

Arc Euro Trade



X3 Small Mill Preparation Guide

A picture story book to help get your factory
assembled Sieg X3 Mill ready for action

Unbeatable Value Engineering Products by Mail Order

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There is no doubt that the Sieg X3 is currently one of the most popular small milling/drilling machines available to model engineers today. It has a well proportioned dovetailed cast iron column and head, a decent sized table with T-slots and coolant trough. With it's variable speed DC motor + 2 speed gearbox, the X3 is available in both metric and imperial options and a choice of either an MT3 or R8 spindle. At our current prices, this represents excellent value for money.

However, to get the best from the X3 Mill, we strongly recommend some preparation work is carried out before you start using the machine. This will not only improve the accuracy of the mill but also help to protect your investment from premature wear or possible failure.

This guide is designed to help you through this preparation process exactly how we do it in our own workshop when a customer chooses the Arc Preparation Service.



1: Presenting the case for the defense today is our engineer Geoff Watson. Geoff has prepared many X3 mills and by now, knows most of the wrinkles.



2: The mill - out of the box and all ready to start work on.



3: Remove the polycarbonate front guard



4: Loosen the drawbar...



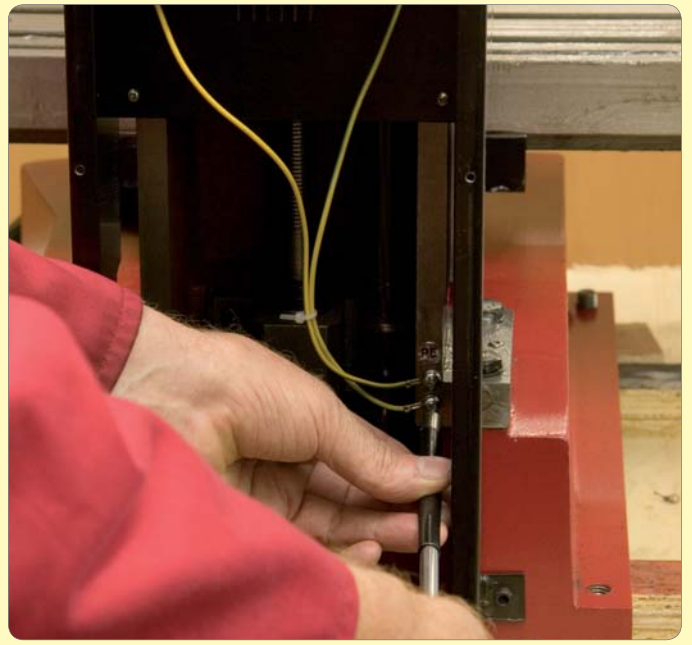
5: ...and give it a tap to release the taper...



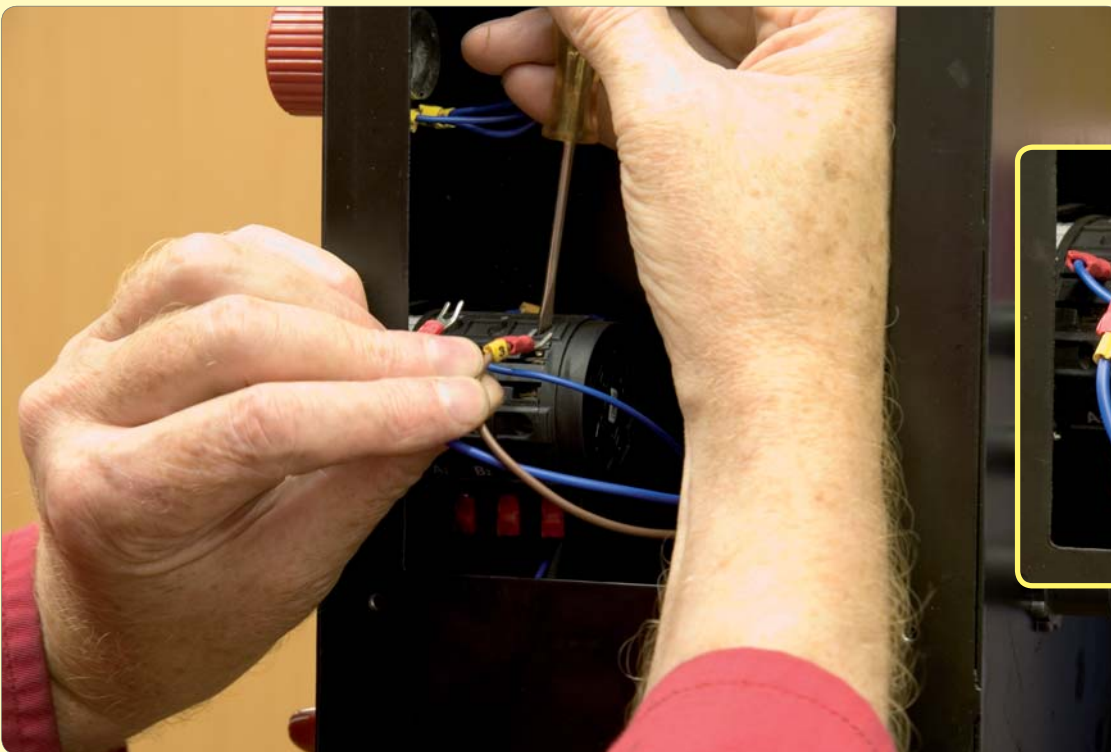
6: ...then remove the drawbar and drill chuck



