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PROCEDURE TO INCREASE THE RETURN CLOCK SPRING TENSION

1. Remove quill feed handle and use screw driver and pop out the pinion shaft hub sleeve.

2. Use spanner wrench and hold down the spring cover and loose two screws (still holding down the spring cover). Allow the spring cover to rotate clockwise slowly to increase the clock spring tension.



3. Until proper tension is reached, retighten two screws. (**Warning: Tension cannot be too high!**) Otherwise, quill will return too fast, either the handle will hurt people or it will cause damage on the Reverse Trip Ball Lever and also cut down the life of the clock spring.

4. ACER new CNC Mill normally comes with more drag on the quill return when run manually due to tightening of the screw with locktie to connect the quill and the yoke and make sure there is no backplay on both components. Once the customer run the machine for a period of time with sufficient lube, the quill return speed will increase.