MAG MAINTENANCE TECHNOLOGIES

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MAG FADAL

DRAWBAR and PILOT KITS - Rev B   May 1, 2009

DRB-0090 DRAWBAR/PILOT KIT, COOLANT-THRU-SPINDLE SYSTEMS

HDW-1616

HDW-0150

HDW-0158 O'Ring is not needed on Spring Pilot when DRB-0109 Sealing Washer is installed at bottom. It is not included in this kit.

HDW-0155

HDW-0158

HDW-0177

HDW-1616
HDW-0506
DRB-0107
DRB-0019
DRB-0014
BRG-0004
DRB-0016
HDW-0155
HDW-0150
HDW-0158
DRB-0109
HDW-0177
DRB-0026
BRG-0005
DRB-0004
BRG-0005

Machines fitted with Locking Drawbar mechanisms and Fadal Coolant-Thru-Spindle systems use this kit. The HDW-0195 Belleville Spring kit [ordered separately] is installed with DRB-0109 Sealing Washer at the bottom of the pocket.

Any DRB-0074 spacers that were previously installed underneath the Orientation Bridge legs *must be removed*.

The new DRB-0092 Knock-Out Cap is improved to allow the black tungsten carbide seal face to pivot better.

HDW-0195 BELLEVILLES:
Short Pocket: 4.325 inch [109.86 mm] is 38 Springs

Long Pocket: 4.627 Inch
[117.5 mm] is 42 Springs

INSTALLATION OF DRB-0109 SEALING WASHER IN COOLANT-THRU SPINDLES

1. Remove original Drawbar, and Belleville stack.
2. *Clean* sidewall in pocket so washer can seal against sidewall at bottom of pocket. A Brake Cylinder Hone could be helpful to do this.
3. Install HDW-0158 and HDW-0150 O'Rings onto DRB-0109 Sealing Washer *with DOW 111 grease*.
4. Insert Sealing Washer *SIDEWAYS* into opening [see photo].
5. Insert Drawbar up from bottom, and through hole in washer. Guide Drawbar through center O'Ring, and press Washer down to bottom of pocket.
6. This design washer allows Coolant-Thru fluid pressure to lift Sealing Washer without damaging O'Ring on bottom of the original design washer.

