Basic Retrofit Instructions

Remove old cross-slide and turret from dove-tail:
Replace with OmniTurn slide & servo-motors.

DSM ONLY:
Install headstock riser to provide correct center-line height.

Remove old electronics cabinet:
Replace with OmniTurn spindle drive cabinet.

Mount OmniTurn CNC control.

Mount OmniTurn operator’s station

Install spindle motor/threading encoder assembly
HARDINGE DSM MODIFICATION FOR DIRECT DRIVE RETROFIT

**EXISTING DSM PULLEY**

**MODIFY THE HARDINGE DSM PULLEY AS SHOWN TO ACCEPT MODIFIED GOODYEAR Y-48S-SDS SPROCKET**

(3) 1/4-20 thru on 4.00 dbc

3.000 DIA.

TURN TO 3.000 DIA.
FACE SHOULDER TO ACCOMODATE SPROCKET

**GOODYEAR Y-48S-SDS SPROCKET**

**DRILL (3)"F" THRU ON 4.00 DBC**

**BORE SPROCKET TO 3.000 FOR SLIP FIT ON PULLEY**

**CHAMFER TO FIT FLUSH TO SHOULDER**

**ASSEMBLE AS SHOWN**

1/4-20 x 1.00 SHCS (3)