

Spindle Brake Deluxe for SX2 Installation Guide



Thank you for purchasing the Spindle Brake from Priest Tools. I developed this tool to improve the productivity, ease, and convenience of performing tool changes on your mill.

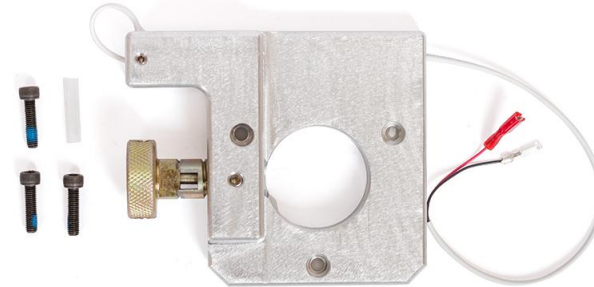
Your new Spindle Brake is made from 6061 Aluminum and is machined to exacting specifications in state-of-the-art CNC machining centers. The Spindle Brake is a very high quality tool that works well and is a great addition to your collection of mill accessories.

I am very interested in your feedback on this product. Please email me with your questions, comments, or concerns at gregpriest@cox.net. If requested, I will respond to your inquiry at my earliest opportunity.

I hope you enjoy using the Spindle Brake from Priest Tools for many years to come.

Greg Priest
Priest Tools, Inc.

What's Included



Hardware

1. Spindle Brake plate with integral hand retractable Spring Plunger and Safety Switch
2. 5-.8 x 20mm socket cap screws (3)
3. Insulator
4. Instructions

Tools required for installation

1. 4mm hex wrench
2. Phillips screwdriver

Caution

Obviously, never operate the mill with the Spring Plunger engaged with the spindle.

Spindle Brake Basic for SX2 Installation Guide

1. Disconnect power to mill.
2. Remove tooling from spindle.
3. Raise mill head to near its highest point.



6. Slide the Spindle Brake Plate down over the spindle with the rounded-edge facing down and the spring plunger to the right (it shows to the left in this picture because the mill head is upside down).

Install the supplied socket cap screws only finger tight.



4. Remove 3 M5-.8x8 cap screws and plastic bearing cover from the underside of the mill around the spindle.



7. Pull, rotate, and release the Spring Plunger so the tip rests against the side of the spindle. Rotate the spindle until the tip engages. With the pin engaged with the spindle, align the Spindle Brake Plate so that the spring plunger operates smoothly, and then completely tighten the plate.

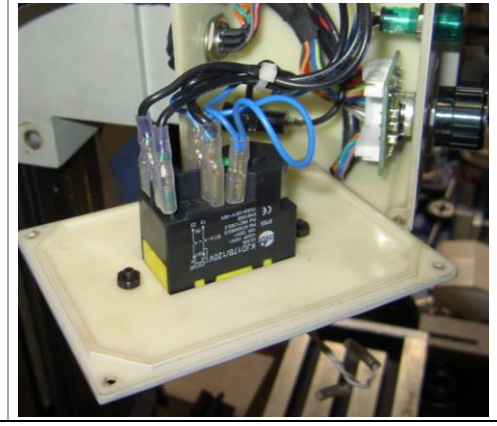
5. The Spindle Brake Plate will be installed in the next step.

Important note: do not repetitively tighten, loosen, and re-tighten the socket cap screws as this will decrease the effectiveness of the nylon patch on the screws.

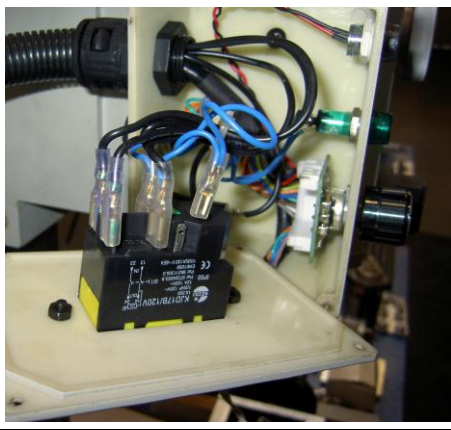
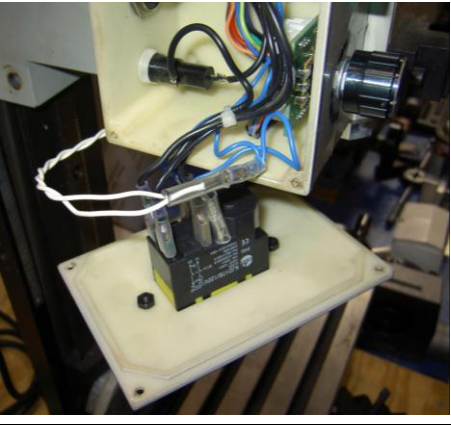

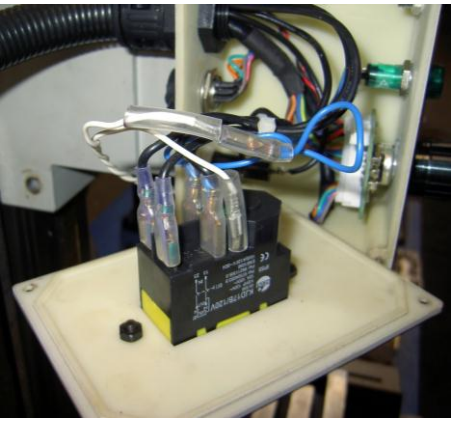


8. Remove the 4 screws holding the cover of the electrical box and remove the cover.

Locate a 1/4" hole on the bottom of the box 1" forward from the back of the box and 3/4" out from the headstock. Center punch and drill the 1/4" hole.



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<p>9. Run the wires from the Spindle Brake Safety Switch up through the 1/4" hole that was drilled into the electrical box.</p> <p>Disconnect the wire pair from the small terminal on the side of the mill power switch.</p>		<p>12. Gently tuck the wires back into the electrical box and re-install the cover.</p>	
<p>10. Place the plastic insulator over the male connector and onto the wire of the Safety Switch.</p> <p>Plug the Safety Switch male connector into the female connector that was just disconnected and twist the insulator up over the edge of the insulation on the female connector. This is a tight fit.</p>		<p>13. Restore power to the mill. Check the operation of the Spindle Brake Spring Plunger. The mill should operate only when the magnet in the Spring Plunger is pointing at the Safety Switch.</p>	
<p>11. Slide the insulated female connector of the Safety Switch down onto the male connector of the power switch. This is a tight connection and the male connector on the power switch may have to be <u>gently</u> bent outward <u>slightly</u> from the switch to enable this connection.</p>		<p>With the spindle stopped, pull, turn, and release the spring plunger against the spindle. Rotate the spindle until the Spring Plunger engages with the hole in the spindle. In this position, with the magnets pointing up and down, power to the mill should be disabled</p>	<p>Congratulations, installation of your new Spindle Brake is complete!</p>