

## Service Bulletin 1011 Replacing the Z-Axis Dial

### *Date*

Issued August 5, 2016

### *Product*

5500 HiTorque Bench Mill with serial numbers below 50089 or in the range 60053-60076. (You can find the serial number on the base by turning the Y-axis to move the table back and then sliding back the black cover, as shown at the right. But the easiest way to see if this issue affects your machine is to simply look at the Z-axis dial, as described under "Symptoms," below.)



### *Issue*

The Z-axis dial on some early-production bench mills have incorrect graduation legends.



### *Symptoms*

Dials with legends from 0.01" to 0.09" are incorrect. The correct dial has legends from 0.005" to 0.045".



Correct

Wrong

## ***Solution***

Replace the incorrect dial with the correct dial, PN 2077. Follow these steps:

1. Remove the Z-axis hand wheel by removing the retaining nut and washer. Use a 14 mm wrench.
2. Pull the hand wheel off the shaft. The graduated dial will come with the hand wheel.
3. Use a shop towel to pull the graduated ring off the hand wheel. The shop towel will contain the arched spring that is under the dial.
4. Install the new graduated ring over the spring onto the hand wheel. The knurled edge goes toward the hand wheel.
5. Replace the hand wheel on the shaft.
6. Reinstall the washer and nut.
7. Discard the dial you removed.