air going to the spindle oiler and the solenoid valve activated. It is also possible to close the air off at the oiler using the air by-pass adjustment.