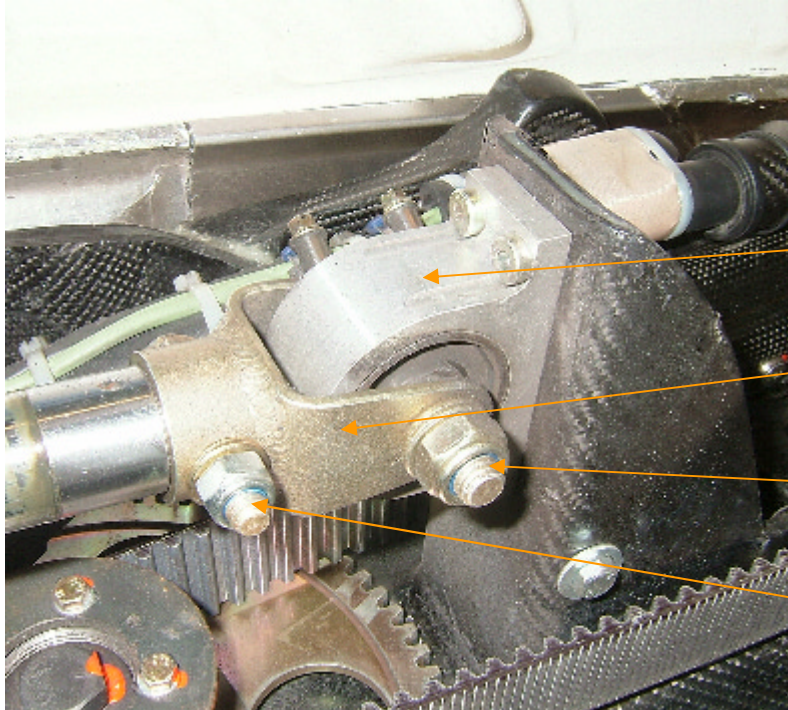


**Working instruction for safetying of the spindle drive fork between the spindle drive  
"Stross BSA10" and the spindle drive motor on the DG-500MB.**

1. Remove the bolt M10x58 between spindle drive and powerplant (see photo).



Bearing support  
5M229  
Lagerbock 8M229

Fork 8M233  
Gabel 8M233

Bolt M10x58  
Schraube M10x58

Bolt M8x45  
Schraube M8x45

2. Remove the bolt M8x45 fixing the fork 8M233/1 to the spindle drive and remove the fork from the spindle drive (see photo at item 1).
3. Inspect the fork for cracks using a magnifying glass and a pocket torch. Especially check for cracks around the weld. If there are any indications of cracks, the fork must be replaced see items 5, 6 and 7. In case of doubt the fork must be replaced.
4. Reassemble fork, bearing support and powerplant with additional safety cable according to drawing 5M210"c". To accomplish this insert bolt M8x62 with washer 8,4 DIN9021, bushing 8M226/1 and safety cable 5M210/1 through the fork and spindle drive. Insert bolt M10x65 with washer 10,5 DIN9021 and bushing 8M226/2 through the safety cable, the fork and bearing support. On the other side fit bushings 8M226/1, 8M226/2 and the second safety cable. Fit washers 8,4 DIN9021 and 10,5 DIN9021 and nuts M8 DIN985 and M10 DIN985 and tighten the nuts.

**Items 5, 6 and 7 must only to be performed if the fork must be replaced, see item 3.**

5. Exchange fork against strengthened fork 8M233"f"
6. Replace the bearing support by modified support 8M229"e" (Not applicable for ser.no. B12, B16 and B17).
7. Reassembly analogous to item 4. but according to drawing 5M211 with securing cables 5M211/1.