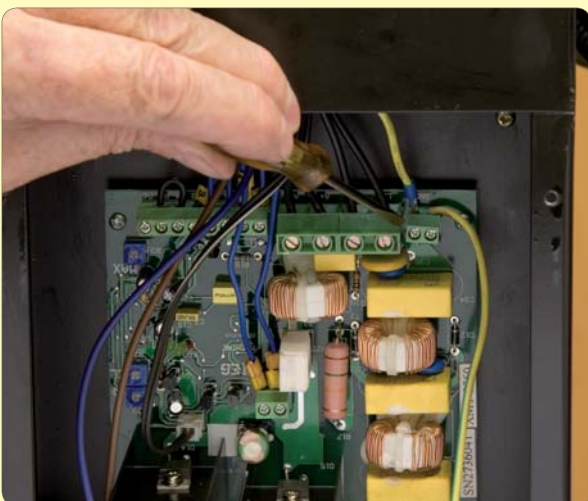
7: Remove rear control panel covers



8: Remove earth terminals at base of column



9: Remove #2 & #3 motor wires noting positions



10: Remove motor earth lead from board



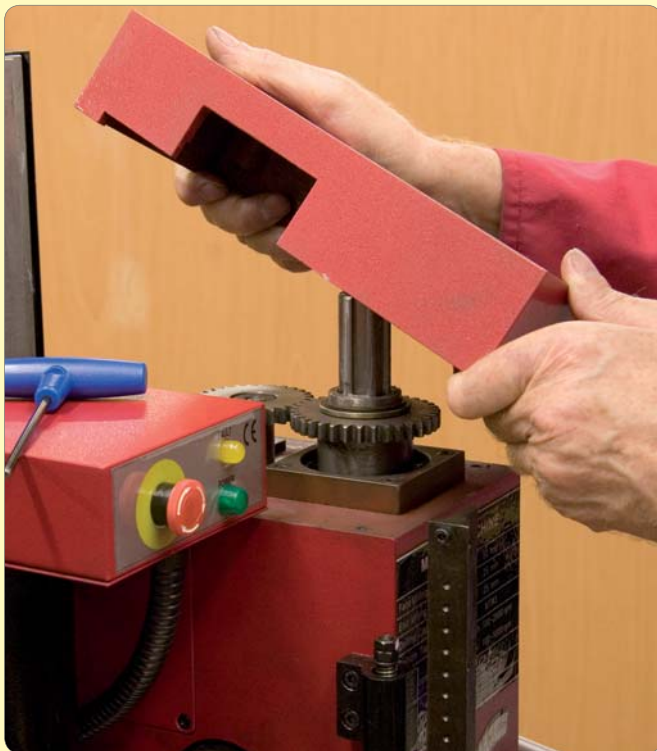
11: Remove 2 cap heads at top & 2 cap heads at bottom of control panel



12: Remove guard switch



13: Remove 4 cap heads...



14: ...and lift off the top cover



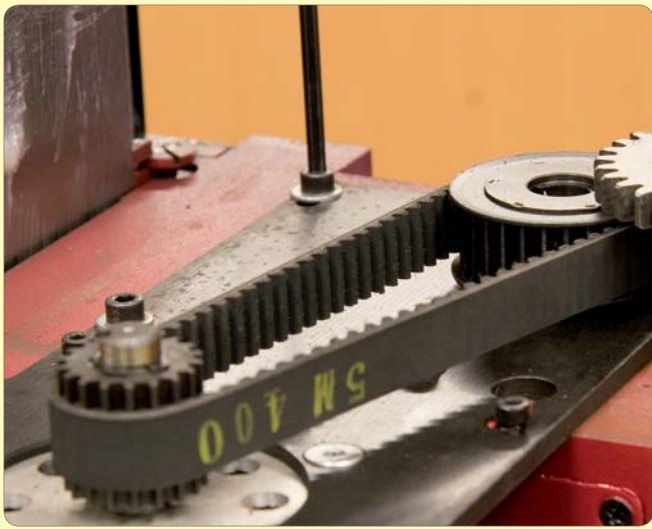
15: Undo emergency stop cover screws 1 turn



16: Cover slides off to the left of machine



17: Remove screws and washers from motor driven pulley and reduction box output gear



18: Slacken motor plate screws



19 : Remove Pulley and gear



20 : Remove motor and plate



21 : Remove rear control box complete



22: Remove X-Axis handwheel...



23: Drive out taper pin through micrometer dial sleeve...



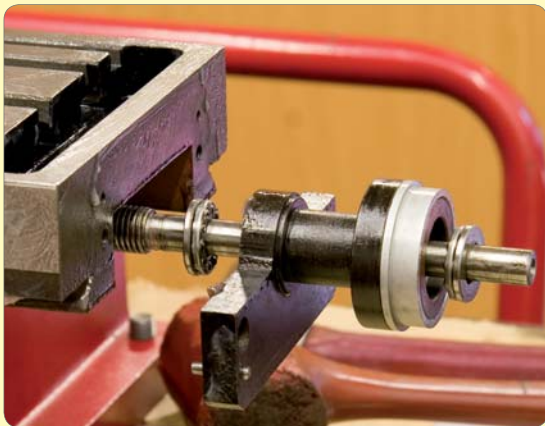
24: ...and remove the dial



25: Remove leadscrew bracket screws



26: Tap bracket with mallet...



