



Lathe upgrade kit part numbers:
P/N 6720/6725—Model 4000/4500 lathes
P/N 6730/6735—Model 4400 lathe
P/N 6760/6765—All lathes, crossslide only
P/N 6780/6785—Model 4000/4500 lathe, leadscrew only
P/N 6790/6795—Model 4400 lathe, leadscrew only

NOTE: The instructions provided here cover all axes on all lathe models. If your kit is for just one axis, not all of these instructions will apply to your particular installation.

**SHERLINE
PRODUCTS**
INCORPORATED 1974

Installing CNC Stepper Motor Mounts on a Sherline Lathe

Using the Template Blocks to Locate New Mounting Holes for the Stepper Motor Mounts

This kit contains two template blocks that will help you locate the holes needed to fit stepper motor mounts to your existing Sherline lathe. (Sherline lathes now in production have the table holes predrilled to make this job easier.) The rectangular block is used to locate the holes in the lathe crossslide table (See Fig. 1). The round template is used for the lathe bed (See Fig. 2). These blocks are not hardened, because they will only be used once or twice and the wear on them will be minor. To drill the hole pattern for the stepper motor mount for each axis, follow the steps below:

1. To minimize leadscrew deflection when reinstalling, use the crossslide handwheel to move the table so the handwheel is as close to the saddle as possible. Then move the saddle so it is as close to the leadscrew handwheel as possible.
2. On models with standard handwheels, break loose the 5-40 screw in the center before removing the handwheel. The handwheel gives you a way to hold the leadscrew while breaking the center screw loose.
3. Remove each of the two handwheels by loosening its set screw with a 3/32" hex wrench and pulling it off the shaft. (For adjustable "zero" handwheels, rotate the collar until the hole lines up with the set screw.)
4. Remove the crossslide thrust from the crossslide table. It is held on by a single 5-40 screw.
5. Remove the leadscrew and thrust from beneath the bed. To do so, remove the socket head cap screw that holds the saddle nut to the saddle. Then remove the two screws that hold the leadscrew thrust to the bed and base. The bed screw is a countersunk screw that comes down from the top of the bed. (Move the tailstock toward the headstock if necessary to expose the screw head.) The other is a socket head screw that comes up from below the base into the bottom of the thrust. Remove the leadscrew/thrust/saddle nut assembly.
6. Bolt the rectangular template to the table using the center hole and one of the 5-40 SHCS provided with the kit. Once level with the table, clamp it in place so it can't move.
7. Using a "C" clamp, clamp the round template to the lathe bed with the hole pattern leveled (See Fig. 2). Measure the height of each hole from the top surface unless you are pretty good at knowing when something is level by eye. It is not critical to its function that the stepper motor be mounted level, but it looks much more professional when it is.

8. Using the holes in the template as a drill guide, start each hole about 1/16" deep with a #29 or 0.136" drill.
9. Next, drill the holes to 0.25" deep, backing the drill out to clear chips. Add cutting oil and finish drilling the hole in two more steps to a depth of 0.50". Countersink the hole slightly with a center drill to make it easier to start a tap.
10. Tap the holes to 8-32 to at least 0.4" deep. Use tapping fluid as you cut the threads. Use the tap carefully. Remember that you are working on a part that is relatively expensive to replace if you break a tap off in the hole. Take your time.
11. Make sure there are no burrs on the surface of the part after tapping the hole. Deburr if necessary.
12. Unscrew the saddle nut from the old leadscrew and thread it onto the new CNC leadscrew. Locate the new CNC leadscrew thrust (P/N 67040) that shipped with your upgrade kit and attach the thrust to the base and bed using the same countersunk screw and socket head screw that held the old leadscrew thrust in place. (In case it came off, the end of the collar with the larger diameter hole goes toward the stepper motor mount.)
13. Attach the stepper motor mount to the bed using the two socket head screws provided. Reattach the saddle nut to the saddle. Adjust the saddle nut. (See adjustment

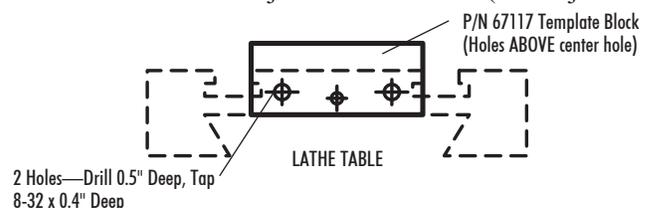


FIGURE 1—The rectangular block is used for the lathe table. The two new drilled holes will be drilled ABOVE the existing center hole as shown in the drawing above.

