



The Service Group



June/July Shoda CNC Technical bulletin 2008

Hello all,

I apologize for the lack of a technical bulletin, but we have been quite busy. Hope all is running well with your machines. Please remember that we are the Primary service organization in the U.S. and Mexico for Shoda CNC Machines. We can provide you parts, service, training and technical assistance in all areas.

Topic #1: Spindle Tapers

In recent months, we have noticed a trend on many of our customer's machines. We have seen many operators using large wrenches or hammering on their collet nuts to tighten them down. **DO NOT TIGHTEN COLLETS IN THIS MANNER.** If you have to use a hammer or large wrench to tighten your collet nuts, then it is time to replace or repair your spindle. Collets and collet nuts need to be kept clean along with the taper. **DO NOT USE OIL BASED PRODUCTS ON TAPERS.**

Spindle tapers: Should be a straight taper, the inside taper is designed to grip the collets adequately with hand torque. No grooving, burrs or concaved tapers. If you have doubt about the condition of the taper, take a digital picture and send it to me and I'll try to give a limited recommendation. TSG would be glad to assist in the rebuild of your motors or repair of your spindles.

Topic #2: Table Grease Hose Routing.



Numerous customers are sustaining serious damage to their machines OT switch arms due to miss routing of the table grease hoses.
Corrective Action: Secure and route grease hose to the inside of Vacuum hose ensuring that upon full +/- stroke, hose remains away from OT dog arm.

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