

## HSK SPINDLE MAINTENANCE

Every 500 working hours (or every 3 months with a tool change cycle every 2 min.), clean the locking device with a clean cloth (see picture 5) and spray it with the proper lubricant (cod. SCM 0002400035C). Place the small hose of the can in between the petals like is shown in picture 1. With the can vertical apply the lubricant. Repeat the operation for every space between the petals.



**Picture 1**

To make sure the lubricant is distributed into the mechanism, it is necessary to lock and unlock the spindle 10-15 times. (M51, see picture 2).



**Pictures 2**

After these steps and checking that the operation and movement of

the mechanism is fine, put the HSK tool holder back in position and turn on the spindle at 18000 RPM for 30 sec. (see picture 3)



Picture 3

The excess of grease is going to be deposited on the HSK tool holder; now it is necessary to clean the inside of the tool holder. Remove the tool holder from the spindle and clean it with a clean cloth. (See picture 4)



Picture 4

Also clean the inside of the spindle to remove the grease from the sides where the taper of the HSK tool holder makes contact. (See picture 5)



Picture 5

Every 6 months clean the taper of the tool holder with acetone (careful it is flammable) , once it is dry apply the dry-lubricant (teflub) (cod. SCM 002400034A), that helps to protect from dust for a correct “unlock” of the HSK tool holder. (See picture 6)



Picture 6