



Output spindles



Original instructions.

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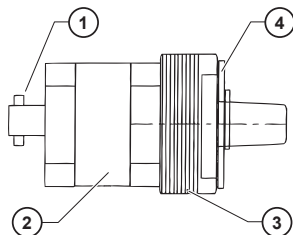
Software and documentation available at:

<http://cadfiles.desouttertools.com>

No login/password required.

200 SERIES SPINDLES

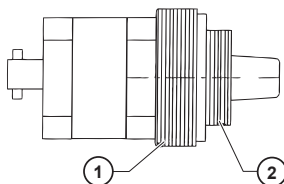
K32 - Jacob's No 1 Taper



- 1 Drive Pin - Meshes final planet cage
- 2 Bearings and Spacer
- 3 Lock Nut - Single Thread Size
- 4 Metal "flinger" and shaft seal Held by circlip

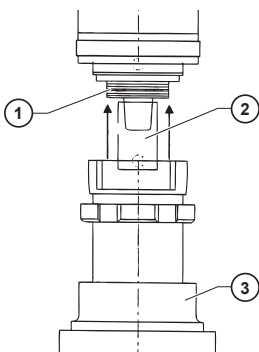
K35

For attaching multihead or push pull tapping head - same as K32 except no metal "flinger" or shaft seal and lock nut has two different threads.



- 1 Thread One for locking output spindle in tool
- 2 Thread Two for attaching multihead or push pull tapping head

Fitting a multihead or push pull tapping head



- 1 K35 Output Spindle with double threaded nut
- 2 Drive Dog
- 3 Multi Head or Push Pull Tapping Head

Multihead threads onto double threaded nut on output spindle.

Ensure drive dog is fitted and engages in the drive of the multihead.



If the quill assembly rotates ensure crosshead (for changing stroke is tightened).

Fitting and Removal of K32 or K35

Tools required:

- 22mm AF Wrench
- External circlip pliers (K32 only).

To Remove:

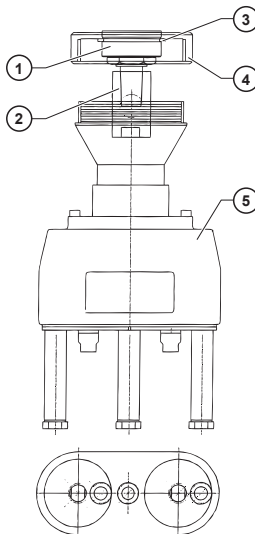
- Remove external circlip - metal "flinger" will also be removed.
- Use 22 AF Wrench to loosen lock nut and remove.
- Output spindle will now pull out.



If the quill assembly rotates ensure crosshead (for changing stroke is tightened).

To Refit:

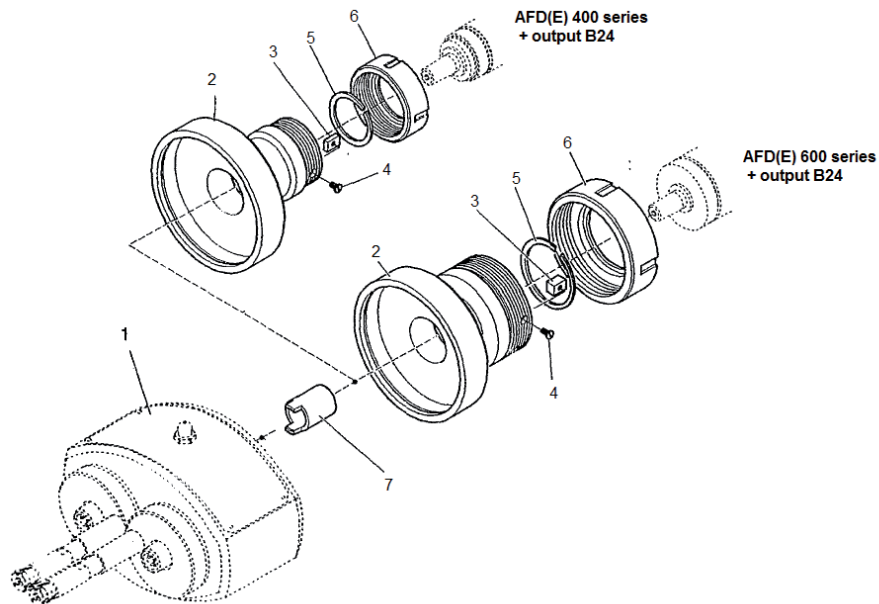
- Push output spindle into quill, ensure it is fully seated and the drive pin is meshed with the final output from the gear train.
- Use 22 AF Wrench to tighten lock nut (approx 28Nm/20ftlbs)
- On K32 only, refit metal "flinger" and lock in place with circlip (using external circlip pliers).



- 1 Machine Spindle jacob's No. 2 taper output
- 2 Drive Adaptor

- 3 External Snap Ring
- 4 Locking Nut
- 5 Multi Head Body

400/600 SERIES SPINDLE



Item	Description
1	Multi spindle head body
2	Multi spindle adaptor
3	Key
4	Screw
5	External snap ring
6	Locking nut
7	Drive adaptor

- Assemble the B24 output on the quill of the AFD and tighten it to 28 Nm.
- Slide the locking nut (item 6) on the quill of the AFD.
- Assemble the external snap ring (item 5) on the quill of the AFD.
- Assemble the key (item 3) on the Multi head adaptor (item 2) with the screw (item 4 – 2.5 Nm).
- Tighten the locking nut (item 6) on the Multi head adaptor (item 2 – 35 Nm)

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