Installation Instructions for the Kwik Way SVSII Tru-Valve Collet Spindle

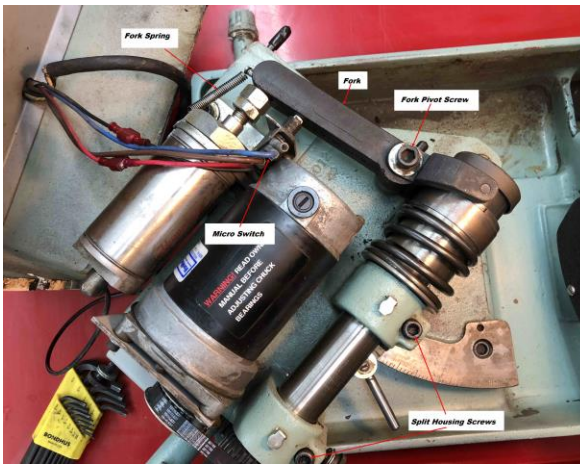
Caution:

First unplug the machine and make sure the machine has no power and will not start while you are installing the new spindle.

Note: Installation is easiest if you have easy access to the front and rear of the machine.

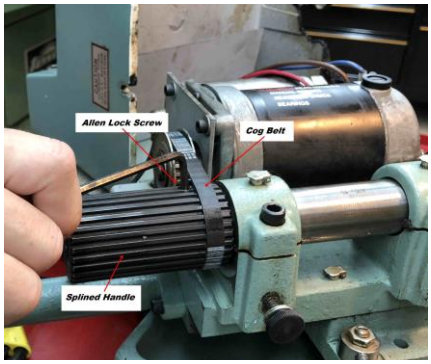
Disassembly:

Remove the cover from the chuck by loosening the 2 thumb screws and sliding it slightly toward the back of the machine. The wires should be long enough to lay the cover over to the left of the machine as your standing front of it. You are now ready to start the removal of the old spindle.



First disconnect the fork return spring.

Next remove the allen bolt that the fork pivots on and remove the fork from the machine.



Remove the cog drive belt by loosening the allen screw on the splined handle and pull the handle back as you push the belt forward.

Now you can loosen the 2 split housing allen screws that are used to adjust the clearance on

the spindle. Back them off several turns so they are completely free of tension.

Pull the existing spindle out from the rear of the machine.

Use a clean rag and wipe out the spindle bores and make sure they are clean before installing the new spindle.

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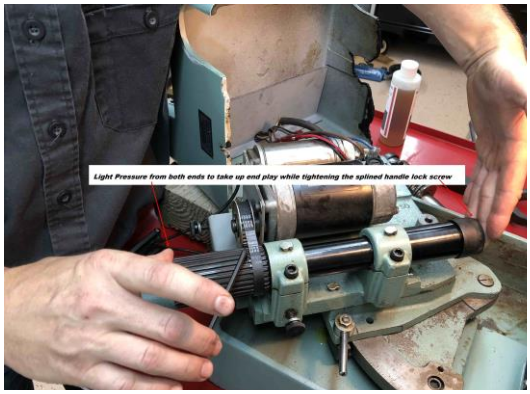
Assembly:

Carefully slide the new Spindle into the housing bores. Fill the oilers with oil and turn the spindle a few revolutions to pre oil it.

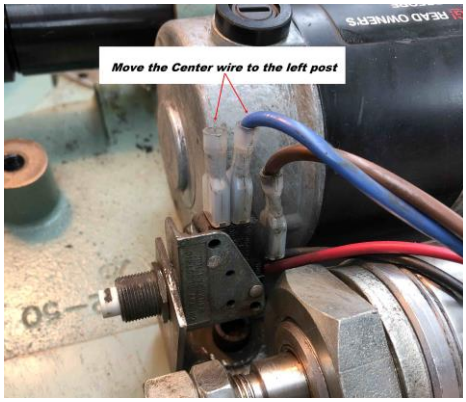
Adjust the 2 split housing allen screws as follows. Start with the one toward the collet end. Slowly tighten the screw with one hand while turning the spindle with the other. Adjust until the spindle barely locks up. Now, slightly back off just enough for it to unlock and spin without having unnecessary drag. Repeat the process with the other screw. Now fill the oilers again as they probably emptied before you got the screws adjusted.



