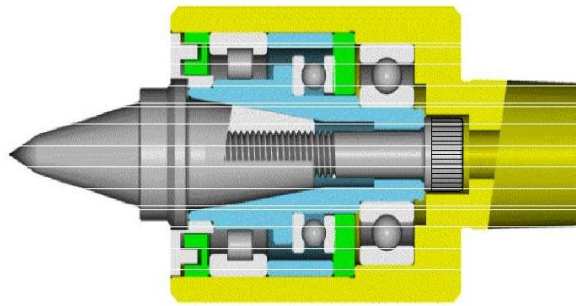


HOW TO CHANGE BEARINGS OF PRASHTECH LIVE CENTERS?

1. Remove the Tip (Bullet) from Center as usual.
2. All parts are to be removed from the front side. In case of **MT5** Center the Cap is press-fitted. In case of **MT3** & **MT4** Centers instead of Cap, Rotating Labyrinth is provided. In either case, it gets ejected along with other parts by following procedure.
3. Take a **hardened** rod of Dia. 7.5mm or less X 150mm long in case of MT4 & MT5. In case of MT3 it should be of Dia. 5.5mm or less X 100mm.
4. Remove Seal Plug at the end of taper shank. Insert rod through a hole in the shank. Place end of this rod in the socket of the Draw Bolt inside.
5. Hit the rod-using hammer while supporting the periphery of the Housing on the table. Thus entire sub-assy will come out of the Housing.
6. This sub-assy consists, in this order - Cap or Labyrinth (Two parts), Cylindrical Roller Bearing, Pipe Spacer, Thrust Bearing, Disc Spacer, Wave Washer, Ball Bearing, Circlip (in certain models) and Draw Bolt at the rear end, all parts in line with Sleeve. One part of Labyrinth is press-fitted to Sleeve at its front end. Whereas other part was press-fitted into Housing.
7. Separate outer part of Labyrinth. Then its inner part, Cylindrical Roller Bearing & Pipe Spacer will be free. Next remove the Ball Bearing by pushing Disc Spacer towards rear end of Sleeve with the help of hollow pipe. This will separate all the parts on outside diameter of Sleeve except rotating race of Thrust Bearing. Remove this race using another hollow pipe of suitable size.
8. In MT5 Centre, Oil Seal is provided. Such Oil Seal is press-fitted in the Cap from inside face. Replace it if it is damaged.
9. Clean all the parts thoroughly using cleaning agents. Replace all damaged parts & Bearings. Use KLUBER NBU 15 grease for lubrication. Assemble all the parts in original sequence and direction. Press-fit Labyrinth on Sleeve at the end.
10. We recommend using such repaired Center for secondary machining operations on manual lathes. Always use new **PRASHTECH** Live Centers and fresh Tips for important operations on CNC as well as manual machines for total reliability and controlled run-out.
11. Order spares according to ordering nos. mentioned in the following table.



SPARE PARTS / ASSLY	MT3		MT4		MT5	
	QTY per Center	Ordering No.	QTY per Center	Ordering No.	QTY per Center	Ordering No.
Sub-Assly sleeve with draw bolt including all Bearings	1	FLCMT307006	1	FLCMT407010	1	FLCMT507013
Sleeve with Draw Bolt	1	P/N 101.003.0	1	P/N 111.003.0	1	P/N 120.003.0
Housing	1	P/N 101.100.0	1	P/N 111.100.0	1	P/N 120.100.0
Rotating Labyrinth	1	P/N 101.111.0	1	P/N 111.111.0	----	NA
Stationery Labyrinth	1	P/N 111.110.0	1	P/N 111.110.0	----	NA
Cap with Oil Seal	---	NA	---	NA	1	P/N 120.004.0
Disc Spacer	1	P/N 101.106.0	1	P/N 111.106.0	1	P/N 120.105.0
Pipe Spacer	1	P/N 101.107.0	1	P/N 111.107.0	1	P/N 120.106.0
Draw Bolt with 'O' Ring	1	P/N 101.004.0	1	P/N 111.004.0	1	P/N 120.005.0
Seal Plug with 'O' Ring	1	P/N 101.002.0	1	P/N 111.002.0	1	P/N 120.002.0
Special Allen Key	1	P/N 101.105.0	1	P/N 120.104.0	1	P/N 120.104.0
Cylindrical Roller Bearing [Strictly use specified make]	1	P/N 900.400.0	1	P/N 900.400.0	1	P/N 900.401.0
		NU-205 [NRB]		NU-205 [NRB]		NJ-2206 [NSK]
Thrust Ball Bearing	1	P/N 900.403.0	1	P/N 900.403.0	1	P/N 900.405.0
		51105		51105		51106
Deep Groove Ball Bearing	1	P/N 900.407.0	1	P/N 900.407.0	1	P/N 900.408.0
		6204		6204		6205
Wave Washer	1	P/N 900.228.0	1	P/N 900.228.0	1	P/N 900.229.0
Circlip	---	NA	1	P/N 900.200.0	1	P/N 900.201.0
				A 20		A 25
Oil Seal	---	NA	---	NA	1	P/N 900.108.0
						33 X 52 X 6
'O' Ring For Draw Bolt	1	P/N 900.101.0	1	P/N 900.102.0	1	P/N 900.102.0
		5.28 X 1.78		7 X 1.78		7 X 1.78
'O' Ring For Seal Plug	1	P/N 900.103.0	1	P/N 900.103.0	1	P/N 900.103.0
		9.25 X 1.78		9.25 X 1.78		9.25 X 1.78
Grease Pouch [For Single Assly.]	---	P/N 900.220.1	---	P/N 900.220.1	---	P/N 900.220.2