



SPINDLE BREAK-IN and STORAGE PROCEDURE

Break-In

Please observe the following procedure to “break-in” your new, or newly repaired unit properly.

1. Start the unit at 10% of the maximum speed.
2. Run it for about 30 minutes.
3. Monitor the temperature closely, not to exceed 60° C (140° F) at the bearing housing.
4. If the unit is running at an acceptable temperature, increase the RPM by 10%.
5. Repeat steps 2, 3, and 4 until maximum RPM is reached and the temperature at the bearing housings level out within acceptable limits.

If at any point the temperature exceeds 60°C, STOP THE SPINDLE and let it cool to room temperature, then begin the procedure again at speed -10% where you left off.

Centerline also recommends the above break-in procedure for spindles that have been in storage for an extended period of time, especially grease lubricated units.

Centerline performs spindle break-in (if possible on the spindle type) at our facilities as a standard procedure in our final Quality Control inspections after performing your spindle repair. If you are receiving your spindle back after repair you should still perform the procedure as a part of installation but you can expect a very abbreviated procedure time.

When your spindle has been idle for a short period of time we recommend an abbreviated warm up of spindle prior to starting the machining process to extend the life of the spindle. Please adhere to machine manufacturers warm up procedures for the spindle when starting machine.

Spindle Storage

Spindles should be stored in a clean, dry, temperature controlled environment, in an area free from inadvertent/ambient vibration. The spindle shaft (bearings) should be rotated while stored every 3-4 weeks to keep grease contact between the bearing balls and the raceways, preventing metal to metal contact damage.