



COGSDILL TOOL

products, inc.

Field Service Instructions For Nobur® JA-2000 Recessing Heads

Disassembly and reassembly procedures

The pilot and cutter arm assembles into the Nobur® JA-2000 recessing head in the same manner as the standard JA/JC units. This procedure is shown in pictorial fashion earlier in this brochure. However, **parts are not interchangeable between the JA/JC and JA-2000 models.**

Unlike the JA/JC heads, which cannot be disassembled without special tools, the JA-2000 head can be disassembled in several minutes using only a few hex wrenches. This provides for ease of maintenance, as well as easy conversion of a tool from through-shank coolant to side-port coolant, or vice versa.

Disassembly of the Nobur® JA-2000 recessing head

1. Remove the stop collar (detail 21) by loosening the set screw (detail 19) - use a 1/8" hex wrench. Unscrew the stop collar counter clockwise until it comes free of the

housing. Also remove the two flat point screws (detail 7) from the shank with the 1/8" hex wrenches.

2. Remove the outer housing (detail 18) by removing the three set screws that hold the bearing retainer (detail 20) in place - use a 3/32" hex wrench. Once the bearing retainer has been removed over the shank, slide the housing forward and off the front of the body assembly.
3. Loosen the locking screw (detail 9) in the stop nut (detail 8) with a 5/32" hex wrench. Screw stop nut counter clockwise to remove it from the shank.
4. Loosen the 3 screws in the bearing collar (detail 14) with a 5/64" hex wrench. Remove bearing collar by pulling it forward and off the nose of the tool; the three leaf springs (detail 16) will come out of their slot when the collar is removed.
5. Slide the bearings (detail 11) and the bearing spacers (detail 12 and 13 if through-shank coolant tool; details 23, 24, 25 if side-port coolant tool) forward and off the front of the tool with the bearings.
6. Remove the bearing sleeve (detail 10) from the spindle (detail 1) by compressing the spring (detail 3) slightly - use a hex wrench inserted into the open end of the head and apply pressure to the spacer bushing (detail 4) to compress the spring. While holding the spring in its compressed state, slide the pin (detail 5) out of the assembly by pushing it through the spindle with another hex wrench. CAREFULLY release the spring pressure after the pin has been removed.

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7. The bearing sleeve (detail 10), spindle (detail 1), spring (detail 3), and spacer bushing (detail 4) can now be disassembled.

Reassembly of the Nobur® JA-2000 recessing head

To reassemble the JA-2000 head, simply reverse the above procedure, keeping the following things in mind:

1. The cross-holes in the spindle (detail 1) are offset to the centerline. When reassembling the items in step no. 7 above, be sure to orient the front end of the spacer bushing (detail 4) so that the short step will be in line with the cross-holes in the spindle.
2. Use care when compressing the spacer bushing (detail 4) and spring (detail 3). Release the pressure carefully only after the pin (detail 5) is fully inserted into both cross-holes in the spindle (detail 1).
3. When installing the three leaf springs (detail 16), stack them on top of each other and locate them in the slot on the side of the bearing sleeve (detail 10). Hold them in place while sliding the bearing collar (detail 14) into place. Be sure that the groove in the back of the bearing collar is oriented to slide over the back ends of the three leaf springs. Lock the collar in place with the three set screws - these should locate in the 'v' groove on the outside diameter of the bearing sleeve.
4. Install the rear bearing retainer (detail 20) so that the side with the small counter-bore is next to the top bearing. The locking screws should locate in the 'v' groove on the outside diameter of the retainer.

Converting from side-port coolant to through-spindle coolant, or vice versa

1. Disassemble head as instructed above through step no. 5.
2. When converting from a through-spindle coolant configuration to a side-port coolant configuration, remove the two bearing spacers (details 12 and 13). Reassemble the head with spacers and O-rings (details 23, 24, and 25). Also install the coolant nipple into the threaded hole in the housing (detail 18), and screw the pipe plug (detail 27) into the shank.
3. When converting from a side-port coolant configuration, remove the pipe plug. (Install a plug in this hole, making it sure it does not protrude into the inside diameter of the housing.) Remove spacers (details 23, 24, and 25). Reassemble the head with through-spindle coolant spacers (details 12 and 13). Also remove the pipe plug (detail 27) from the shank so coolant can flow through it.



