• Remove the spindle unit.
  1. The spindle and the spindle unit are not in contact with each other.
  2. The distance between the conductive plate and the spindle unit is 0.7 mm or less. (For your reference, the conductive plate is 0.12 mm thick.)

2. Preparing for Replacement
- Move the spindle unit into the standby position, and turn the power on.
- If the milling bur is attached to the spindle unit, press the operation button on the main unit, and remove the milling bur from the spindle unit.

3. How to start VPanel from the Windows [Start] screen (or [Start] menu)
  Windows 8 / 8.1:
  Right-click the background in the [Start] screen to display the app bar, and click [All Apps]. Click the VPanel for DWX-51D icon under Roland DWX-51D. To operate the DWX-51D, click the VPanel for DWX-51D icon under Roland DWX-51D.

4. Adjusting the Position of the Conductive Plate
- Check the position of the conductive plate.
  Verify the following 3 points. If all points have been met, go to step 6.
  a. If any point has not been met, go to step 6.
  b. The conductive plate and the spindle unit are not in contact with each other.
  c. The conductive plate and the spindle unit do not come into contact with each other or produce an abnormal noise when the motor pulley rotates.
  d. The distance between the conductive plate and the spindle unit is 0.7 mm or less. (For your reference, the conductive plate is 0.12 mm thick.)

1. Loosen the screws.
2. Rotate the adjustment screws to the left or right to move the conductive plate to a position that meets the requirements in step 6.

5. Operation after Replacing the Spindle Unit
- Run in the spindle unit.
  Failure to run in the spindle may result in unstable spindle rotation. Refer to the manual included with the milling machine for how to perform the work.
  a. Check for abnormal noise during run in.
  b. If an abnormal sound is generated, the conductive plate may be in contact with the spindle. Start over from step 6 in section 4.
  c. Perform automatic correction of the milling machine.
  d. If automatic correction is not performed, the cutting results may be undesirable. Refer to the manual included with the milling machine for how to perform the work.

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