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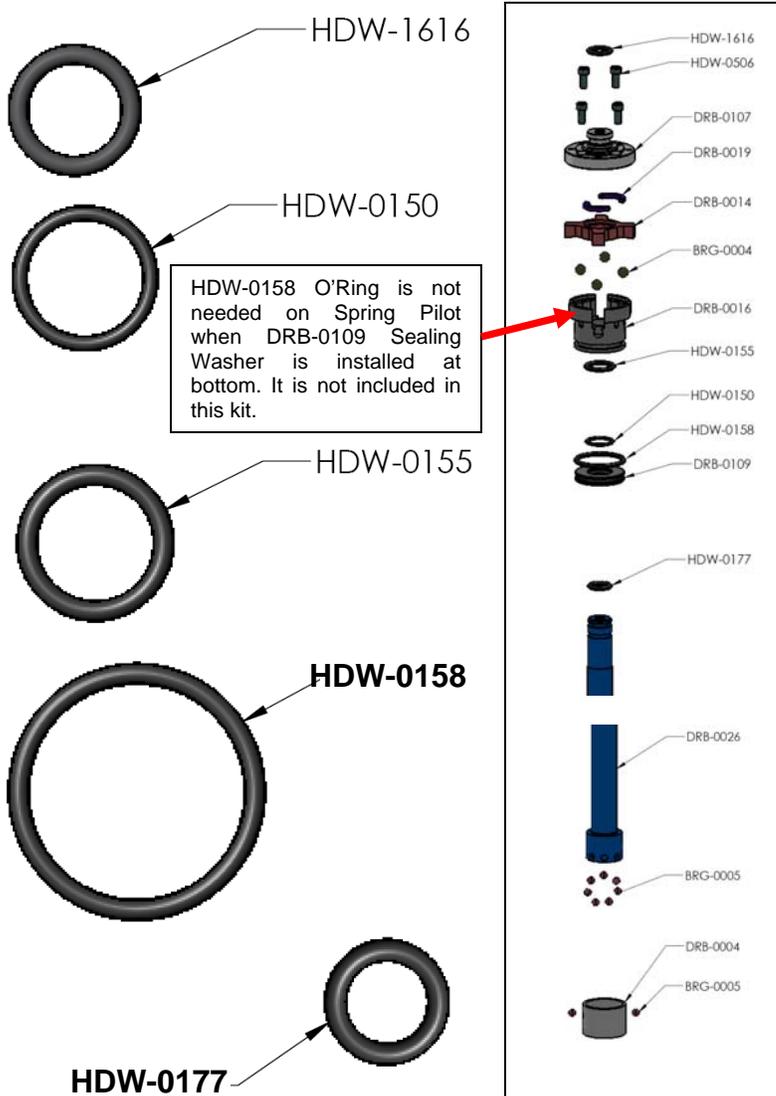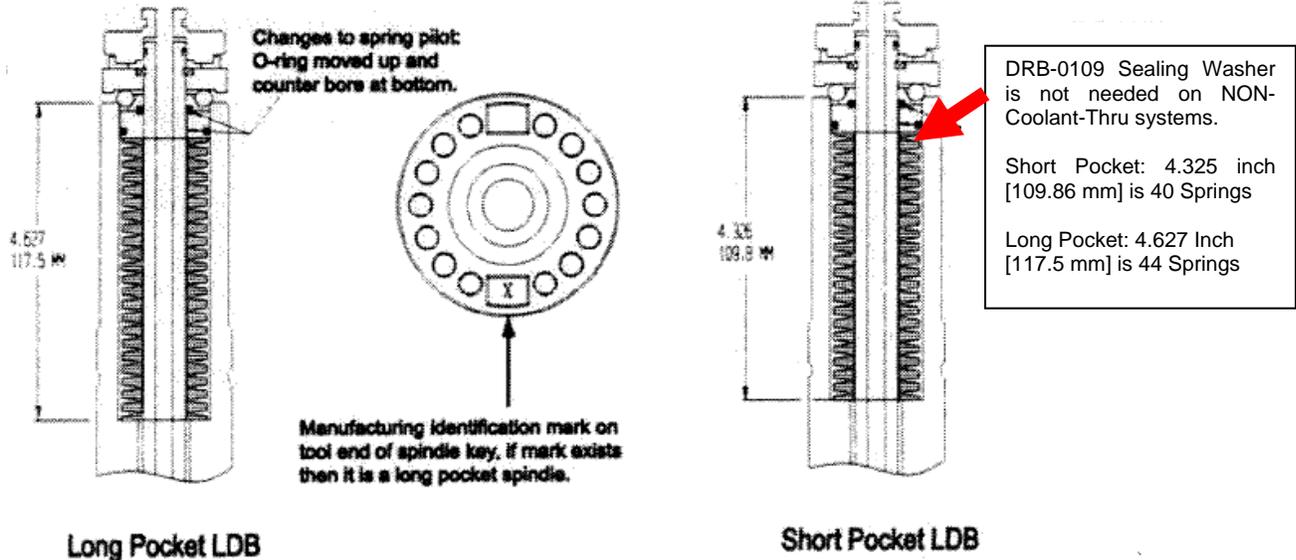Chatsworth, CA 91311
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DRB-0091 DRAWBAR/PILOT KIT, NON-COOLANT-THRU-SPINDLE SYSTEMS

Machines fitted with Locking Drawbar mechanisms and have no coolant-thru system use this kit. The HDW-0195 Belleville Spring kit [ordered separately] are installed with DRB-0068 Knock-Out Cap. The included DRB-0074 spacers are installed underneath the Orientation Bridge legs to raise the Bridge .070 inch.

DRB-0109 Sealing Washer is not needed on NON-Coolant-Thru systems.

Short Pocket: 4.325 inch [109.86 mm] is 40 Springs

Long Pocket: 4.627 Inch [117.5 mm] is 44 Springs

Long Pocket LDB

Short Pocket LDB

Changes to spring pilot: O-ring moved up and counter bore at bottom.

Manufacturing identification mark on tool end of spindle key, if mark exists then it is a long pocket spindle.

DRB-0030 DRAWBAR/PILOT KIT NON-LOCKING

Machines fitted with Non-Locking Drawbars in either 6500, 7500, 8000, 10000 or 15000 RPM configurations use this kit to replace Drawbar, with HDW-0195 [ordered separately] Belleville Springs. Use 47 springs if the manufacturing mark exists on the bottom of the long spindle key, and 44 if not marked.

Short Pocket: 4.325 [109.86mm] 44 Springs

Long Pocket: 4.627 [117.53mm] 47 Springs

Non-Locking Drawbars will not have the DRB-0109 Sealing Washer installed as the Coolant-Thru-Spindle systems are not installed on Non-Locking Drawbar Spindles.

Long Pocket NLDB

Short Pocket NLDB

Manufacturing identification mark on tool end of spindle key, if mark exists then it is a long pocket spindle.