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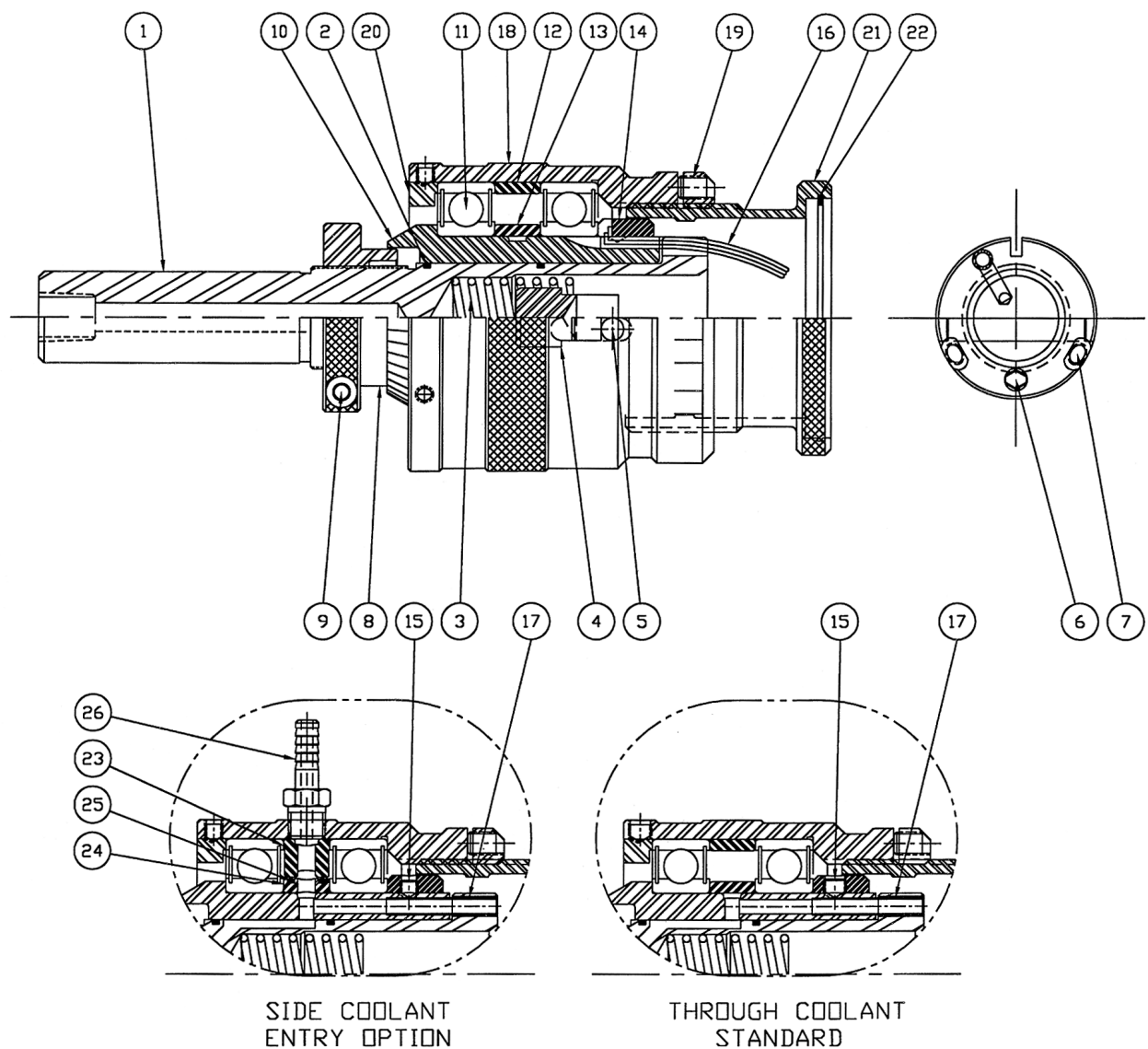
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* Details 23 thru 27 Optional