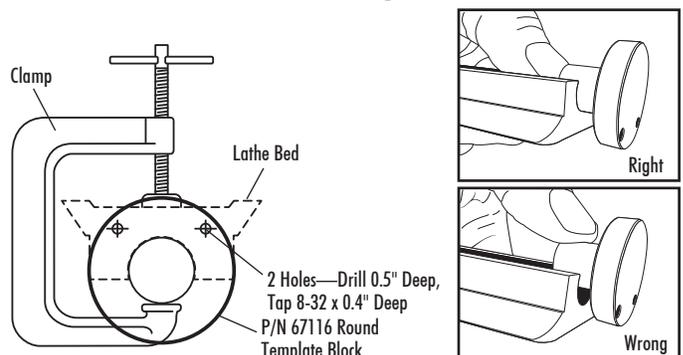


FIGURE 2—The round center of the template block registers in the center portion of the lathe bed, not on top. Rotate the template until the holes are level and clamp in place while starting holes.

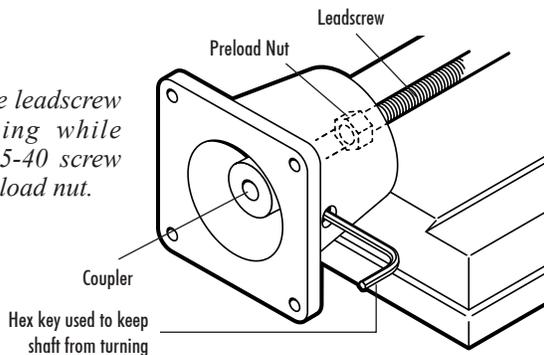
instructions that follow at the end of the next column.)

Installing the Crossslide Stepper Motor Mount

1. Before you start, look at the cross-section view in Figure 4 and at the exploded view for the parts list. One of the most important parts of the assembly is to be sure that the preload nut is installed with the counter bore facing the bearing.
2. Thread the preload nut onto the crossslide screw. **Note:** The C'bore side of the preload nut must be facing the bearing as shown in the exploded view on the following page.
3. Slide the stepper motor mount over the leadscrew end.
4. Push a coupler through the bearings and over the tapered end of the leadscrew. Attach it to the leadscrew with the new 5-40 screw provided. To tighten, put a hex key through the hole in the side of the mount and into the handwheel shaft set screw. Hold the key to keep the shaft from turning while tightening the 5-40 SHCS in the end of the coupling. (See Figure 3.)

FIGURE 3

Keeping the leadscrew from turning while tightening 5-40 screw and the preload nut.



NOTE: In the drawing above, the mill base is used as an example, but the same technique is used on the lathe. The hex key adjustment hole may be located on either side depending on the axis. On older models the hole may be on the bottom instead of the side as is shown here.

5. Using a 3/8" wrench, adjust the preload nut snugly against the end of the bearing. Tighten it enough to remove all endplay. (See Figure 4 to understand how the nut preloads the bearings.) Turn the coupling by hand to make sure it turns freely, then put a little LocTite® on the threads behind the preload nut and let capillary action draw the fluid in.
6. Attach the stepper motor mount to the table or bed by installing two 8-32 x 3/4" SHCS provided. This will insure proper alignment. The 8-32 socket head screws go inside the motor mount and thread into the tapped holes in the bed or table. Before tightening the screws, turn the coupler by hand to make sure the mount is properly aligned and is not putting tension on the leadscrew. The holes in the mount are slightly oversize to allow for minor alignment adjustments. Check again for proper alignment by again hand-turning the coupler to assure there is no binding after the final tightening of the screws.

