Figure 6-14. Series I CNC Head, R-Ram (Sheet 1)
NOTES

⚠️ BEND ALL TABS DOWN ON 117-0150.
⚠️ BEFORE ASSEMBLING RETAINER 117-0178.
⚠️ TORQUE TO ROTATE BALL QULL 15-1/4 IN. OZ.
⚠️ MAX. WHEN EXTENDING THE QULL, 91. IN. OZ. MAX.
⚠️ WHEN RETRACTING THE QULL. THIS IS EQUAL TO
⚠️ A 25 OZ. PULL ON BELT 117-0252 EXTENDING A
⚠️ 40 OZ. PULL RETRACTING THE QULL.
⚠️ BEND COPPER TUBE AS SHOWN IN SIDE VIEW TO
⚠️ DIRECT OIL TO BALL QULL EXTENSION.
⚠️ ADJUST MOTOR FOR BELT 117-0252 TO HAVE 66 LBS.
⚠️ TO INSTALL SET SPEED CHANGER TO MAX
⚠️ RAMP & PULL VARIOUS DRIVE BELT ONTO CENTER
⚠️ SPINDLE, INSTALL MOTOR WITH 23-642 PULLEY &
⚠️ 117-0254 RETAINING RING ASSEMBLED ON IT
⚠️ KEEPING VARIOUS DRIVE BELT ON OUTSIDE OF MOTOR
⚠️ SHAFT, DEPRESS 23-642 PULLEY, KEEPING THE
⚠️ BELT TO THE OUTSIDE & INSTALL THE 117-0252
⚠️ PULLEY & THE TM-01-0880 RETAINING RING.
⚠️ SET SWITCH 1-66-5059 WITH PLATE 77-0179
⚠️ AT 2.506 IN. ADJUST SCREW 66-5807 TO
⚠️ 3/32 IN.
⚠️ SET SWITCHES 1-66-5055 TO TRIP AT 2.600 &
⚠️ 4.560/72 IN.
⚠️ ADJUST STOP 71-3085 TO 0.005-010 CLEARANCE
⚠️ AFTER SWITCH 1-66-5059 HAS BEEN SET. SEE
⚠️ NOTE 6.
⚠️ SUN LUBE SUPPLY LINE THRU RAM & DOWN THRU
⚠️ COLUMN TO A HOLE IN THE REAR OF THE
⚠️ COLUMN 24 UP FROM THE BOTTOM.