27: ...to remove with thrust bearings



28: Slacken gib strip screws



29: Slide off table



30: Mark gib strip X-Axis



31: Remove leadscrew



32: Remove table lock, gib adjusting screws and pointer



33: Remove Y-Axis handle assembly



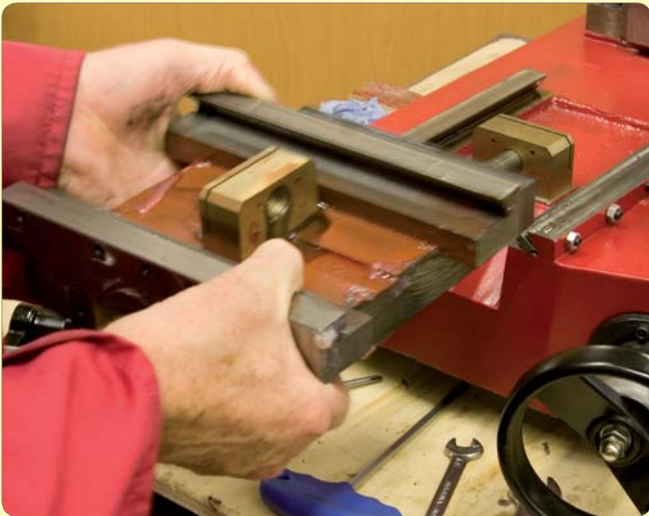
34: Remove bracket assembly screws



35: Remove key



36: Tap off bracket and thrust assembly



37: Remove cross slide



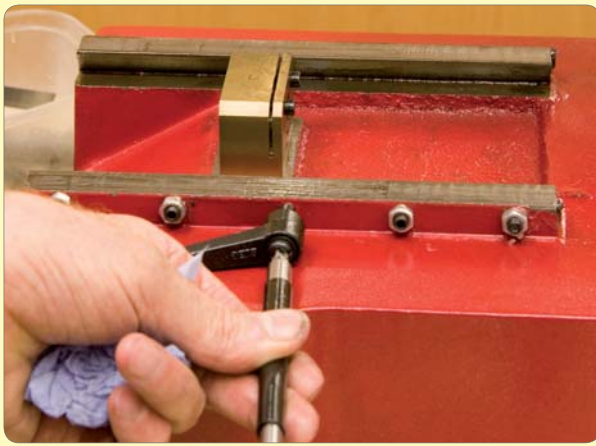
38: Remove and mark Y-Axis gib strip



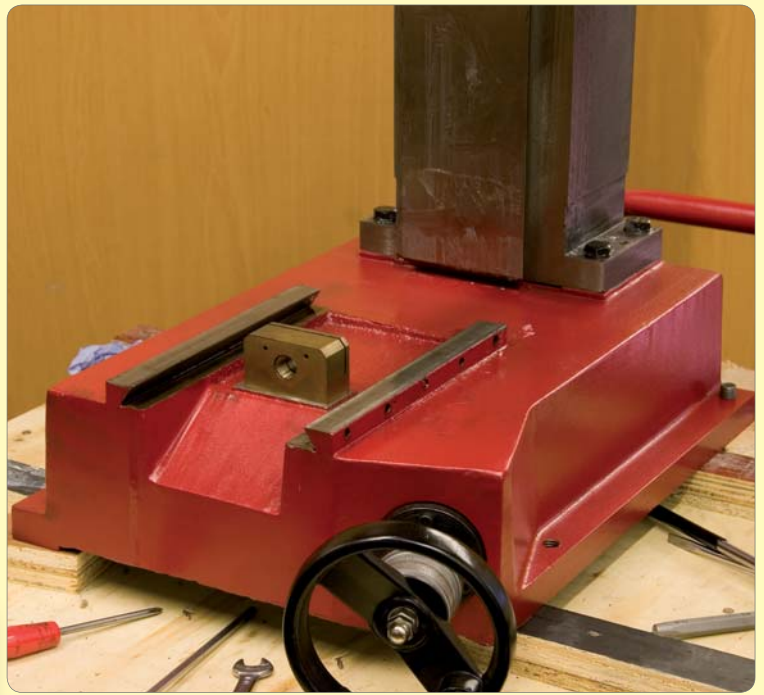
39: Remove circlip and washer from end of leadscrew



40: Remove leadscrew



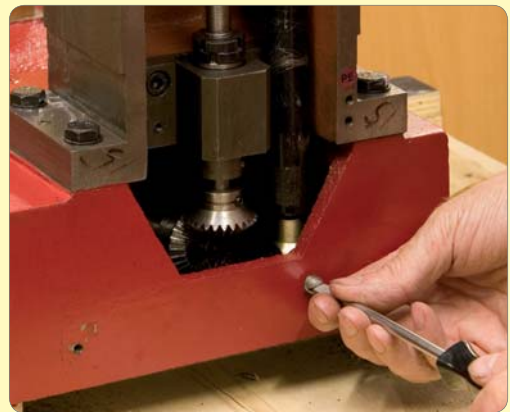
41: Remove locking handle assembly and gib screws



42: Table and cross slide assembly removed



43: Wind head up to end of travel to remove gas strut screws
- upper screw...



