



Items Used in This Procedure

Included items		Main unit accessories
Spindle unit (1)	Short belt and long belt (1 each)*	T-shaped hexagonal screwdriver (1)

* There are two types of belts included. Use the longer belt (length: 170 mm) for the DXW-51D, DWX-52D, DWX-52DC and DWX-52DCi.

Replacement

⚠ WARNING

Before performing replacement work, switch off the machine's power switch and pull out the power cord from the machine. Attempting such operations while the machine is connected to a power source may result in injury or electrical shock.

⚠ CAUTION

Be sure to perform operations as specified by these instructions, and never touch any area not specified in the instructions. The machine may move in an unexpected way, resulting in injury or burns.

⚠ CAUTION

Do not touch the spindle unit or the surrounding areas immediately after milling has ended. Doing so may result in burns.

⚠ CAUTION

Remove the milling tool before performing replacement work. Contact with the blade may result in injury.

1. Carry out the preparations for the replacement.

* Figures and illustrations may appear differently depending on the model. (Figures and illustrations in this manual are of DWX-52DCi products.)

1 To move the spindle unit into the standby position, turn the power switch on.

2 If the milling bur is attached to the spindle unit, press the operation button on the machine, and then remove the milling bur from the spindle unit.

3 **Display VPanel.**
Click (the VPanel icon) in the task tray. VPanel will appear. If VPanel is not displayed correctly, check the instruction manual included with the machine.

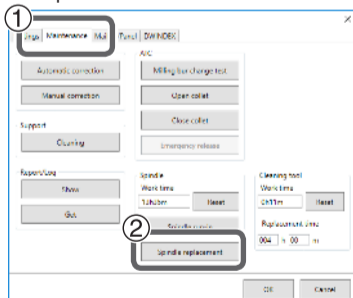
4 ① In the top window of VPanel, select the machine to operate. When you have connected multiple machines, you can switch between the machines by clicking icon.
② Click .
The [Settings] window will appear.



5 **Adjust the spindle unit position.**

- ① Click the [Maintenance] tab.
- ② Click [Spindle replacement].

The spindle unit will move.



6 Once the above preparations have been completed, switch off the machine's power switch, and then pull out the power cord from the machine.

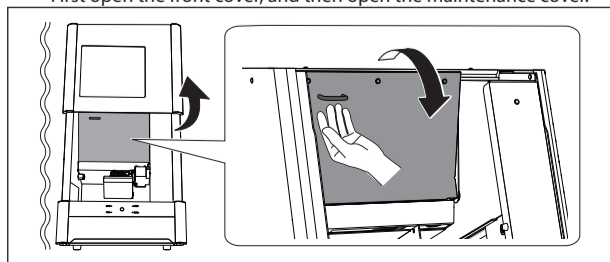
2. Remove the spindle unit.

Meaning of illustrations

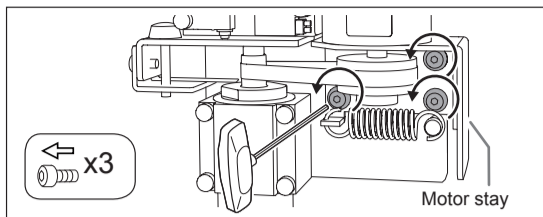
Remove	Attach	Loosen	Tighten

1 **Open the maintenance cover.**

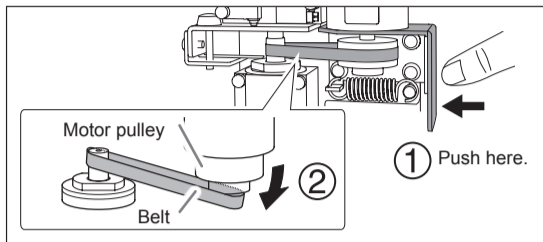
First open the front cover, and then open the maintenance cover.



2 **Loosen the screws securing the motor stay.**
Loosen the screws by about two turns.

