

## **How to Change the bearing on Galaxi lathe**

Parts required:

2 x 6207LLB (or equivalent) bearing (3 x DVR only)

Circlip pliers (Internal/External or pliers to fit External 25mm (1"), and Internal 72mm (3"))

Plastic Mallet (Dead blow preferably)

Clean cloth and methylated spirits.

#2 pozi/Phillips screw driver

2.5mm Allen key.

5.0mm Allen Key.

Preferably access to a hydraulic press or similar.

1. Isolate the power to the lathe. Remove the plug from the wall socket;
2. Take the headstock off from the main bed and keep the headstock stand up on the bench;
3. Remove the hand wheel and the red guard plate, disconnected all wires on the red guard, keep all screws in a safe place.
4. Ideally, the control box should be taken off from the headstock but it'll be too complicated to customer. So Please make sure the control box protected with carefully operation;
5. Unfasten the M4 grub screw (M4 Allen key required ) on the Aluminum fan and then pry off the fan using even force at 180 degree (2 big flat screwdrivers might need here);
6. Remove the 8xM6 Cap screw and the sheet metal cover exposing the green PCB sensor board
7. Remove the 2 screws fastening the sensor board, unplug the 5pins sensor cable and carefully take the sensor board and two small 6mm tubes off. That's very important step. Wrong operation will cause the failure after assembly.
8. Press(manual press required) or Tap the spindle with rubber hammer from the front to the back, the rotor/spindle and the rear cap will come out together. Whatever methods taken, Please prevent the spindle head and thread damage from impact. For example, if the spindle is very tight, customer might have to use heavy metal hammer so please use soft material as cushion between the spindle and hammer.
9. Once the rotor spindle comes out, the front bearing can be removed with a drift.
10. Use the circlip pliers (both inner and outer) to take off all the circlips from the real spindle and bearing house. Now the rotor/spindle is able to be taken off from the rear end caps, so is the rear bearing;
11. Clean both bearing housings with methylated spirits, now the replacement of new bearing is ready.
12. Press/tap carefully new bearing into the read bearing housing and secured by outer circlips and then press/tap the rotor spindle into the rear endcap and secured it with inner circlips;

13. Reinstall the assembled rotor spindle back into the headstock and tap the rear spindle and put 8xM6 cap screw back and then secure the rotor spindle as much as you can;
14. Reinstall two front bearing into the front bearing housing. Do NOT tap the bearing with the mallet. Use an or two old bearings as a cushion against the bearing to keep it square.
15. During step 13 and 14, you might find the spindle assembly coming in/out between the front and back, so please repeat step 13 and 14 until the front bearing fit in and all 8-M6 secured in place. Sometimes, you might find spindle very tight after installation, in this case, you need tap either front or back on the spindle or release 8-M6screws a little bit to release the tension on the spindle.
16. Put the sensor and tube back to the headstock, plug the sensor cable back and then sealed with the sheet metal guards;
17. Reinstall the aluminum fan and secured by M4 grub screw
18. Reconnect all wires and cable and put the red guard plate back on the headstock;
19. Plug the lathe into power and test new bearing and lathe.
20. All Done!

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