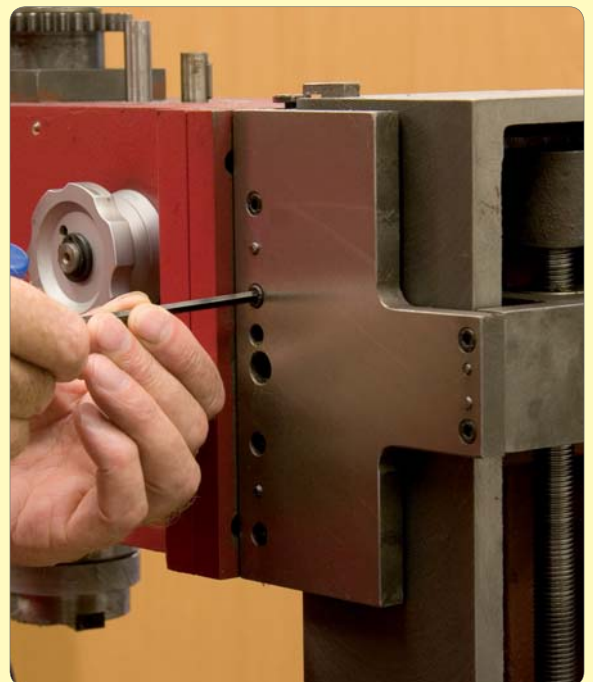
44: ...and lower screw



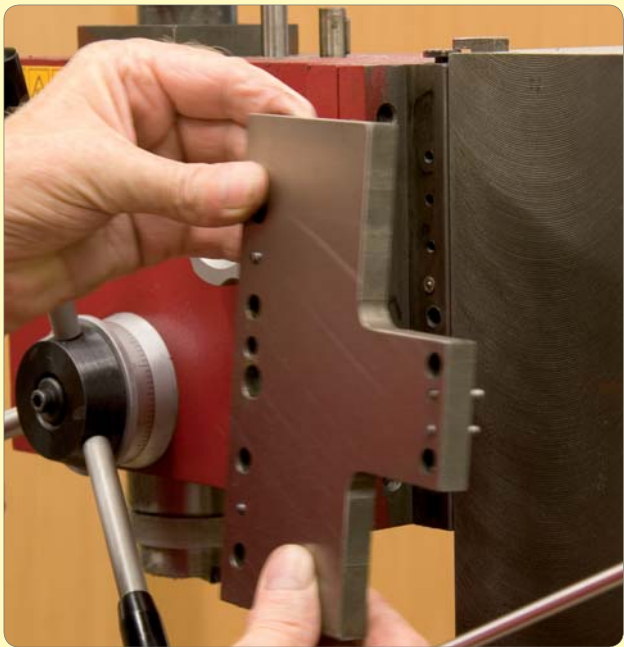
45: Remove gas strut



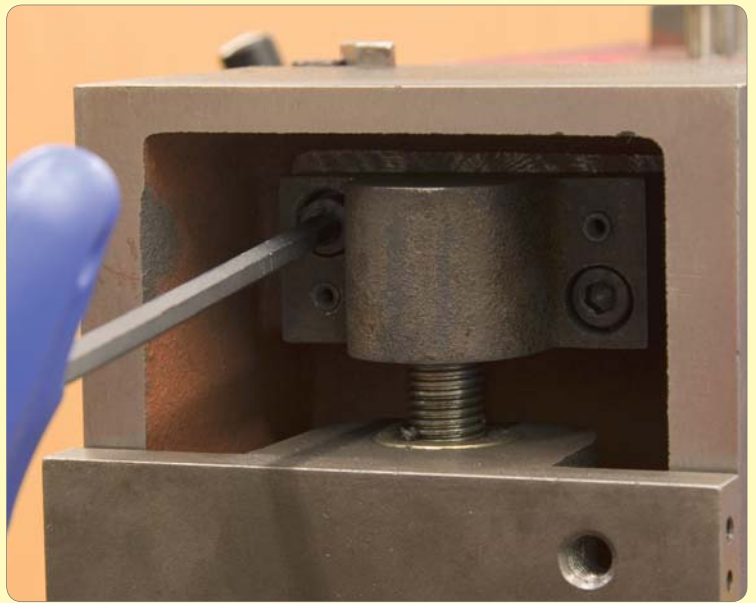
46: Place prop under head and wind down until the head just touches



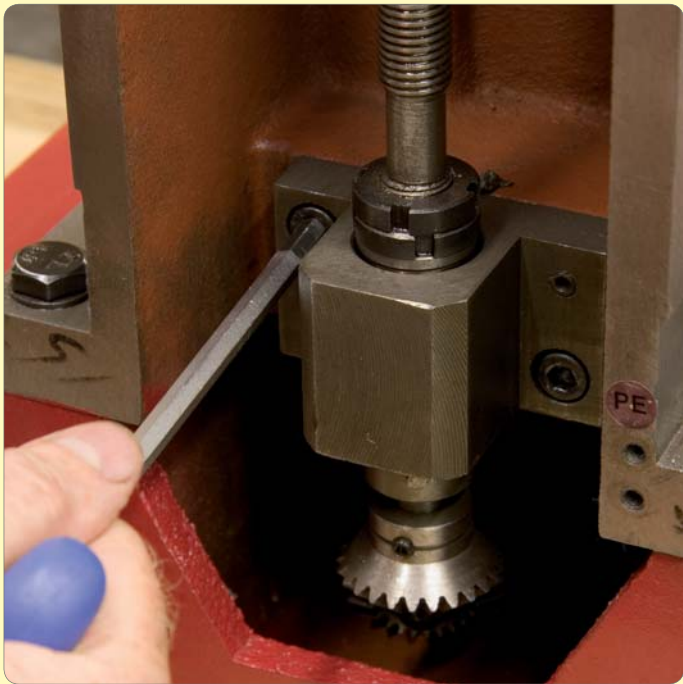
47: Remove locking lever and cap heads from both side plates



48: Remove side plates



49: Remove screws from Z-Axis leadscrew brackets - upper...