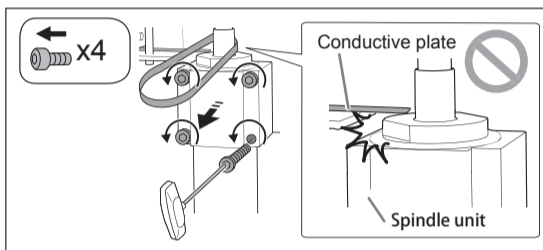


3 **Remove the belt from one side.**
Push the location indicated by the arrow in the figure toward the left of the milling machine to remove the belt from the motor pulley.



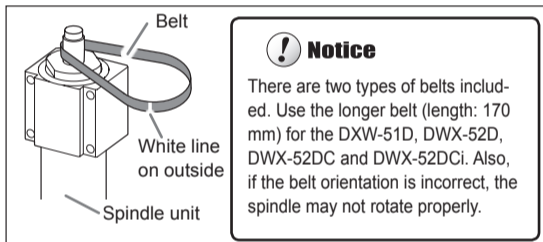
4 **Remove the spindle unit.**
Remove the screws, and then slowly pull both the spindle belt and the spindle unit straight out.

Notice When removing the parts, make sure that the spindle unit does not come into contact with the conductive plate.



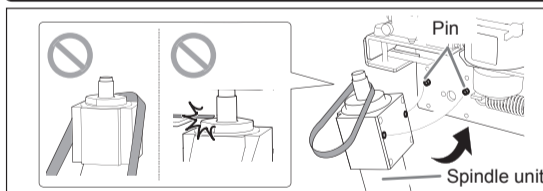
3. Attach the new spindle unit.

1 **Set the belt onto the new spindle unit.**
Using the included new belt, make sure the white line is on the outside of the belt.

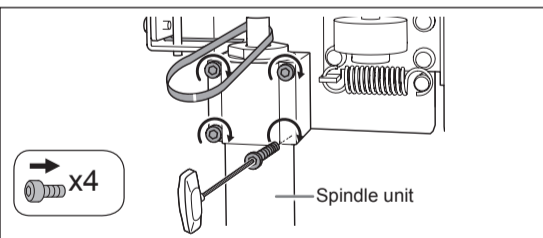


2 **Attach the spindle unit.**
Set the spindle unit onto the pins.

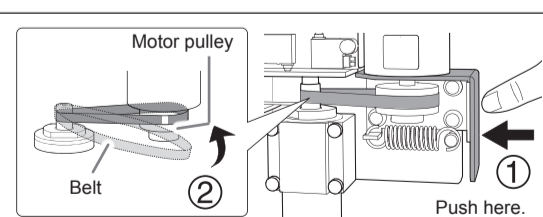
Notice Make sure the belt is not pinched behind the spindle unit. Make sure the spindle unit does not come into contact with the conductive plate.



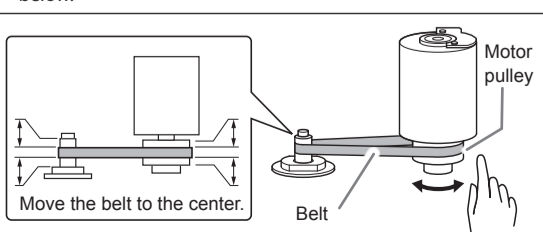
3 **Secure the spindle unit.**
Secure the spindle unit with the screws.



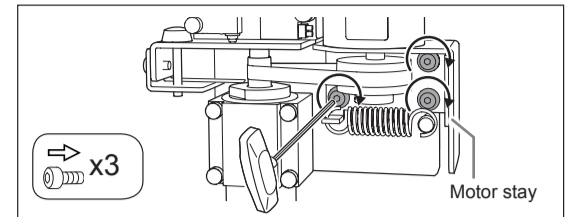
4 **Set the belt on the motor pulley.**
Push the location indicated by the arrow in the figure toward the left of the milling machine to set the belt on the motor pulley.



