



## Gas Spring Kit Little Machine Shop 5500 Mill Installation Instructions

The enclosed Gas Spring Kit is for use on the Little Machine Shop 5500 mill and all Sieg SX2.7 compatible mills. The Gas Spring counterbalances the weight of the mill head when raising and lowering the mill head.

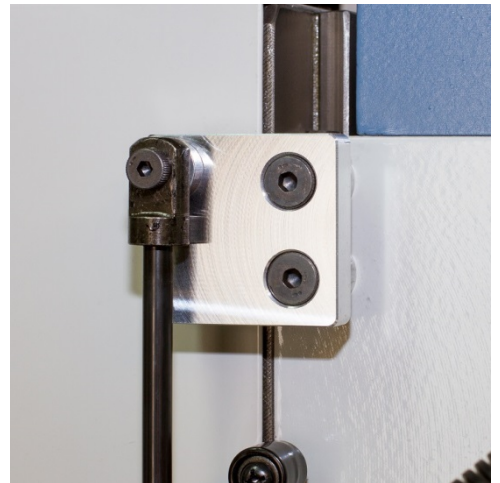
### What's Included

1. Gas spring bracket
2. Spacer .382x.750x.625 (2)
3. Spacer .319x.625x.250 (2)
4. Shoulder screw, 3/8x3/4" (2)
5. Shoulder screw 5/16x5/8" (2)



### Installation Instructions

1. Remove the Z gib slotted screw in the upper left back corner of the mill head casting.
2. Mark a line on the beige mill head casting (not the blue mill cover) 1" to the right of the Z-Axis column, from the top of the casting down 3".
3. Hold bracket against the mill head casting, even with the top of the mill head casting, and align the right edge of the bracket with the line marked in the previous step.
4. Mark the top right hole with a 3/8" transfer punch.
5. Drill, chamfer, and tap a 5/16-18 threaded hole on this mark.
6. Mount the bracket using the supplied 3/8" shoulder bolt with the spacer behind the bracket against the mill head. Align the bracket square and plumb and mark the lower right hole with a 3/8" transfer punch. Remove the bracket.
7. Drill, chamfer, and tap a 5/16-18 threaded hole on this mark.
8. Mount the bracket to the mill head using the supplied 3/8" shoulder screws and spacers. Align the bracket to be square and plumb before tightening the shoulder screws.





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9. Mark a vertical line on the base of the mill in line with the edge of the column flange where it connects with the base. This is shown in the picture to the right.
10. Mark a line  $3/4$ " to the left of this line. Place a  $1/32$ " shim on the horizontal surface of the base shown just above the ruler in the picture to the right.
11. Mount the top (the thinner part) of the gas spring to the left hole in the bracket using the supplied  $5/16$ " shoulder bolt. Place the bottom of the gas spring on top of the shim with the line marked in the previous step in the center of the mounting hole.
12. Use a  $5/16$ " transfer punch and mark the location in the mounting hole.
13. Drill, chamfer, and tap a  $1/4$ -20 threaded hole on the mark made on the previous step.
14. Place the supplied  $5/16$ " spacer on the shoulder screw and mount the bottom of the gas spring to the base of the mill. Remove the shim.
15. Replace and adjust the Z gib screw removed in Step 1.
16. Your Gas Spring is now installed and should look like the picture to the right.
17. Email Greg Priest at the address below with all questions, comments, concerns, and praise.

