



(P/N 6519 shown)



PRODUCT DESCRIPTION

- 6519—Dovetailed headstock, 3/4-16 spindle, timing belt pulley
- 6520—Same as above but with 2-step pulley
- 6521—Dovetailed headstock, ER-16 spindle, timing belt pulley
- 6522—Same as above but with 2-step pulley

Industrial Headstock with Dovetailed Base

P/N 6519, 6520, 6521, 6522

Using the Headstock

The Sherline industrial headstock was designed to be used with Sherline dovetailed columns or beds. A brass gib adjusts the tightness of the headstock and is easily replaced when worn. The 20 mm ball bearings in the headstock are “Lifetime Lubricated” and protected by a dust cap. A preload nut on the spindle pulls both inner bearing races together to adjust endplay. The factory setting is .0002" (.005 mm) of endplay, which is the recommended setting. If your job requires extended high speed (over 4000 RPM) spindle operation, the preload can be adjusted to a looser setting to keep the bearings from overheating.

Adjusting the Spindle Bearing Preload

If any endplay develops in the main spindle, it can be easily eliminated by readjusting the preload nut. If extended running causes the headstock to be too hot to touch, the preload tension can be reduced slightly.

To change the adjustment, remove the spindle pulley, loosen the set screw in the preload nut and back the preload nut off 4° of rotation (counterclockwise). The bearings are lightly pressed into the case, so the inner race will not move without a sharp tap with a plastic mallet to the end of the spindle where the pulley is attached.

If you find your bearings are set too loose, you may want to take up on the endplay. You can check them with an indicator or by spinning the spindle without the motor belt engaged. If the spindle spins freely with a chuck or faceplate on it, the spindle is too loose for normal work. Adjust the preload nut until it turns only about one and one-half revolutions when spun by hand.

Thank you,
Sherline Products Inc.

Parts List, Headstock

NO. REQ.	PART NO.	DESCRIPTION
1	40160	Preload Nut
1	40230	Spindle, 3/4-16 (6519, 6520)
1	65023	Spindle, Er-16 (6521, 6522)
1	40320	Bearing Dust Cover
5	40330	10-32 x 5/8" Socket Head Cap Screw
2	40420	Headstock Bearing
2	40440	#2 x 14" Self-Tapping Screws
3	40600	10-32 x 1/4" Flat Point Set Screw
2	40670	10-32 x 1/2" Socket Head Cap Screw
1	43230	2-Step V-Belt Pulley (6520, 6522)
1	65011	Headstock Case, Dovetailed Base
1	65012	Industrial Headstock Spacer
1	65013	Saddle Nut Attachment Plate
1	65014	Industrial Brass Gib
1	65016	Timing Belt Pulley (6519, 6521)
1	65026	ER-16 collet nut (6519, 6521)