



Safe Spindle Lock

For the X2 Mini Mill

1/1/16

Installation Instructions:

1. Place the spindle lock on the fine feed cover and engage the spindle lock. This will center the lock in the spindle and properly position the lock bearing on the cover. Depending on the model of your belt drive conversion, you may have to shim the lock to get to the correct height. Use either shims or washers to align the pin to the hole in the conversion mount. Leaving the cover slightly loose or slightly bending the far end of the cover can also help in bringing the pin into alignment and should be tried before removing metal from the spindle lock.
2. Mark the location of the two bolt holes using a pen or a center punch.
3. Remove the fine feed cover by removing the two screws securing it to the head.
4. Drill two holes with a #7 bit (clearance holes for a #10 size screw).
5. Install the spindle lock with the included screws, lock washers and nuts to the feed cover.
6. Reinstall the feed cover to the head.
7. Verify that the spindle lock engages and releases smoothly with no binding.
8. The lock is designed to be at the nominal height to engage most conversions. There is enough variation in the various brands of conversion kits that the nominal height won't work for everyone. If the spindle lock binds or does not release smoothly, most likely the nominal height is not correct for your mill. Prior to making any changes, verify the spindle lock is not angled relative to the head and is causing the binding.

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