50: ...and lower



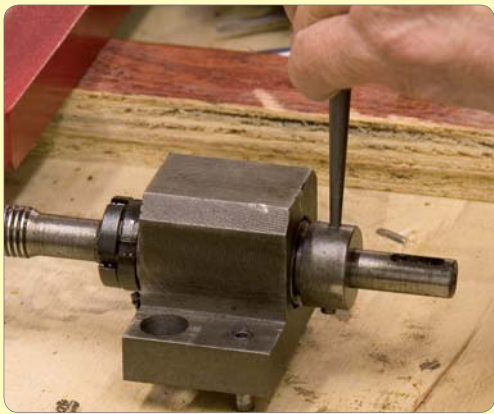
51: Remove leadscrew assembly



52: Undo bevel gear screw and remove gear



53: Remove key



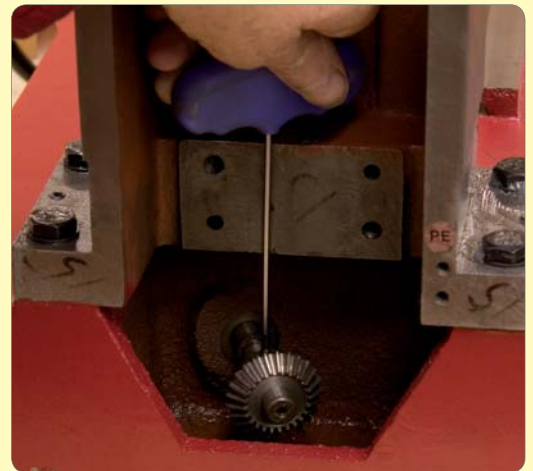
54: Remove taper pin



55: Remove lower thrust bearing block assembly noting orientation



56: Remove leadscrew from nut, pulling off top bearing bracket at the same time



57: Losen grub screw in bevel gear



58: Undo adjusting nuts and remove handwheel assembly



59: Remove key



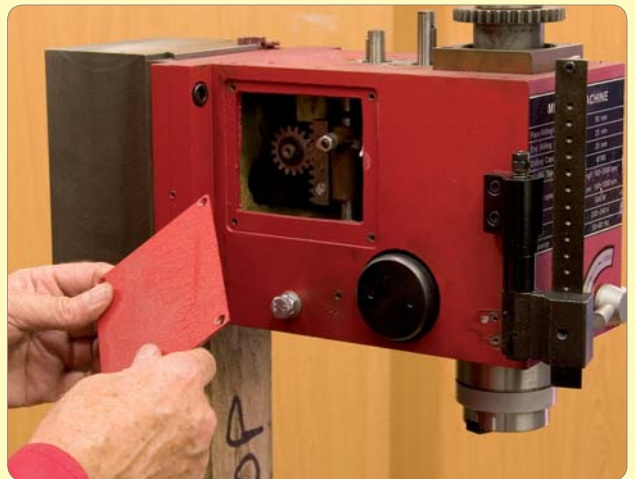
60: Remove screws from bracket



61: Remove carrier bracket and thrust bearings



62: Remove shaft and gear at other end



63: Remove gearbox cover



64: Lock spindle in UP position



65: Remove return spring assembly carefully (see fig. 108 page 16)



66: Remove circlip and spacer



67: Remove first the locking screw...



68: ...and second the spindle anti rotation guide pin beneath



69: Holding spindle firmly, remove handle and slide spindle from bottom of housing



70: Remove spindle lock assembly



71: Drift out spindle drive gear assembly marking position for later re-assembly



72: Hold spindle assembly in vice and remove C-Nuts and spacer



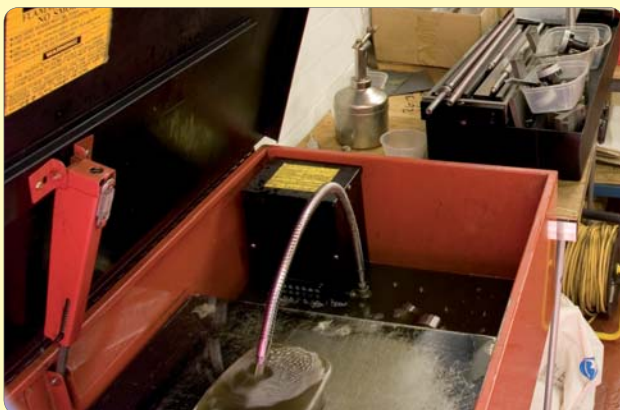
73: Press out inner spindle noting bearing fit as some bearings may be too tight on spindle - this can be adjusted later



74: Using blind bearing puller, remove taper roller bearing and bearing cover



75: Using blind bearing puller, remove top ball race remove ball thrust bearing and spacer



76: Wash all parts thoroughly in paraffin to remove any trace of contamination



77: If spindle bearing fit feels overly tight, polish journals to suit.
Reason:
If the top ball race is too tight on the spindle, it will be difficult to obtain the correct bearing preload.



78: Spindle assembly parts



79: Press flange onto spindle



80: Grease taper roller and fit to spindle sleeve



81: Fit Under oil seal



82: Coat bearing journals before assembly with Copperslip



83: Press spindle into spindle sleeve



84: Grease and assemble thrust bearing



85: Fit Spacer



86: Fit top ball race and press in



88: Fit top spacer



89: Grease threads with Copperslip



90: Fit C-Nuts



91: Tighten C-Nut to adjust preload - over tighten then back off



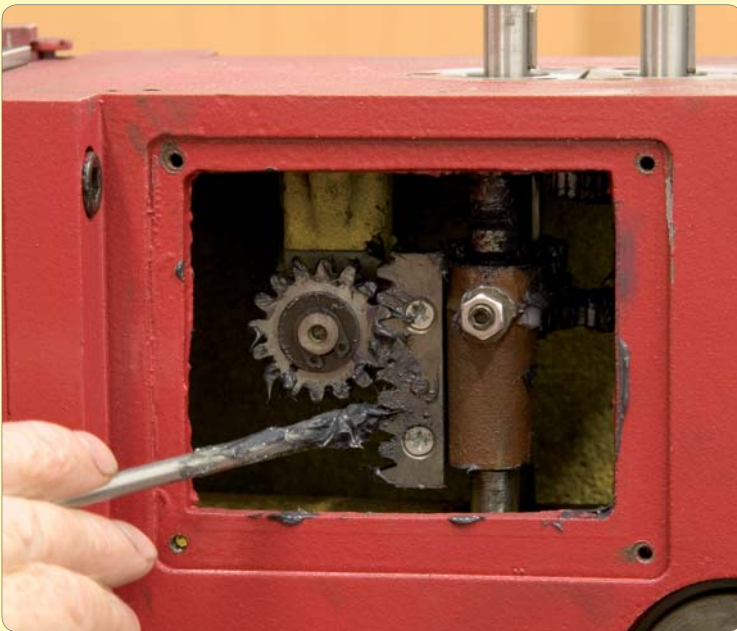
92: Tighten locking C-Nut and check preload - re-adjust as necessary



