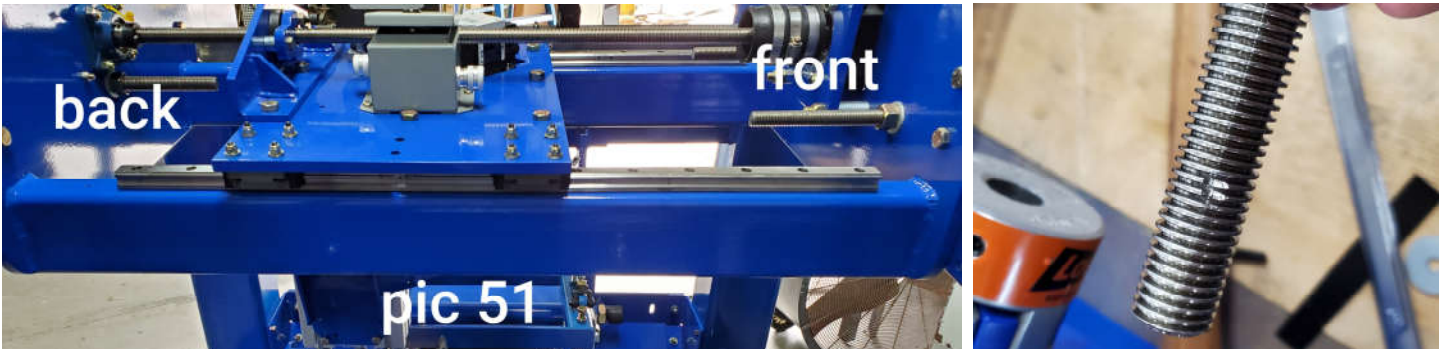


REPLACING ACME ROD ON XL-SAW

- Remove rubber boot from Lovejoy couplings at motor, then remove (both stacked) setscrews from rod side coupling. May have Loctite, soak with WD-40 to break loose.
- Remove 2 bolts from ACME housing capture.
- Either grind weld at bearing side shaft collar (protect THK rails) or loosen motor to pull old ACME rod out of place.
- Before installing new ACME rod, grind flat spot on one side for Lovejoy set screw to set in. This will be on the motor side / Lovejoy side.
- **Confirm that the carriage moves smoothly full travel with ACME rod removed. THK Rail Bearings may be worn causing premature failure of ACME.**



- Thread ACME Rod through bearing, then start threaded collar, push rod through F53 nut mount.
- Thread nut in appropriate orientation (pins facing away from motor. Then slip over blue bow tie capture, you can loosely bolt the capture in place to assist with holding the rod up.
- Slip rubber boot over rod and then loosely fit Lovejoy coupling in place. Do not tighten.
- Fully mate Lovejoy spider and couplings together, and push acme rod until it is touching the end of the motor shaft. Take care to align set screw in ground flat section of rod. Loctite can be used here. Insert second set screw as jam-screw.
- Tighten threaded shaft collar against bearing to keep rod snug against motor shaft. Tighten collar set screw. Confirm shaft turns smoothly by hand. Then reposition rubber boot.
- Tighten nut capture bolts, and finger tighten tension bolt, then lock jam nut in place. Confirm shaft turns smoothly by hand. May require 1/4 turn out on tension bolt.
- Bearing may need to be loosened to get everything moving smoothly and aligned. Tighten order: Motor, Bearing, then ACME nut capture.
- Don't forget to lube the screw daily with white lithium grease!