



# Removing a Frozen Chuck or End Mill Holder from the Headstock Spindle

## End Mill Holder and Chuck Removal

We strongly suggest putting light oil or Never-Seize® on the threads of your chuck and end mill holders. The threads are held to a very tight tolerance, which is almost an interference fit in order to keep the amount of run out to the absolute minimum.

If your chuck or end mill holder will not unthread easily from the spindle, do the following:

1. If possible, place a Tommy bar all the way through the headstock spindle with enough extending from one side to come in contact with the bed. You want the Tommy bar directly against the bed, not against a piece of wood or any other part or material.
2. Place another Tommy bar in the access hole of the chuck or end mill holder to orientate the holder so this Tommy bar can be forced towards the bed in a counter-clockwise rotation of the chuck or end mill holder (as viewed from the bottom of the holder) (see Figure 1).

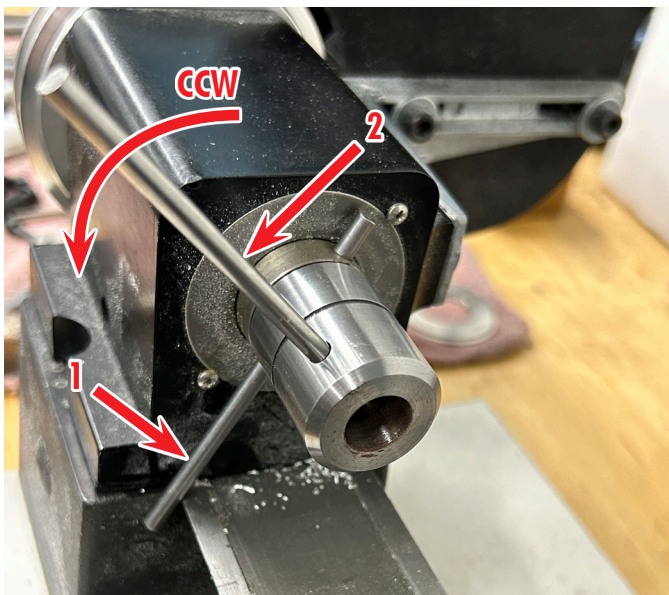


FIGURE 1—#1 shows the Tommy bar inserted through the headstock spindle. #2 shows the Tommy bar inserted in the access hole of the holding device.

3. With the holder and Tommy bars orientated as shown, place a piece of aluminum or steel stock against the

Tommy bar that is in the holder. You want the contact point to be as close to the entrance of the access hole in the holder as possible (see Figure 2).

- A. What breaks the holder or chuck free from the spindle is a sharp shocking blow to the Tommy bar while the spindle is being held securely so it can't move.

If you use a “dead-blow hammer,” plastic-head hammer, or have anything between the spindle Tommy bar and the bed that will move or cushion the impact of the shocking blow, there will be no sharp shocking blow.

- B. Now strike the end of the stock with a steel hammer so the impact point is at the top of the access hole. It may take two or three sharp blows (see Figure 2).

This will break the chuck or holder free from the spindle thread 90% of the time.

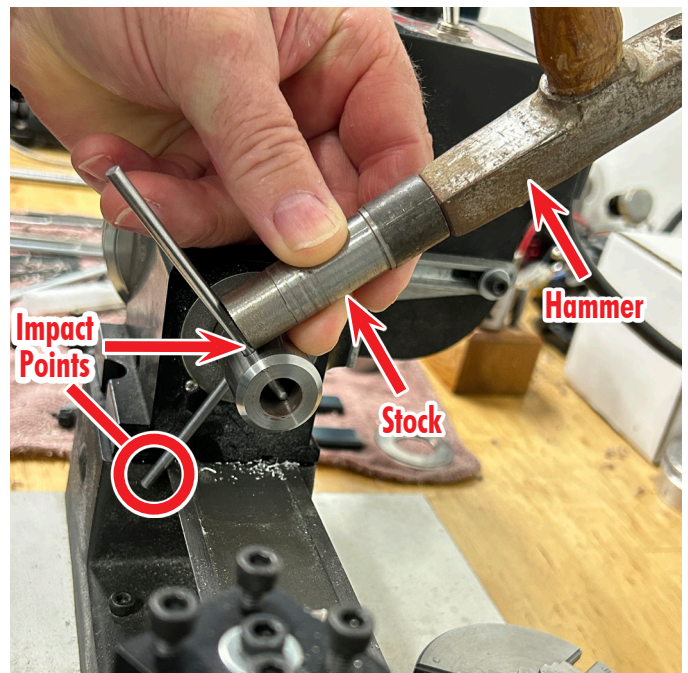


FIGURE 2

Thank you,  
Sherline Products Inc.