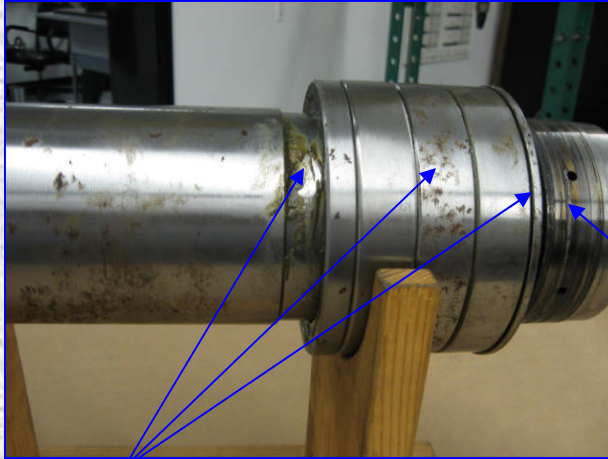


INCOMING INSPECTION



Inspect for external damage

Burned quad seal surfaces. If possible, check drawbar tension and runout before dismantling

Surface pitting on shaft parts - shows possible fluid contamination

DISMANTLE



Dismantle starting at tail shaft, spider drive



Continue dismantling at rear of spindle to gain access to bearing nut



Remove bearing retainer nut



Inspect all disassembled components for wear and cracks



Prepare to remove drawbar, spring assembly and bearings

DISMANTLE



Inspect springs for cracks and wear and stack height



ASSEMBLY



Clean and inspect internal components



Qualify parts for proper tolerance before assembly



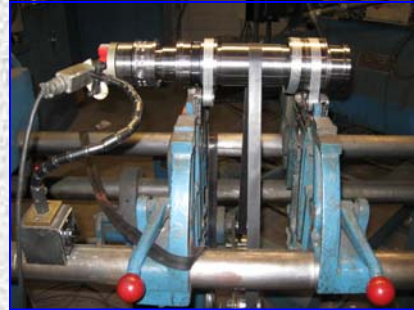
Before installing bearings test bar check for initial runout



Install drawbar

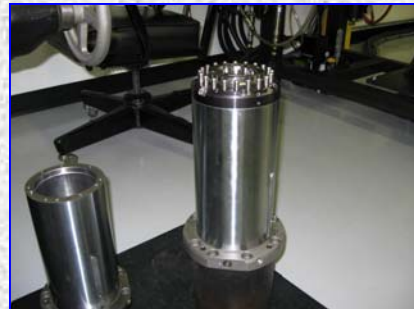
ASSEMBLY

Final assembly stage before balance



Check balance and correct for any unbalanced conditions

After balance, spindle is ready for final testing

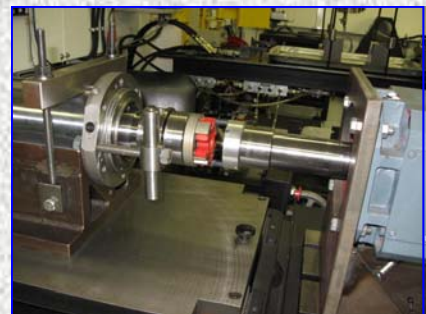


Spindle is placed in run test housing

TESTING



Install spindle in test stand and prepare for final test



Test running in bearings, drawbar force, spindle taper accuracy and final trim balance