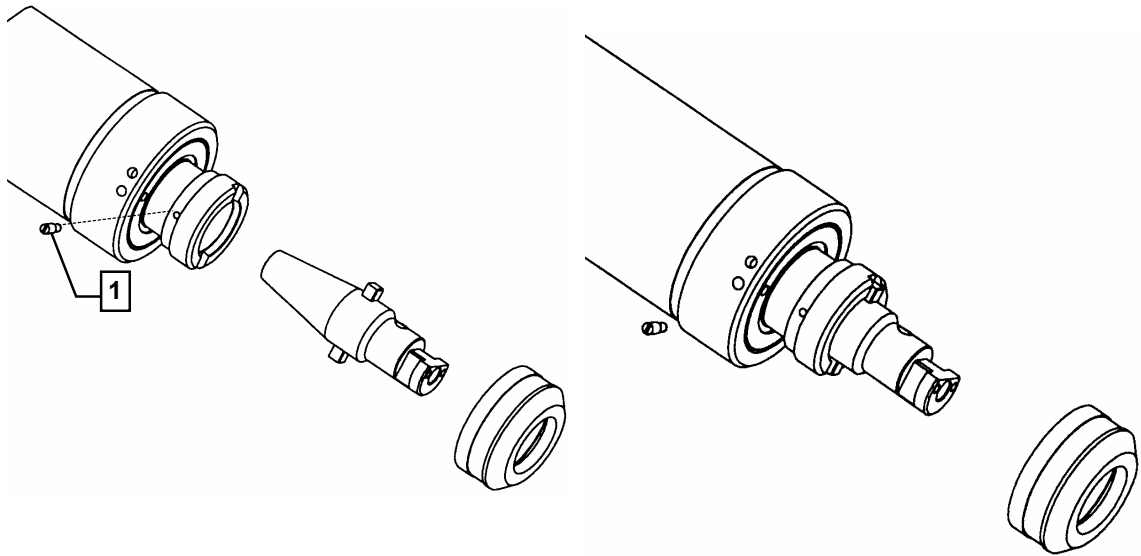


## FOR SERDI MACHINES REPLACEMENT OF THE SPINDLE KNURLED NUT

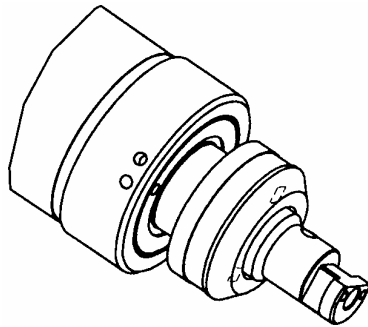
The spindle knurled spare nut reference **009766** is delivered unfinished and requires two machining operations before being mounted on the machine. This is due to the fact that the angular position of the spindle threading changes from one machine to another.

### OPERATING MODE

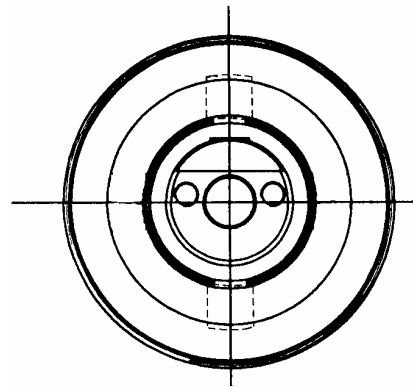


1. Remove the end stop screw **1** and the damaged spindle knurled nut from the spindle of the machine.

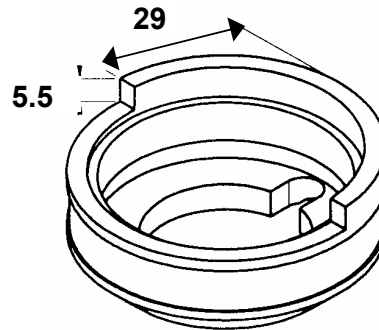
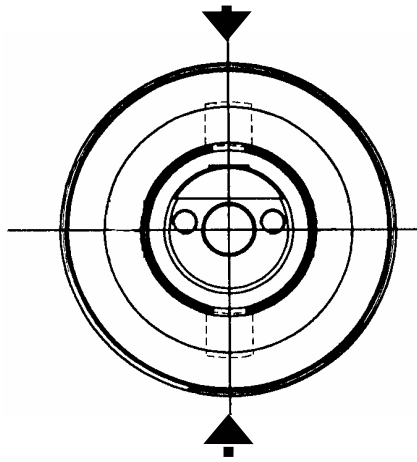
2. Place the tool holder SERDI 5100 into the spindle.



3. Tighten the new nut on the spindle, until the tool holder is firmly locked.



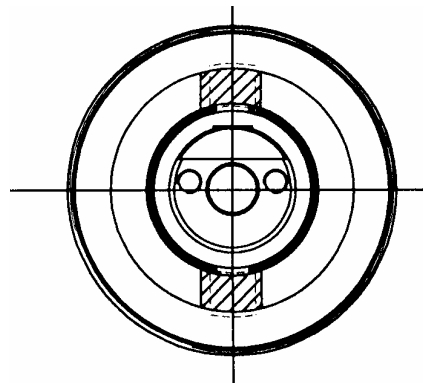
4. Locate the position of the tool holder pins and mark the spindle knurled nut in front of the pins. Locate also the position of the tapped hole for the end stop screw **1**.



5. Remove the spindle knurled nut and mill the nut edge in parallel to the marks, on the side of the end stop screw 1 according to drawing here above.

6. Fit the tool holder again, tighten the spindle knurled nut and fit the end stop screw 1.

7. Unscrew the spindle knurled nut about a quarter of a revolution until it comes in contact with the end stop screw 1. Locate the position of the tool holder pins and make a mark on the spindle knurled nut in this position.



8. Machine the groove for the tool holder pins according to the drawing.