Attaching a Stepper Motor to the Mount

Sherline stepper motors come with a flat machined on the shaft in the proper location. If you are using another stepper motor, a flat must be filed or machined on it where

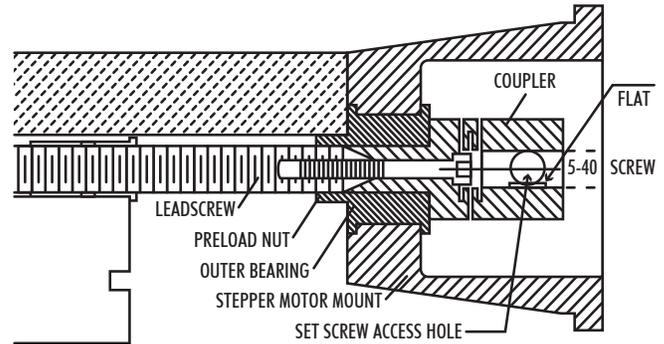


FIGURE 4—A cross-section of the stepper motor mount shows how the coupler is attached to the leadscrew.

the coupling and handwheel set screws are to be tightened against it. See the cross-section on the attached sheet for location of the flat. File a flat or use your mill to machine a flat on the shaft. (If a flat is not provided, the set screw will raise a burr, making it difficult or impossible to remove the shaft from the hole later.) Push the shaft into the coupling and tighten the set screw on the flat. Attach the stepper motor to the mount using the three socket head cap screws provided. The fourth hole can be used for a "cable tie" to secure the cable or for a fourth set screw at your discretion. Attach a handwheel to the shaft on the other end of the stepper motor.

Adjusting the Saddle Nut

The adjustment for the saddle nut consists of two flat set screws on either side of a 10-32 socket head cap screw that attaches the saddle nut to the saddle. With the saddle nut located on the leadscrew close to the stepper motor mount, loosen these two screws and slide the saddle into position over the saddle nut. Put the 10-32 socket head cap screw through the saddle and screw it into the saddle nut, but do not tighten it yet.

Adjust the set screws until the flat points touch the saddle nut, and then tighten the 10-32 socket head cap screw. Watch as you tighten to see that the leadscrew doesn't move. If it does, loosen the screw, readjust the set screws and retighten.

What we are attempting to accomplish is to have the saddle nut ride on the leadscrew with the minimum amount of drag. You can check the drag by turning the leadscrew handwheel. If you feel drag, tighten or loosen a single set screw while moving the saddle with the handwheel until the handwheel turns freely, but keep the saddle close to the handwheel. If you adjust the saddle nut while it is in the center of the leadscrew, it may be slightly off center but will feel free until the saddle gets close to either end of its travel. Here, the leadscrew is supported and cannot deflect, so it will bind. If you can't eliminate the binding, tap the saddle nut with a plastic hammer on the leadscrew side while the saddle nut is tightly attached to the saddle and readjust. Don't use the machine with a loose attachment screw as this will cause excessive wear and backlash.

Thank you,
Sherline Products Inc.