93: The spindle fully assembled



94: X3 Mill stripped, cleaned and ready to assemble



95: Grease all gears and shafts in range change box and refit cover



96: Grease and fit micrometer dial and friction spring to handwheel assembly



97: Grease splines and shaft on handwheel assembly



98: Assemble and grease spindle lock assembly



99: Grease bores for handwheel and spindle lock



100: Lightly oil bottom of spindle bore



101: Fit spindle lock assembly noting cut-outs for spindle sleeve



102: Fit spindle aligning guide slot



103: ...Temporarily lock in position



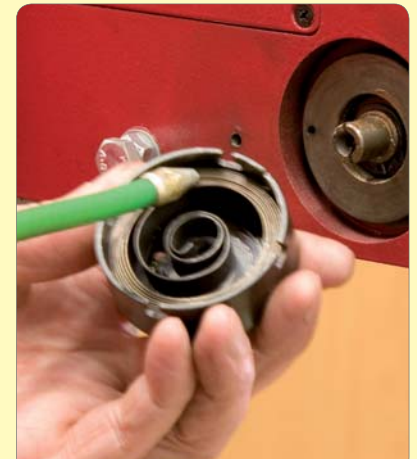
104: Fit handwheel assembly and rotate to desired position



105: Fit anti-rotation grub screw and locking screw



106: Fit spacer and circlip



107: Oil return spring



108: Note how end of spring locates in slot and T-slot locates on pin



109: Fit return spring housing and turn anticlockwise to adjust tension to preference.



110: Grease spindle splines



111: Grease drive bearings and gear carrier splines



112: Assemble unit noting position previously marked



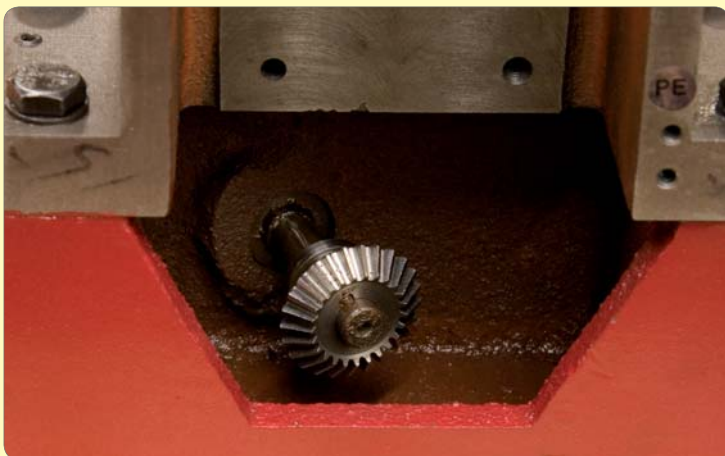
113: Grease handle shaft bore in rear of column



114: Grease Z-axis handle shaft



115: Assemble shaft



116: Fit bevel gear leaving free to move



117: Grease and fit thrust race and bearing and grease inner bearing races



118: Fit housing



119: Grease and assemble outer thrust bearing and race



120: Grease and assemble handwheel and micrometer dial with friction spring



121: Fit handwheel assembly and adjust out backlash



122: Grease Z-Axis nut



123: Grease Z-Axis leadscrew



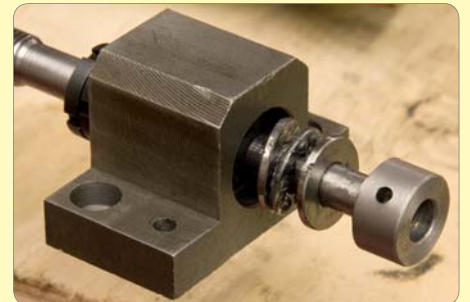
124: Assemble nut noting orientation



125: Press on Z-Axis top bearing assembly



126: Grease and assemble lower block thrust bearing



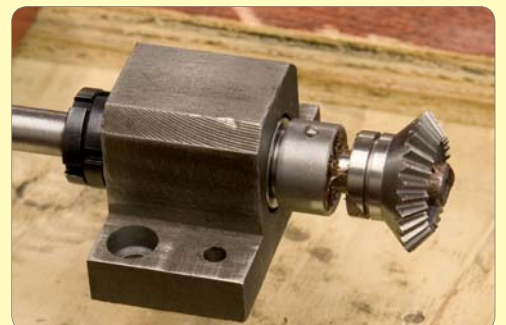
127: Assemble bearing block, thrust bearings and spacer onto leadscrew noting orientation



128: Tap in taper pin



129: Adjust out backlash



130: Slide on bevel gear leaving free to move



131: Finished Z-Axis leadscrew assembly



132: Fit Z-Axis assembly to rear of column



133: Adjust bevel gear mesh and backlash, lock and grease



134: Check oilers work



135: Align Z-axis nut with head and temporarily fit sideplates and cap head screws - do not tighten yet. Remove head prop.
Tighten head gib strip to lock head position and finally tighten side plate cap screws



