

# Satisloh Spindle Care

- **Replacement spindles must be at room temperature prior to starting up**
  - May cause encoder errors if too cold
  - Condensation could also form on the inside of the spindle, causing a large amount of rust
- **A machine run up is recommended prior to running production.**
  - Allows the spindle to warm up @ 25% of the maximum rated RPM for that particular spindle
- **Check spindle motor chiller operation once a day. At lunch time, put your hand on the nose of the spindle.** It should be cool to the touch and never warm.
- **Coolant is only there to take heat away from the spindle assembly and condensation from a “too cold” situation can rust the spindle from the inside**
- **Coolant should be at ambient room temperature of approximately 68° F**
- **Coolant additive must be the manufacture’s recommended**
  - The tool spindle chiller coolant should be changed once a year with a 4:1 mixture of distilled water and Varidos (02-002-232) coolant additive. If the unit needs to be topped off in between changes, make sure to use the correct 4:1 mixture.
- **The air intake grate on the rectangular chillers should be cleaned monthly.**
  - The square chillers don’t have an intake grate, but the condenser coil should be kept clean.
- **Use only clean and dried compressed air.**
- **Excessive heat is not good and can reduce grease life**
- **Excessive cold is not good and can reduce spindle life**
- **Any spare spindles on the shelf must have the shaft turned every three weeks to ensure binding is kept at a minimum**
- **Remove the tool once a week and lubricate the chuck mechanism to prevent the tool from seizing.**
- **Do not over tighten when reinstalling the tool and make sure to rotate the collar on the neck of the spindle motor to the closed position to keep debris out of the chuck mechanism.**