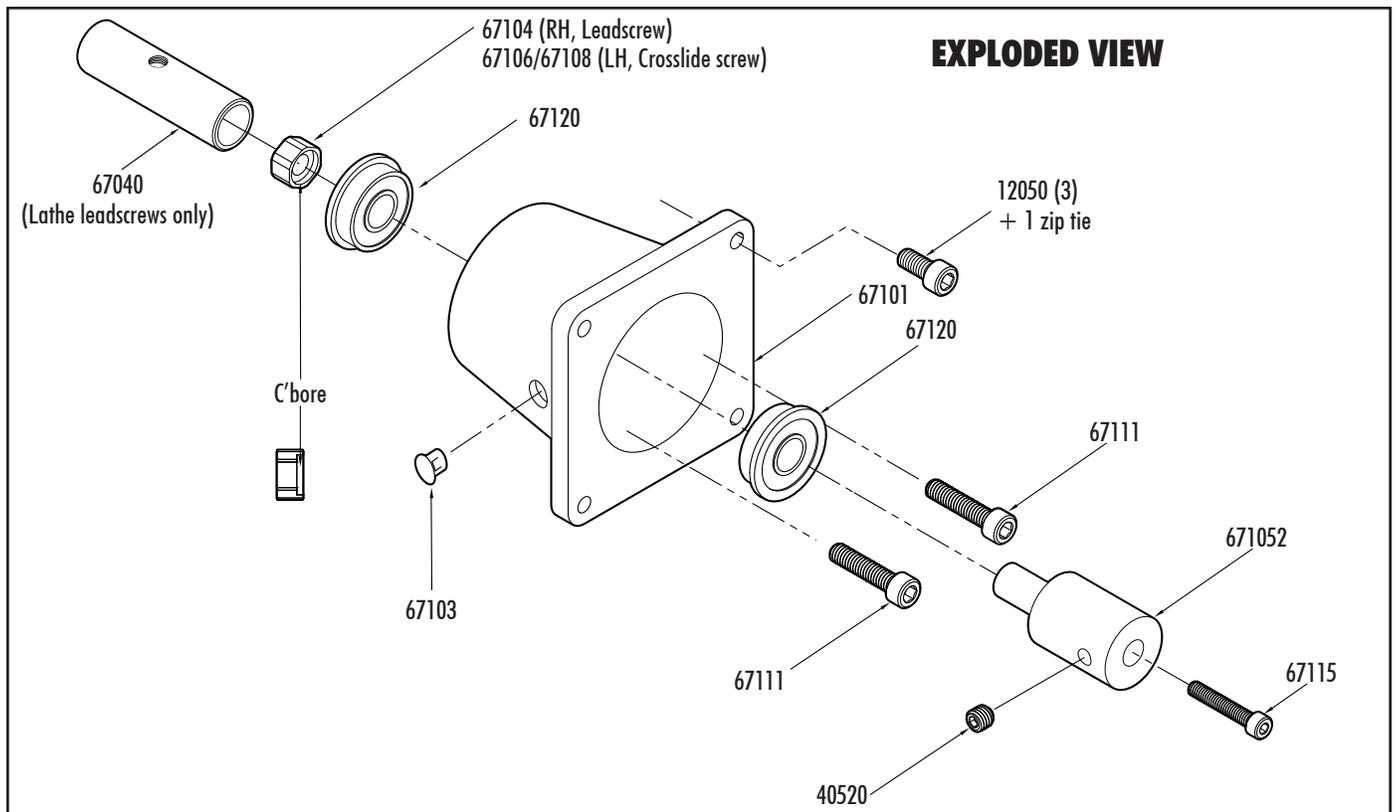
KIT FOR SHERLINE LATHES, MODEL 4000/4100, 4500/4530, 4400/4410

