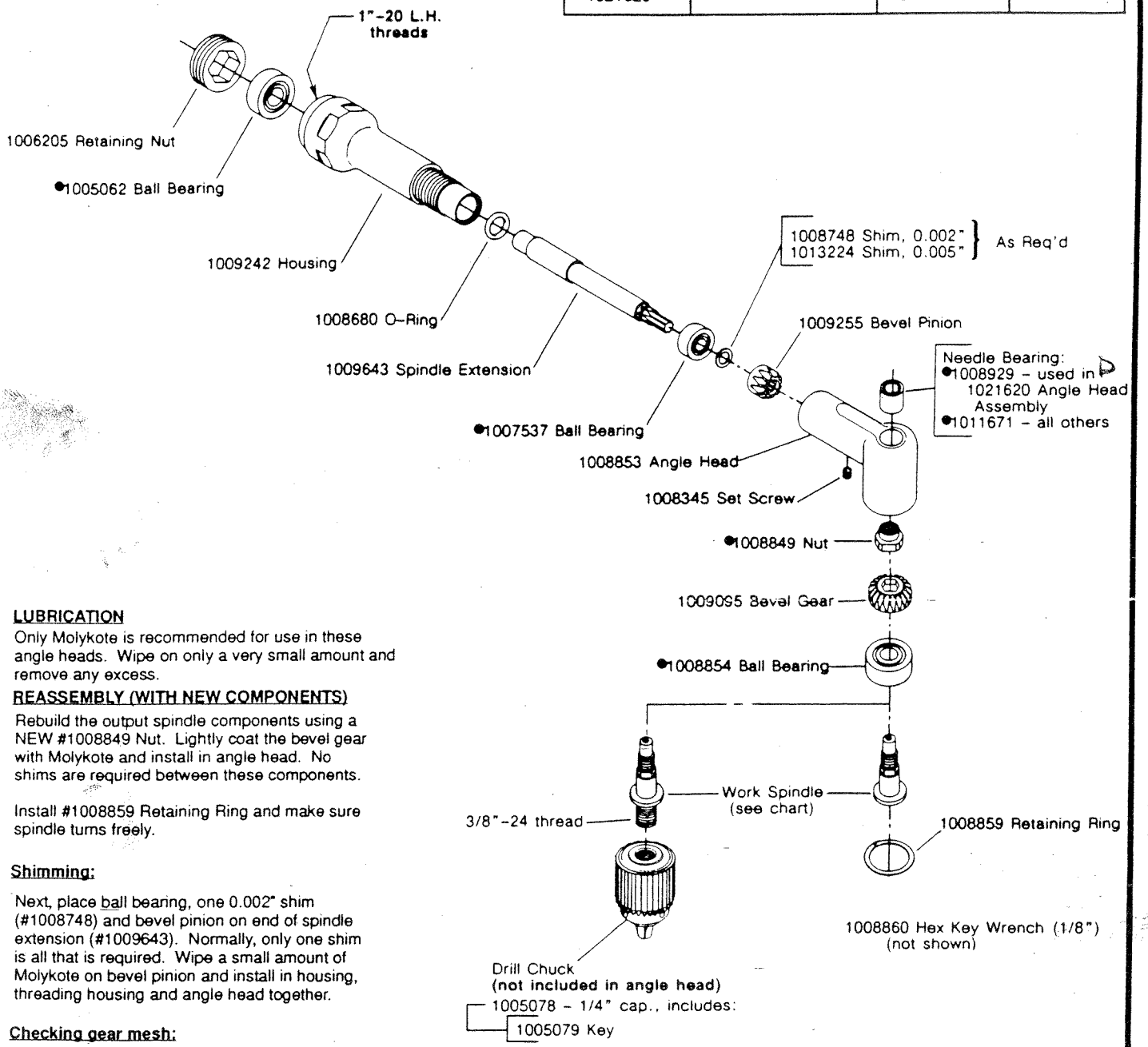
DOTCO®

Model 15LS & 15LN Series Angle Drills
90° Heavy Duty Angle Heads

Angle Head Assembly Part Number	Assembly Includes Output Spindle Part Number	Spindle Thread Size (internal)	Termination Code
1025547	1110062	#10-32	-51
1021289	1008850	1/4"-28	-52
1021292	1008948	9/32"-40	-53
1021291	1008856	5/16"-24	-54
		(male thread)	
1021620	1015703	3/8"-24	-59



LUBRICATION

Only Molykote is recommended for use in these angle heads. Wipe on only a very small amount and remove any excess.

REASSEMBLY (WITH NEW COMPONENTS)

Rebuild the output spindle components using a NEW #1008849 Nut. Lightly coat the bevel gear with Molykote and install in angle head. No shims are required between these components.

Install #1008859 Retaining Ring and make sure spindle turns freely.

Shimming:

Next, place ball bearing, one 0.002" shim (#1008748) and bevel pinion on end of spindle extension (#1009643). Normally, only one shim is all that is required. Wipe a small amount of Molykote on bevel pinion and install in housing, threading housing and angle head together.

Checking gear mesh:

Hold end of spindle extension with fingers and turn output spindle back-and-forth. Acceptable play is **0.005", or less**. Add only one shim at a time (or take out one shim) until play is correct.

(●) Indicates recommended spare part. Order one (1) or one set for every 6-10 tools. Small, low cost or easily lost parts should also be ordered on the basis of 3-4 per 10 tools.