

## Procedure for changing belts - Hegner hdb 200xl

Part numbers mentioned can be found on "HDB200 Headstock exploded view.jpg"

- 1) position and lock headstock so both ends of spindle can be easily accessed
- 2) Loosen motor bracket and remove belt from motor pulley.
- 3) Remove the four socket cap bolts(26) with a 4mm hex key and remove main bearing housing ring(6) careful to retain the sprung washer if present.
- 4) It may be prudent to spray penetrating fluid such as plusgas or WD40 around where the bearing(54A) seats in the casting to make removal easier.
- 5) At this point the whole spindle and pulley assembly complete with the bearings can slide out of the castings towards the tailstock end of the lathe - If this is the case then skip to 9) else continue below. EXCESSIVE FORCE CAN DAMAGE THE BEARINGS.
- 6) Prise plastic spindle cover(23) off casting.
- 7) Remove circlip(48) from end of spindle.
- 8) Gently drift the spindle out of the headstock casting, bearing(55) should remain behind.
- 9) Once the bearing(54A) is free of the casting, move the spindle as far in the inboard direction as possible - there should be room to slip the belt between the casting and spindle end and over the pulley.
- 10) push the spindle assembly back into the rear bearing(55) and seat the bearing(54A) back into the casting. To help seat the bearing use a mallet and tube as a drift. Use the main bearing housing ring(6) against the bearing as this will apply the force to the outer bearing housing. Once the bolts(26) gain sufficient purchase. Fit the sprung washer between the housing ring(6) and bearing (54A) and gradually tighten the bolts in a diagonal pattern to push the bearing back into the casting. Tighten the four bolts(26).
- 11) Fit the circlip(48) to the rear of the spindle and push the plastic spindle cover(23) back into place.
- 12) place belt round motor pulley and tighten up motor bracket at the correct belt tension