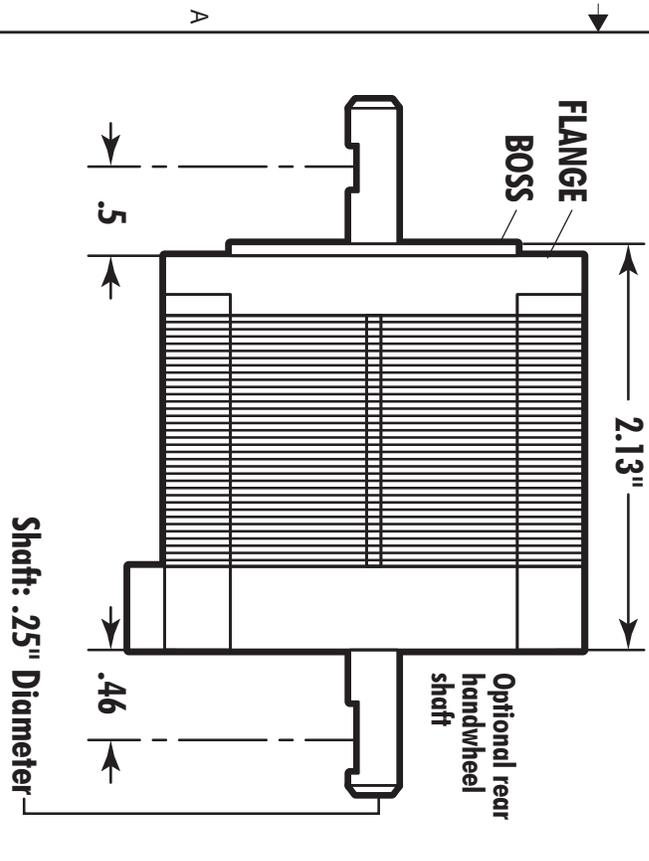
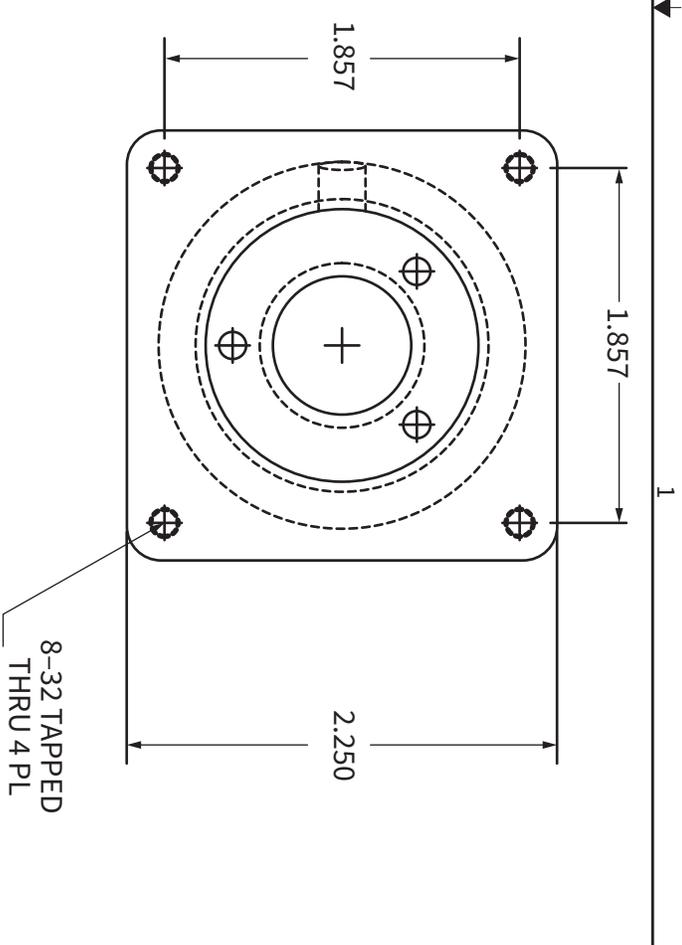
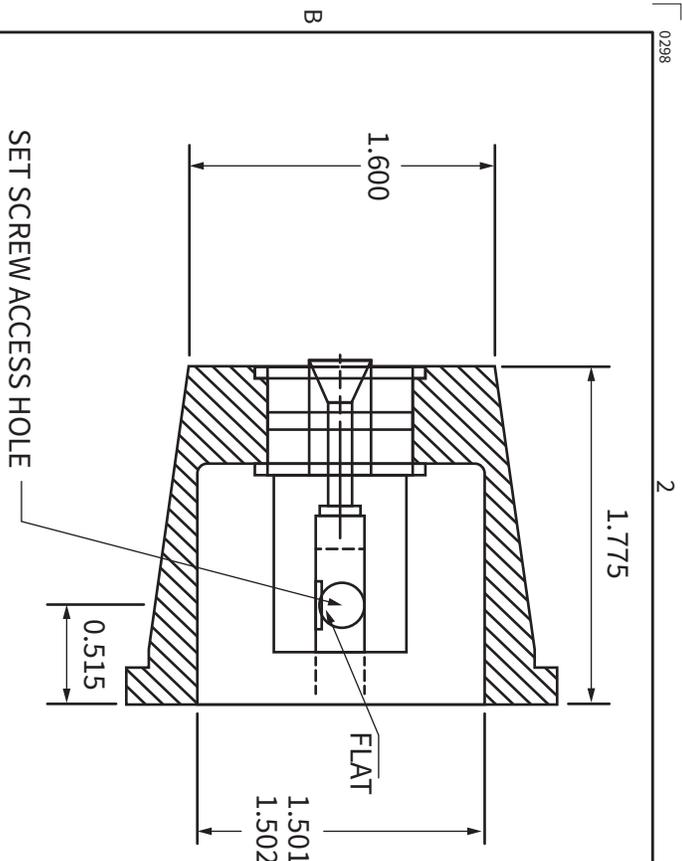
Parts List , Crossslide CNC Mount Upgrade

