



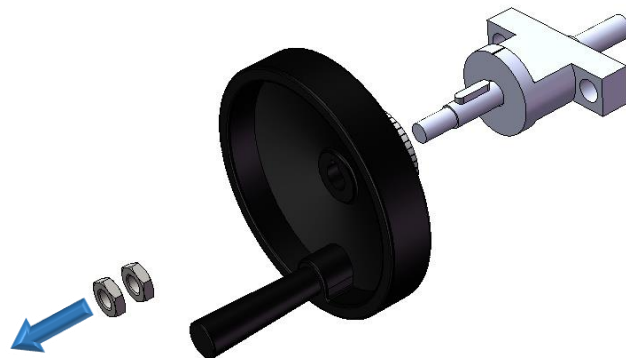
Y Axis Thrust Bearing Upgrade Kit

For the X2 Mini Mill

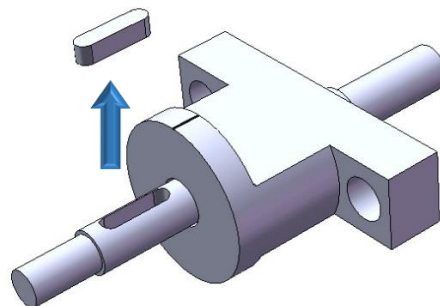
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Installation Instructions:

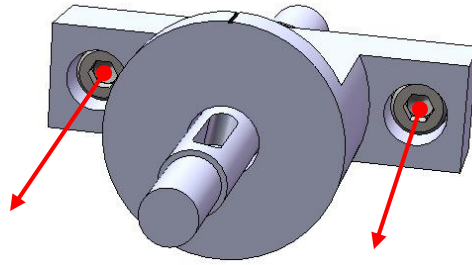
1. Bring the milling vise under an end mill in the spindle, so that you can cut the key by only moving the X axis.
2. Remove the double nuts securing the Y axis hand wheel and remove the hand wheel.



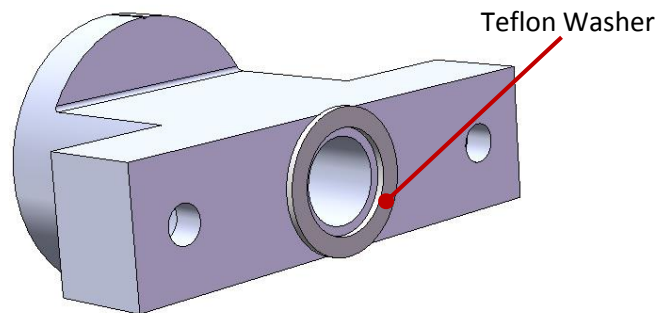
3. Remove the key from the lead screw.



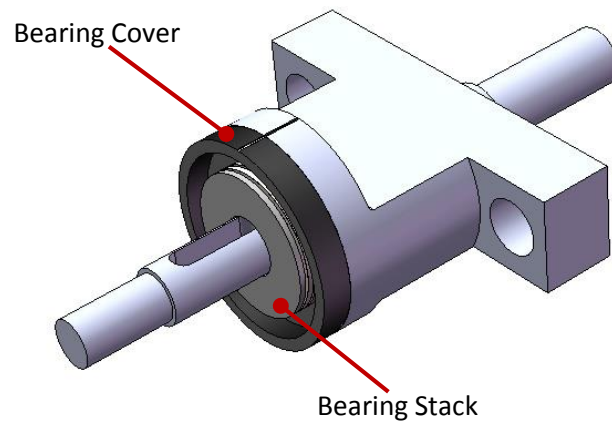
4. If using the optional Teflon washer:
 - a. Remove the two screws securing the lead screw seat to the mill's base.



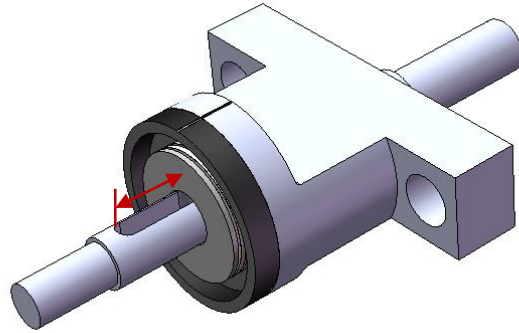
- b. Pull lead screw seat away from the base and clear of the lead screw.
 - c. Place washer onto backside of lead screw seat and reinstall seat and screws.



5. Place bearing cover over lead screw with the open end facing out.
6. Install a washer, bearing then 2nd washer onto the lead screw and into bearing cover (work a small amount of lubricant into the bearing to reduce wear).

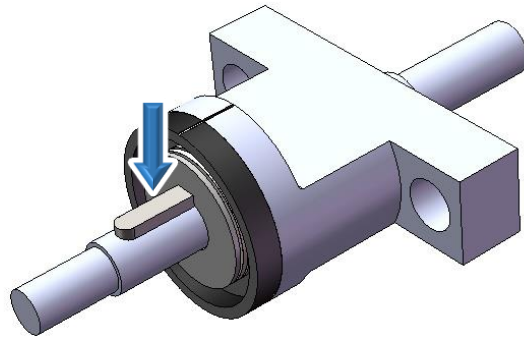


7. Measure the amount of keyway exposed.

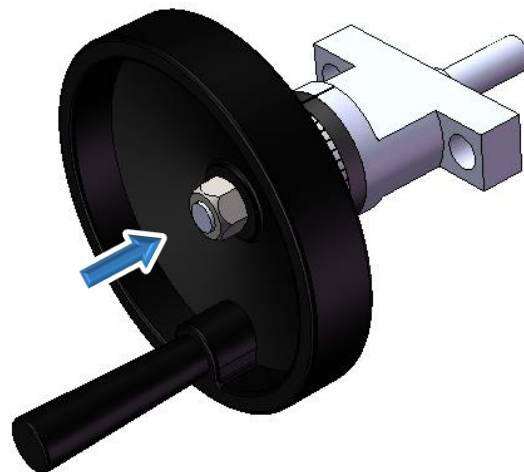


8. Set up key in vise and remove material to an overall length of that measured in step 6 (nominally about 0.550").

9. Install key back into lead screw.



10. Install hand wheel and locknut.



11. Tighten locknut to desired amount of resistance in moving the hand wheel. While tightening, align mark in bearing cap with mark on the lead screw seat.

Total time to install is less than 10 minutes.