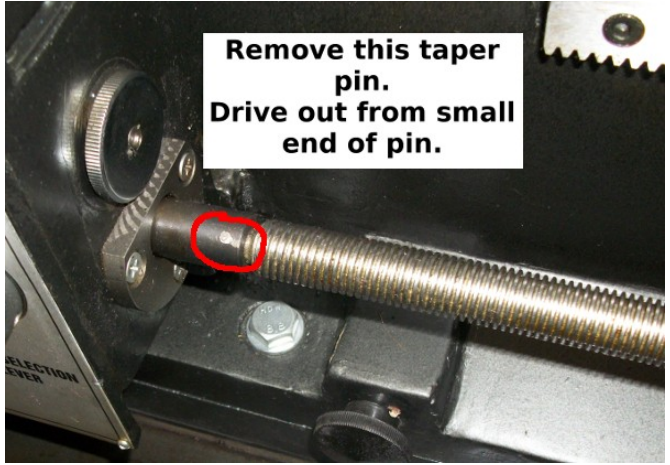


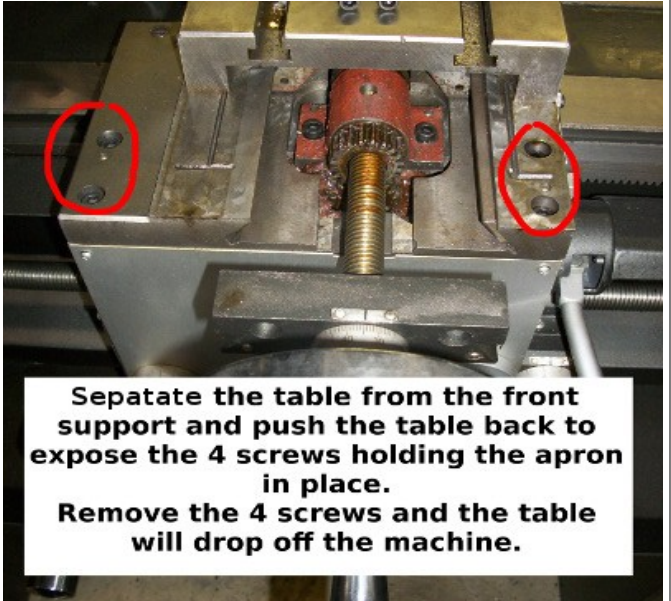


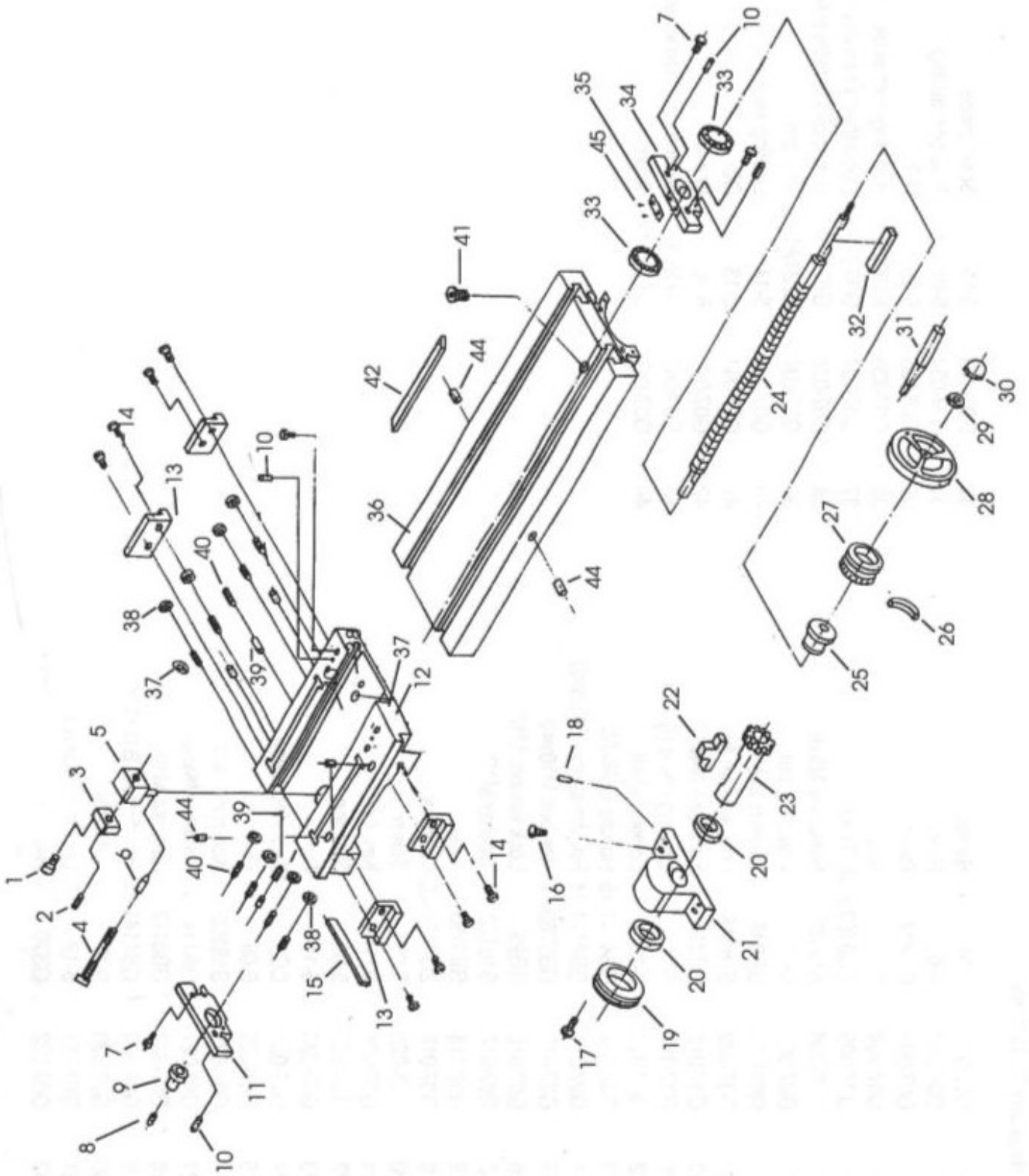
REMOVING THE APRON AND LEAD SCREW FROM THE GRANITE 1300 SERIES