136: Wedge Z-axis nut to hold head in position and remove head gib strip



137: Check gib strip is straight and flat, lubricate and re-fit



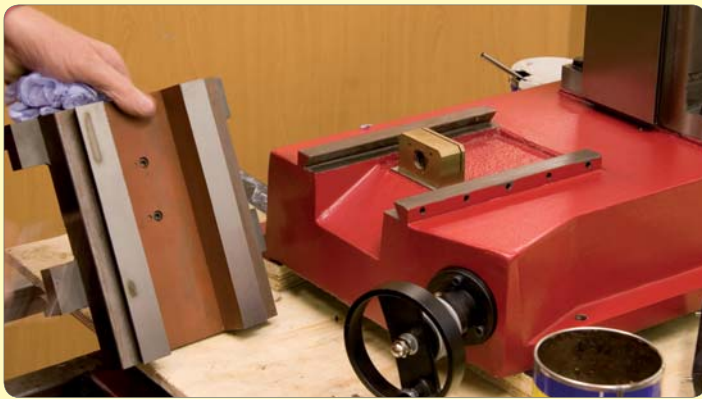
138: Fit Head locking lever



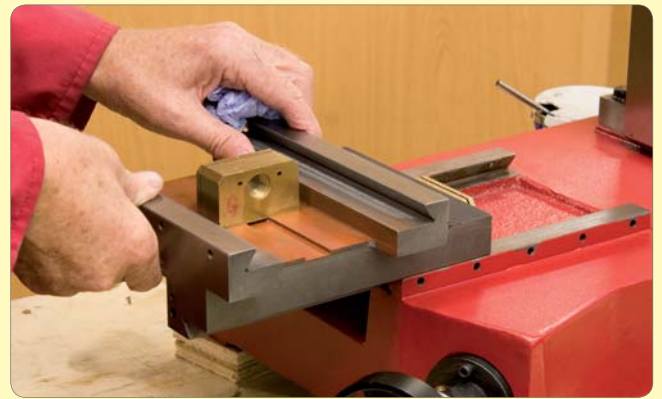
139: Fit gas strut and final adjust head gib strip



140: Finished assembly



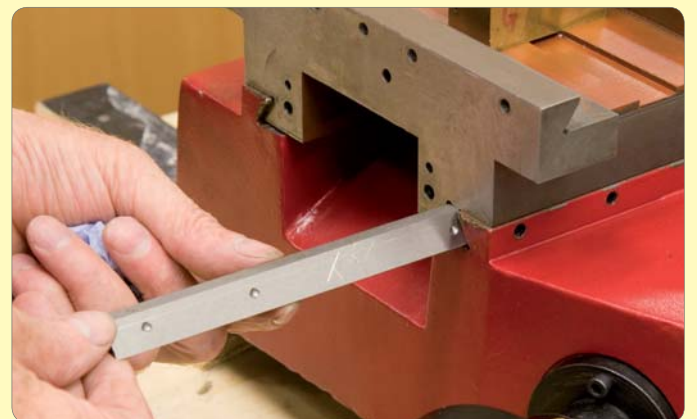
141: Grease saddle and base dovetails and leadscrew nut



142: Fit saddle



143: Check gib strip is straight and flat



144: Fit Y-Axis gib strip



145: Check tips of gib adjusting screws for concentricity



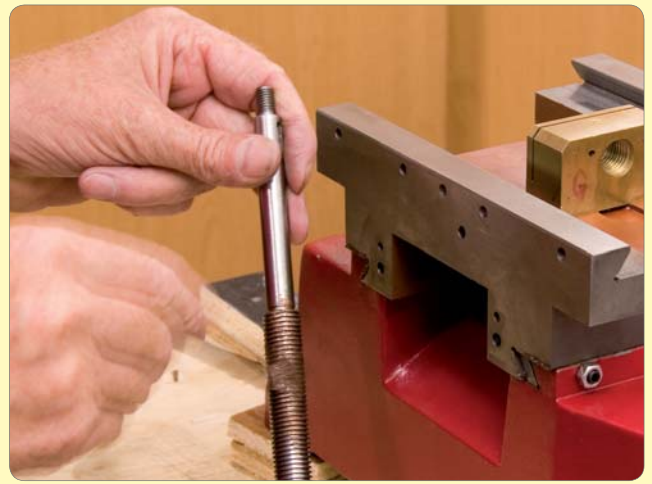
146: Grease and fit adjusting screws



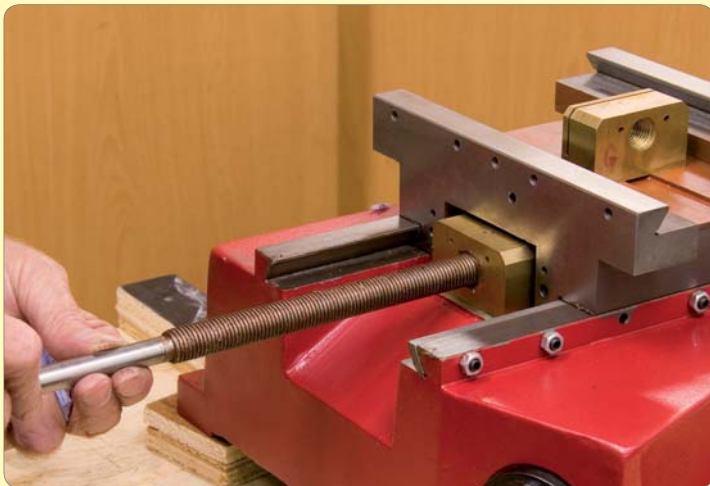
147: Adjust gib strip



148: Check for free movement



149: Grease Y-Axis leadscrew



150: Fit leadscrew



151: Fit washer and circlip at rear of leadscrew



152: Grease and fit thrust bearings and bearing housing



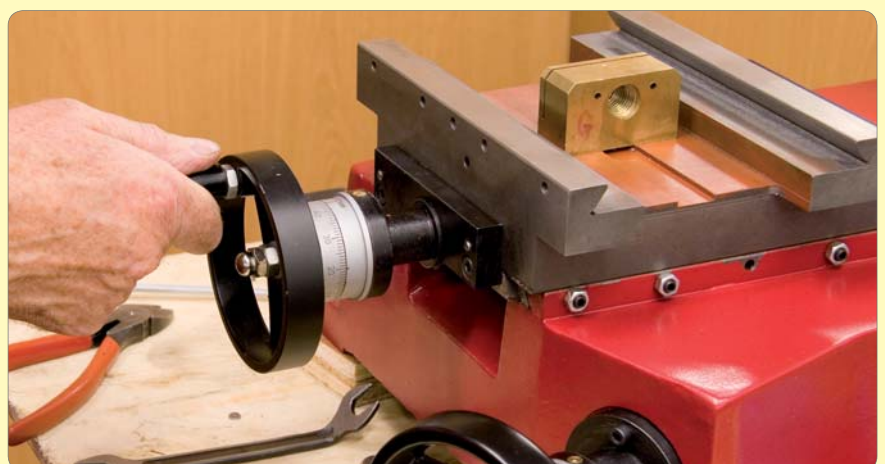
153: Fit outer thrust bearing



154: Grease and fit micrometer dial to handwheel with friction spring



155: Fit handwheel assembly and adjust backlash



156: Wind saddle in and out to check for smooth and consistent travel making final adjustment to gib strip as required