The next step is to place the belt back onto the motor pulley and end of the spindle shaft. Now take the splined handle and slide it onto the Spidle shaft and into the cog drive belt.

Hold a slight amount of pressure to the front and back simultaneously while tightening the lock screw on the splined handle.

The fork microswitch has 2 wires connected to it and has 3 spade posts. Take the wire of the middle post and put it on the outer post that is not in use(failure to do this will keep the valve chuck spindle motor from turning on unless the microswitch is compressed). Now replace the cover and you are ready to start using the machine.



Valve Depth Stop:

The original spindle has a valve stem depth stop. The same depth stop can be pushed out of the original spindle and be reinserted in through rear of the Tru-Valve Collet Spindle.

IMPORTANT:

The Tru-Valve Collet Spindle is a precision piece and should be treated as such. The collet, collet nut, and collet seating area in the spindle should be wiped out and cleaned every time that the collet is changed out to a different size or regularly even when you are always using the same size collet. Failure to do so will lead to premature wear and the chucked valve not running “True”. Cleanliness is the KEY to accuracy and Long Life with the Tru Valve Collet Spindle!

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Operating instructions for the Tru-Valve Collet Spindle

CAUTION:

READ and FOLLOW the instructions below for repeatable and long service life of your Tru-Valve Collet Spindle.

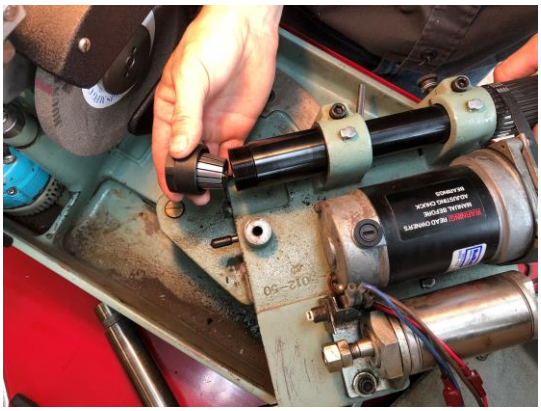
Once the Tru-Valve Collet Spindle is correctly installed in your valve grinder you ready to start grinding valves.

First remove the Spindle Nut

Clean the collet and Insert the correct collet into the nut (the collet must be snapped into the Nut before being placed into the spindle). The correct collet will be the one that your valve just fits through in its relaxed position. For example; you should use a 6-7mm collet for a 7mm valve stem or a 4-5mm collet for a 5mm valve stem. This gives the most surface contact between the collet and valve stem. The more the collet is collapsed the less the surface contact area you will have between the collet and valve stem.

Use a clean rag and wipe out the inside surface where the collet will seat in the spindle (failure to do this will result in inconstant concentricity and diminished spindle life)

Insert collet and thread the nut onto the spindle.



Insert your valve into the collet to your desired depth and tighten the nut. (The nut only needs to be snug or hand tight in most cases. In other words, use the wrench to just hold the nut with

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one hand and the other hand to turn and tighten the spindle.

When removing do the reverse but you will need to turn the nut back far enough to pop the collet out of its seat to release the valve.

Be sure to fill the spindle oilers daily and keep the spindle housing adjustment and endplay correct for your machine.

The Tru-Valve Spindle assemblies and the collets are precision pieces and should treated as such by being kept clean and free from any debris (tightening a collet in the spindle housing with grinding stone debris, metal chips, or any other such debris will irreversibly damage the spindle). Also, refrain from using excessive or blunt force on any part of the Tru-Valve spindle assembly. When dressing the valve facing stone with the diamond dresser it is best to cover the collet so that no stone dust gets into the collet.

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