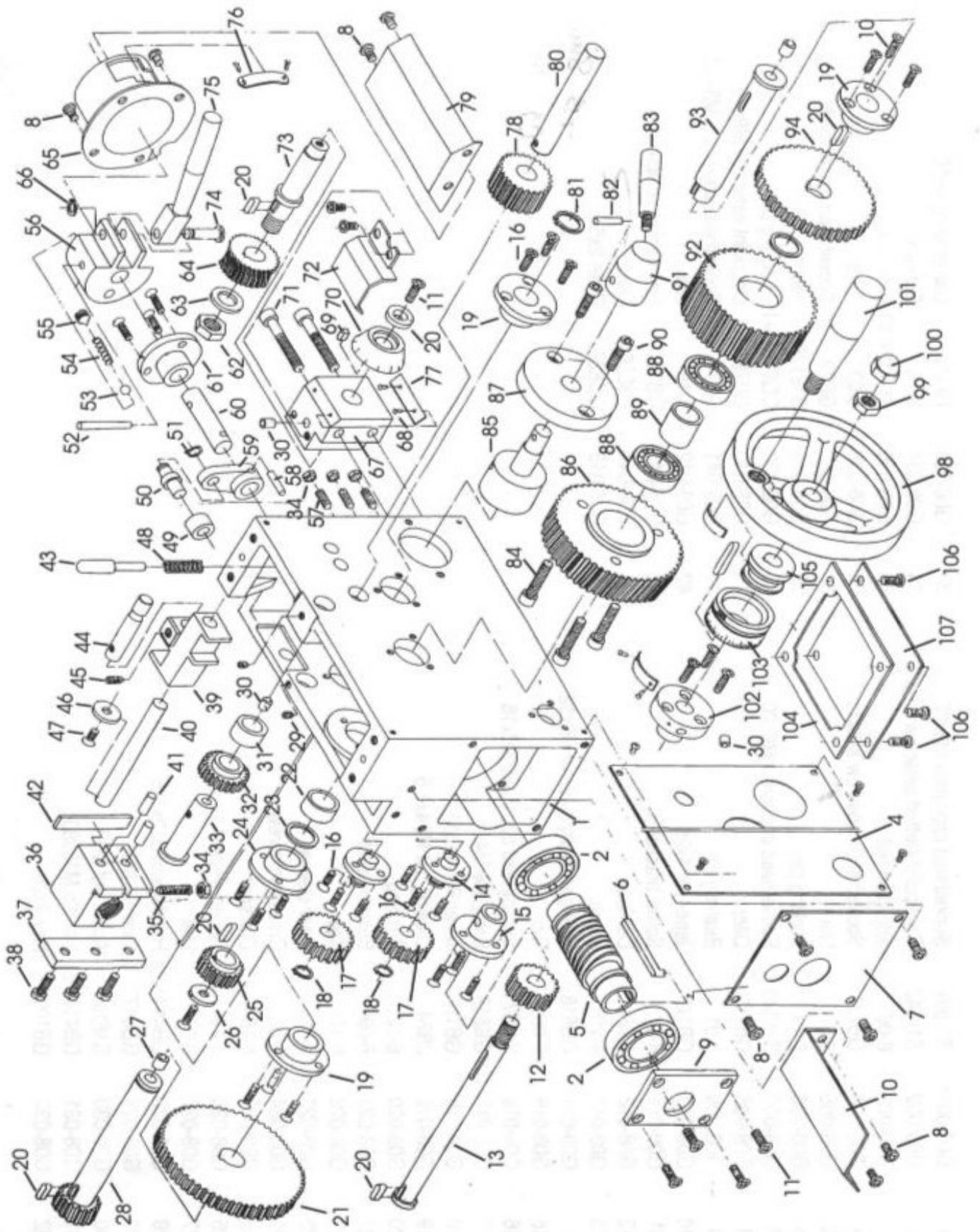
DESCRIPTION: This document is for the removal and installation of the power input apron and feed screw from the Granite 1300 series machines. The apron and leadscrew can be removed from the machine as individual items or as a single unit then separated later. Have the owner's manual available when doing any machine maintenance. The items referenced in these instructions can be found in the parts section of the owner's manual. **MAKE SURE THE MACHINE IS UNPLUGGED BEFORE ANY DISASSEMBLY IS STARTED.**

NOTE: When installing the feed screw into the apron, **DO NOT** forget the key (#6) inside the worm gear.

STEP	DESCRIPTION	PICTURES
LEAD SCREW REMOVAL		
1	Disengage the half nut and place all powerfeed controls on neutral.	
2	Position the carriage close to the center of the machine bed if possible.	
3	Drive the taper pin out of the left end of the leadscrew. This pin is larger on one end than it is on the other, be sure to drive it out from the small end toward the large end.	
4	<p>Remove the two screws from the right hand leadscrew support.</p> <p>Rotate the leadscrew so the key slot is facing downward. This will keep the worm gear key (#6) from falling out of place when the leadscrew is pulled from the apron. See apron diagram page 4.</p> <p>Pull the leadscrew bracket away from the machine bed just enough to clear the alignment pins next to the two screws.</p>	

5	Pull the leadscrew out of the apron. If the leadscrew is stuck in the apron, the apron and leadscrew can be taken off together.	
APRON REMOVAL		
6	Remove the two screws that mount the front crossfeed screw support to the table.	
7	Separate the table from the support and push the table back far enough to expose the four screws that hold the apron to the carriage.	
8	Remove the four mounting screws and drop the apron off the bottom of the carriage.	
INSTALLATION (SEE APRON DIAGRAM PAGE 4)		
It is best to put the leadscrew into the apron before installing the apron on the machine because it is easier to make sure the worm gear drive key (#6) is in place while inserting the leadscrew.		
9	To install the drive key, remove the cover (#7) from the left side of the apron.	
10	Look inside the apron at the worm gear. Rotate the worm gear so the key slot is on the bottom.	
11	Put some grease on the key and in the slot to hold the key in place.	
12	Place the key in the slot with the foot of the key in the hole at the end of the worm gear slot.	
13	Insert the feed screw from the right side of the apron and guide it over the key.	
14	Install the cover onto the left end of the apron.	
15	The remainder if the installation is a reversal of the removal instructions above.	
16	If installing a new apron assembly, do not use the taper pins #10 on the carriage table diagram pg.3.	





END