157: Grease table leadscrew nut and dovetails



158: Grease table dovetails and leadscrew bush



159: Slide table onto saddle



160: Check X-Axis gib strip is straight and flat



161: Fit gib strip



162: Check tips of gib adjusting screws for concentricity



163: Grease and fit adjusting screws



164: Working from the middle outwards, adjust and lock each in turn



165: Check table movement after each adjustment



166: Grease table leadscrew



167: Fit X-Axis leadscrew



168: Grease and fit inner thrust bearing and bearing housing



169: Fit outer thrust bearing



170: Grease and assemble micrometer dial with friction spring and sleeve



171: Fit sleeve and locate holes for taper pin



172: Tap pin home



173: Fit handwheel assembly



174: Wind table back and forth to check for free movement and minimum drag



175: Wind table to far right. With thumb on joint between table and saddle, use right hand to move table backwards and forwards to check for slack in dovetails



176: The same procedure as above but put thumb over joint between saddle and base - rock to and fro



177: Wind saddle fully in and do check again



178: Wind saddle fully out and do check again



179: Fit locking levers and scale pointer



190: Finished assembly



191: Fit rear electronics casing



192: Fit 2 lower screws and 2 top casing screws



193: Fit guard micro switch and Secure trunking with P-clip



194: Fit motor and plate making sure trunking is behind motor and above bolt with locknut



195: Loosly fit motor plate screws



196: Grease reduction box shafts



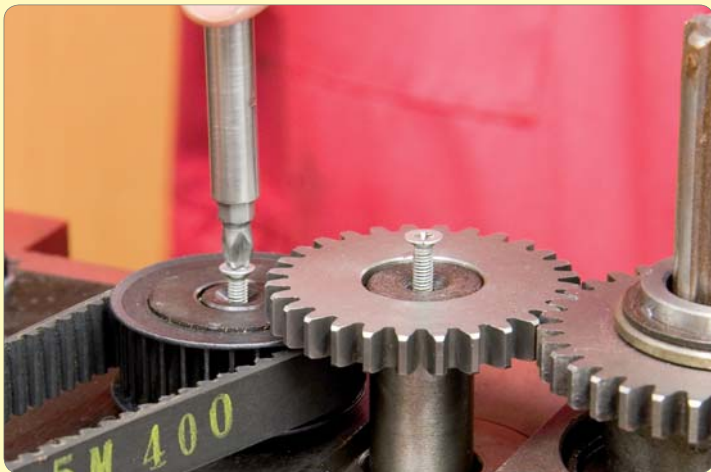
197: Fit driven pulley and belt



198: Pull motor towards you to tension the belt and lock motor plate screws



199: Fit reduction box output gear



200: Secure pulley and gear with washers and screws



201: Grease gears



202: Fit top cover and lock down





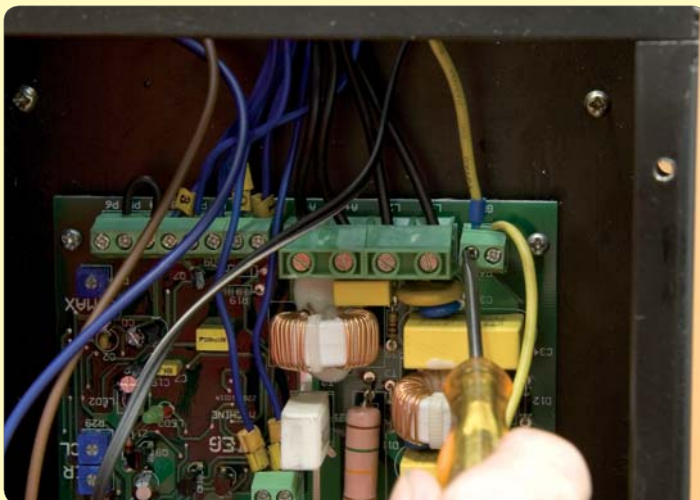
203: Fit stop switch housing - just slide on and pinch screws down



204: Thread motor wires through casing



205: Attach Brown and Blue wires to the forward/reverse switch as previously noted



206: Attach motor earth wire to the board



207: Fit earth wires to base of column. Cable tie any loose wires and replace covers

Always follow the correct Start-Up Procedure:

1. Turn the Power Switch to 0 (off)
2. Turn the Forward/Reverse Switch to 0 (off)
3. Connect the 13amp plug to a suitable socket outlet and switch on the power
4. Select the High or Low range gear as required
5. Rotate the Emergency Stop Switch to re-set
6. Close the Guard
7. Set the Speed Control Knob to a low speed position
8. Check there are no obstructions around the spindle or cutter
9. Turn the Power Switch to 1 (on)
10. Set the Forward/Reverse Switch to the direction you require
11. Slowly turn the Speed Control Knob to the desired speed

Running the spindle for the first time:

1. Follow the Start-Up procedure with Low gear selected and the motor running forwards
2. Run for 10 minutes at a low RPM. (The machine should run smoothly with minimal noise and vibration. If not turn off the machine and investigate the cause of the problem)
3. Slowly increase the speed and run for 10 minutes at a medium RPM
4. Slowly increase the speed and run for 10 minutes at a high RPM
5. Stop the machine and repeat steps 1-4 above in High gear
6. Stop the machine and repeat steps 1-5 above with the motor in Reverse

Note: Failure to follow this procedure may cause rapid deterioration of the spindle and related parts.

WHEN CHANGING THE CUTTER OR SETTING UP, ALWAYS TURN THE POWER SWITCH TO 0 (OFF)

The Completed Machine