NO. REQ.	PART NO.	DESCRIPTION
3	12050	8-32 x 3/8" SHCS (To attach stepper motor to mount)
1	40520	10-32 x 3/16" cup point Set screw
1	67101	Stepper motor mount
1	67103	Stepper motor mount cap
1	671052	Coupler
1	67106/67108	Preload nut (LH), crossslide
2	67111	8-32 x 7/8" SHCS
1	67115	5-40 x 7/8" SHCS
1	67117	CNC template, slide bushing (rectangular, not shown)
2	67120	Bearing
1	81080	Black tie 4" wrap

Parts List , Z-Axis CNC Mount Upgrade

NO. REQ.	PART NO.	DESCRIPTION
3	12050	8-32 x 3/8" SHCS (To attach stepper motor to mount)
1	40520	10-32 x 3/16" cup point Set screw
1	67024/67025	Leadscrew (4000-series lathes, not shown)
1	67026/67027	Leadscrew (4400-series lathes, not shown)
1	67040	CNC lathe leadscrew thrust
1	67101	Stepper motor mount
1	67103	Stepper motor mount cap
1	67104	Preload nut (RH), leadscrew (used for both inch and metric)
1	671052	Coupler
2	67111	8-32 x 7/8" SHCS
2	67115	5-40 x 7/8" SHCS
1	67116	CNC template, bed bushing (round, not shown)
2	67120	Bearing
1	81080	Black tie 4" wrap





If using a non-Sherline stepper motor, make sure to grind flats on the shafts as shown where the coupling and handwheel set screws contact the shaft.

Mounting Instructions

To mount the motor, start by turning the lead screw until the coupling set screw lines up with the access hole in the mount. Carefully insert the motor shaft into the coupling. With the flanges touching, rotate the stepper motor until the flat on the shaft is in alignment with the coupling set screw. Tighten the set screw. Rotate the motor to align with the motor with the 8-32 tapped holes. We usually attach the motor using three screws and use a zip tie in the fourth hole to secure the wire bundle.

If you decide to use LocTite® on the shaft set screw, a problem can occur if the motor has to be removed. What can happen is the shaft ends up glued to the coupling. If this occurs, loosen the preload nut until the motor and shaft can be backed out to expose the coupling so you can work on it. Be careful not to flex the coupling or it can break at the dampening slots.

DO NOT SCALE DRAWING !!! UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS .00 ±0.006 DECIMALS .000 ±0.003 ANGLES 1° DEBURR NONE HEAT TREAT NONE		TITLE SHERLINE STEPPER MOTOR MOUNT		SHERLINE PRODUCTS, INC.	
FINISH BLACK ANODIZE		SCALE 1 = 1		SIZE A	
DRAWN JOE MARTIN		PART NUMBER 67101		REV. 1998-09	
CHECKED JOE MARTIN		MATERIAL 3 5/16 ROUND 6061 T6		SHEET 1 of 1	
DESIGNER JOE MARTIN					