5 **Adjust the belt position.**
Rotating the motor pulley will cause the belt to move. Rotate the pulley back and forth to adjust the belt to the position in the figure below.

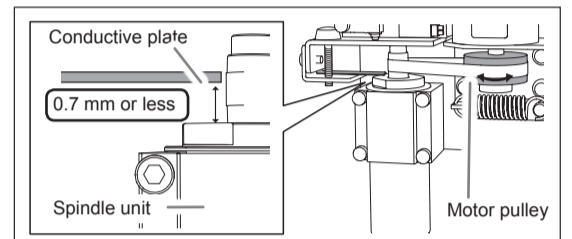


6 **Secure the motor stay.**
Tighten the screws.

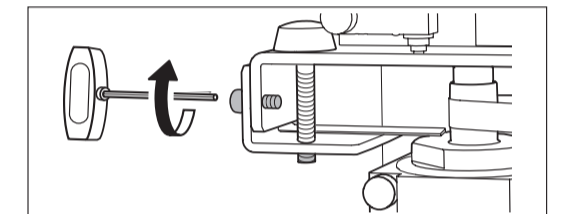


4. Adjust the position of the conductive plate.

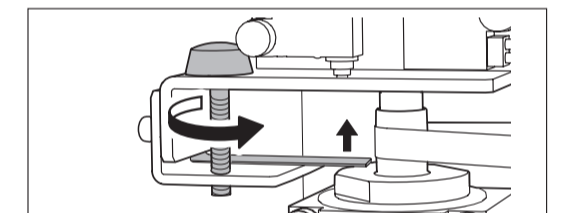
1 **Check the position of the conductive plate.**
Verify the following 3 points. If all points have been met, go to step 4. If any point has not been met, go to step 2.
① The conductive plate and the spindle unit are not in contact with each other.
② The conductive plate and the spindle unit do not come into contact with each other or produce abnormal noise when the motor pulley rotates.
③ The distance between the conductive plate and the spindle unit is 0.7 mm or less. (For your reference, the conductive plate is 0.2 mm thick.)



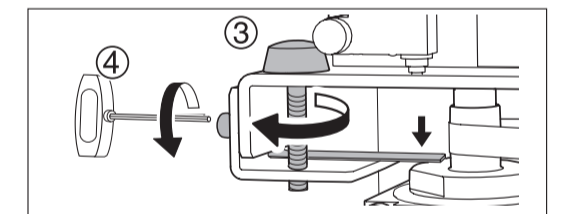
2 **Adjust the position of the conductive plate.**
① Loosen the screw.



② Turn the adjustment screw in the counterclockwise direction until the conductive plate and the spindle unit are in contact with each other.



③ Rotate the adjustment screw through one full clockwise turn.
④ Tighten the screw that you loosened in step 1.



3 **Verify that the conductive plate is in a position that meets the requirements in step 1.**

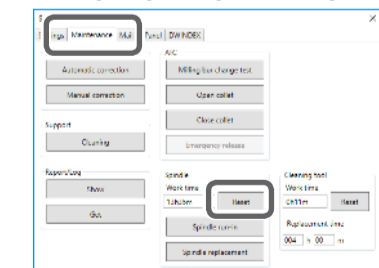
4 **Close the maintenance cover, and then close the front cover.**

5 **Connect the power cord, and then turn on the machine's power switch.**

5. Perform operations after replacing the spindle unit.

1 **Reset the work time of the spindle unit.**

- ① Display VPanel, and then click .
- ② Click [Reset] on the [Maintenance] tab.



2 **Run-in the spindle unit.**
Failure to run-in the spindle may result in unstable spindle rotation. Refer to the manual included with the milling machine for instructions on how to perform run-in. Check for abnormal noise during run-in. If abnormal noise is generated, the conductive plate may be in contact with the spindle. Start over from step 2 in section 4.

3 **Perform automatic correction of the milling machine.**
If automatic correction is not performed, the cutting results may be undesirable. Refer to the manual included with the milling machine for instructions on how to perform the work.