

## Spindle Handwheel

P/N 2049, 2049-DRO

The spindle handwheel was designed to make the task of controlling the spindle easier. With it, you can quickly stop the spindle or turn it by hand to tap a thread or inspect a part.

We also offer a version (P/N 2049-DRO) that has a longer, 1.625" shaft to prevent interference with the DRO RPM sensor (see Figure 1).

### Installing the Spindle Handwheel

The spindle handwheel is installed on the end of the headstock spindle shaft next to the drive pulley (see Figure 2). There is a hole drilled in the spindle shaft, and the cone point set screw in the handwheel should be aligned to index in the hole. If you cannot push the handwheel onto the shaft far enough to engage the hole, it may be because the pulley has been moved slightly on the shaft. If this is the case, loosen the set screw holding the pulley and move it closer to the headstock so that the handwheel set screw can align with the hole.

### Maintaining the Handwheel Finish

Most Sherline steel parts are finished with a black oxide coating to prevent rust, however, a polished steel part has a better "feel". For that reason we left the steel on the handwheel unfinished. Using the handwheel will keep the outside diameter shiny. If you live in a humid climate, the handwheel can be polished using a Scotchbrite® pad or fine steel wool to remove any rust that may form. Since it rotates with the spindle, polishing it while it is rotating is an easy task. Before you store the machine, wipe on a light coating of rust preventative or light machine oil.

Thank you,  
Sherline Products Inc.

FIGURE 1— The DRO spindle handwheel with the longer shaft.

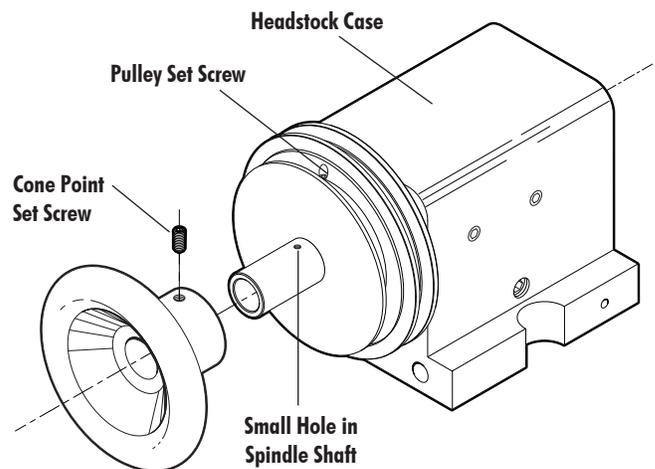
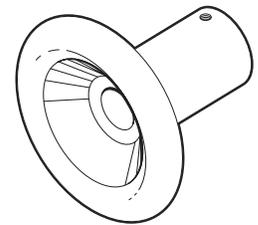


FIGURE 2—The point of the handwheel set screw should go into the hole in the spindle shaft. In case the pulley needs to be moved toward the headstock case, the set screw is located in the smaller pulley groove.