SHERLINE STEPPER MOTOR SPECIFICATIONS

Sherline P/N:	67127 (w/ DIN plug and flats on shaft) 67130 (no plug, flats on shaft)
Frame size:	NEMA #23
Step angle:	1.8°
Voltage:	3.2 V DC
Current:	2.0 A/Φ
Resistance:	1.6 Ω/Φ
Inductance:	3.6 mH/Φ
Holding torque:	.775 N.m (Newton meters) 7.9 kg-cm 109.71 oz/in (ounce inch) 6.856 in/lb (inch pound)
Rotor inertia:	250 g-cm ²
Number of wire leads:	6 (See color code diagram FIG. 2)
Weight:	1.32 lb (0.6 Kg.)
Length:	2.13" (54 mm)
Shaft:	Double ended, 1/4" diameter

See figure 3 for the pin diagram and wire color layout of the stepper motor connector cables we supply with our stepper motors. Since there is no industry standard for wire colors in this field, if using a connector not supplied by Sherline each pin and color should be confirmed with a continuity tester before applying power.

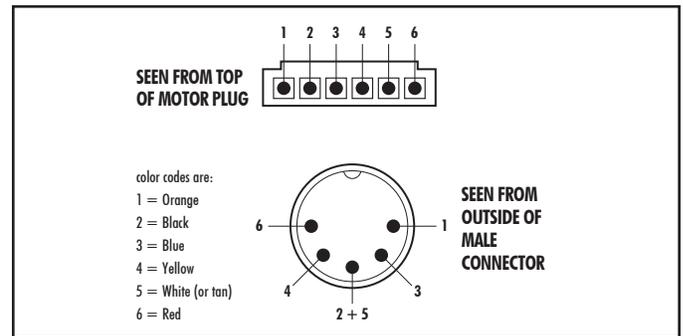


FIGURE 3: diagram shows which pin in the DIN connector is wired to which position in the motor connector.

NOTE: Motors can be wired in either unipolar or bipolar configuration depending on how the leads are connected. Sherline motors with plugs are wired for unipolar operation.

PRECAUTIONS

- Make sure the ends of raw wires are not touching each other when turning the handwheel by hand to drive the stepper motor and leadscrew. It can cause the motor to feel rough and hard to turn.
- DC motors generate current when hand cranked that can damage the control unit. When positioning a stepper motor by hand using the handwheel, do not crank faster than about 1 rev/second. For long travels, use the jog mode of your CNC control software.
- Poor connections can cause arcing, which can burn out motors or control chips. Always make sure plugs and connections are fully engaged and making good contact.
- Always turn off driver box power before plugging in or unplugging a stepper motor.

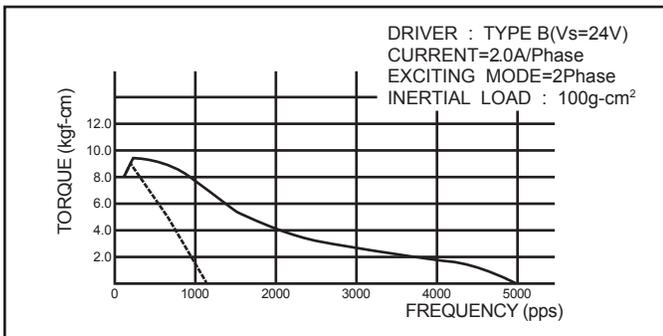


FIGURE 1—Motor torque curve

Lead Wire Connection and Color Code

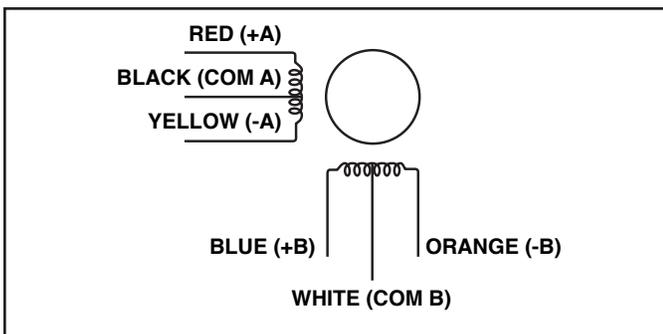


FIGURE 2— Color of internal wiring for NMB motors