



Spindle Brake Basic Hi-Torque Mini Mill (Sieg SX2) Installation Guide

Thank you for purchasing the Spindle Brake from Priest Tools. I developed this tool to improve the productivity of performing tool changes, and to make tool changes easier and more convenient.

Your new Spindle Brake is made from 6061 Aluminum and is machined to exacting specifications in state-of-the-art CNC machining centers. The Spindle Brake is a very high quality tool that works well and is a great addition to your collection of mill accessories.

I am very interested in your feedback on this product. Please email me with your questions, comments, or concerns at gregpriest@cox.net. If requested, I will respond to your inquiry at my earliest opportunity.

I hope you enjoy using the Spindle Brake from Priest Tools for many years to come.

Greg Priest
Owner, Priest Tools

What's Included



Hardware

1. Spindle Brake plate
2. 5-.8 x 25mm socket cap screws w/ Nylon patch (3)
3. 1/4-20 x 3/4" socket set screws w/ Nylon patch (3)
4. Instructions

Tools required for installation

1. 4mm hex wrench
2. 1/8" hex wrench

Caution

Obviously, never operate the mill with the locking pin engaged with the spindle through the spindle Brake Plate or otherwise.

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1. Disconnect power to mill.
2. Remove tooling from spindle.
3. Raise mill head to near its highest point.
4. Remove 3 M5-.8x8 cap screws and plastic bearing cover from the underside of the mill around the spindle.



5. Slide the Spindle Brake Plate down over the spindle with the rounded-edge facing down and the hole for the locking pin to the right.

Important note: do not repetitively tighten, loosen, and re-tighten the socket cap screws as this will decrease the effectiveness of the nylon patch on the screws.



6. Insert the spindle locking pin through the side hole and rotate the spindle until the pin engages. With the pin engaged with the spindle, align the Spindle Brake Plate so that the locking pin operates smoothly, and then completely tighten the plate.



7. Check the operation of the spindle locking pin with the Spindle Brake plate to make sure the locking pin operates smoothly and engages in the spindle locking pin hole. If not, refer to the following Height Adjustment procedure. Otherwise, congratulations, installation of your new Spindle Brake is complete!

Height Adjustment

Use this procedure if the Spindle Brake is not in alignment with the spindle lock pin hole causing the spindle lock pin to not engage (lock) the spindle.

Due to manufacturing variance of the vertical position of the spindle lock pin hole, it may be necessary to use the 3 Socket Set Screws (SSS's) located in the Spindle Brake plate to space the plate slightly away from the mill head so that the spindle lock pin hole aligns with the Spindle Brake.

- a. Start with the Spindle Brake mounted to the mill.
- b. Sight through the hole in the side of the Spindle Brake to see how far off-center the spindle lock pin hole is.
- c. Unscrew all 3 Socket Cap Screws (SCS's) that hold the Spindle Brake plate to the mill head, evenly and far enough so that the spindle lock pin hole is in the center of the hole in the side of the Spindle Brake.
- d. Tighten the Socket Set Screws (SSS) evenly until they come in contact with the spindle bearing surface recessed within the mill head.
- e. Tighten the SCS's.
- f. Check the operation of the spindle lock pin with the Spindle Brake to see if it engages properly with the spindle lock pin hole.
- g. If the spring plunger engages properly with the spindle lock pin hole, then this procedure is completed. If not, then repeat this procedure making fine adjustments with the SSS's/SCS's until the spindle lock pin engages properly with the spindle lock pin hole.