

# WELLS

DENTAL, INC.

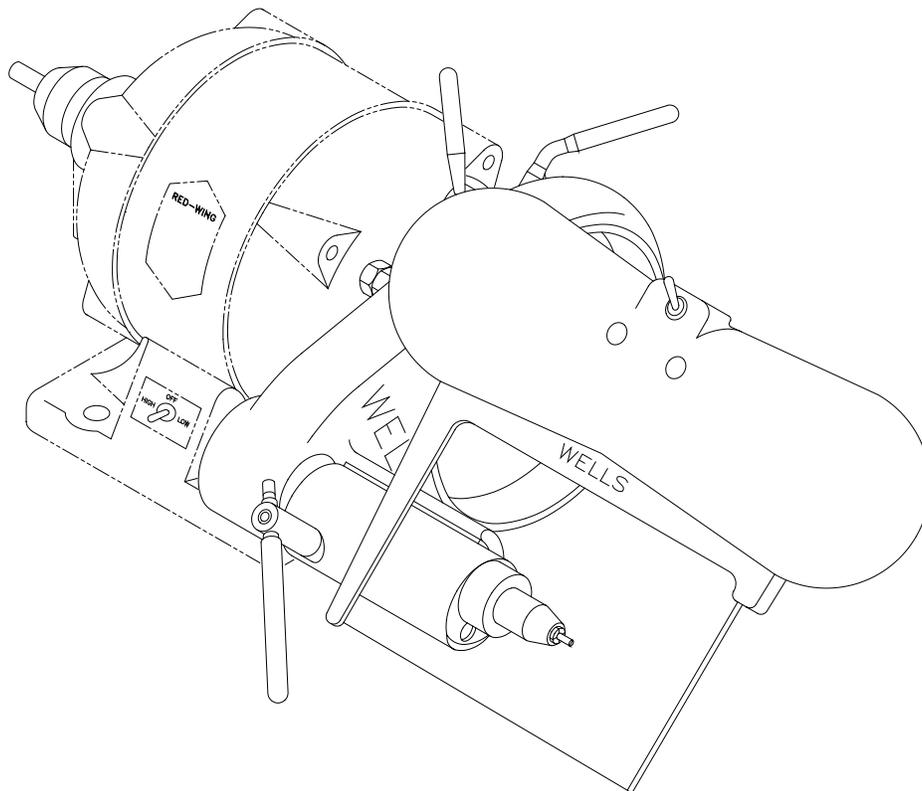
TECHNICAL BULLETIN  
G801-022510

5860 FLYNN CREEK ROAD  
P.O. BOX 106  
COMPTCHE, CALIFORNIA, U.S.A. 95427-0106  
www.wellsdental.com

**READ ALL INSTRUCTIONS  
BEFORE PROCEEDING  
SAVE THIS FOR FUTURE REFERENCE**

**THIS PRODUCT IS FOR PROFESSIONAL LABORATORY USE ONLY**

## USER'S MANUAL



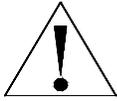
**WELLS GOLD CHROME BRACKET ASSEMBLY  
ON A RED WING LATHE  
Product No. U011**

**SALES      CUSTOMER SERVICE      TECHNICAL ASSISTANCE  
CALL TOLL-FREE: 1 800 233-0521**

**PHONE: (707) 937-0521, FAX: (707) 937-2809  
MONDAY-FRIDAY, 8:00 a.m.-4:30 p.m. P.S.T.**

DENTAL EQUIPMENT FOR TECHNICIANS WHO VALUE TIME AND QUALITY

## 1.0 SAFETY INSTRUCTIONS



**WARNING: WHEN USING ELECTRIC TOOLS, BASIC SAFETY PRECAUTIONS SHOULD ALWAYS BE FOLLOWED TO REDUCE THE RISK OF FIRE, ELECTRIC SHOCK, AND PERSONAL INJURY INCLUDING THE FOLLOWING ITEMS:**



**1.1 GROUND THE LATHE.** The Lathe must be grounded while in use to protect the user from electric shock. Plug into a three-hole grounded receptacle. If an adapter is used to accommodate a two-hole receptacle, the grounding lug must be connected to a known ground. Never remove the third prong. If in doubt, have a licensed electrician check the receptacle for **PROPER GROUNDING** and **POLARITY**.

**1.2 HANDLE WITH DRY HANDS.** Never handle the plug, power cord, Lathe or Spindle with wet hands.



**1.3 DISCONNECT THE POWER CORD.** Before servicing, unplug the power cord to prevent electric shock or unintentional starting.



**1.4 ALWAYS USE SAFETY GLASSES.** Wear industrial certified safety glasses for **ALL** work and maintenance. In addition, always put the clear safety shield between the Spindle and your face for protection in case of tool breakage.

**1.5 SECURE LOOSE ARTICLES.** Fasten long hair. Do not wear loose clothing, necktie or jewelry. They can get caught in rotating parts.



**1.6 USE PARTICLE MASK** when there is dust or particles in the air.

**1.7 ALWAYS KEEP A TOOL IN THE COLLET.** Never operate the unit without a tool.



**1.8 DO NOT EXCEED THE MAXIMUM OPERATING SPEED OF THE TOOL.** Use **ONLY** tools, parting disks or polishing wheels that are rated above the speed of your spindle. Insufficiently rated tools may break apart, bend or come loose causing serious personal injury.

**1.9 MAINTAIN THE WHEEL OR TOOL.** Never operate with a damaged or bent tool. It could break apart or come loose causing serious personal injury.

**1.10 CHECK TOOL IS SECURE.** Insert the tool shank into the collet to the **MAXIMUM** depth that will allow free rotation of the tool. An extended tool is likely to break or bend causing serious personal injury. Always check that the tool is securely held in the collet.



**1.11 KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from the work area. Do not run the unit unattended.

**1.12 MAINTAIN THE UNIT.** Inspect periodically for damaged or worn parts. Follow the instructions for maintenance. Don't use if the power cord, lathe, switch, belt or other parts are in poor condition. Don't use if the unit has been dropped, damaged, or exposed to water. Have a qualified service person inspect and replace parts when necessary.

**1.13 FOR LABORATORY USE ONLY.** The WELLS Gold Chrome Bracket Assembly is intended for use by trained professional laboratory personnel.

## 2.0 PRODUCT DESCRIPTION

The WELLS Gold Chrome Bracket Assembly is designed for heavy duty laboratory service, quiet operation and low maintenance. Tool changes are quick and safe with the Wells High Speed Spindle. A quarter turn of the handle disengages the clutch, stops the shaft and opens the collet while the lathe is running. The Light Shield is a combination lamp and safety shield.

- U011 GOLD CHROME FOR RED WING LATHE** consists of:
- G200 BRACKET ASSEM & LIGHT SHIELD/RW with:
  - S013 WELLS SPINDLE with:
    - S250 ACCESSORY KIT
      - 151 HEX WRENCH 3/32
      - 159 HEX WRENCH 1/8
      - S152 STOP TUBES SET OF 6
      - S153 STOP REMOVING TOOL
      - S165 TUBE BRUSH 3/16
  - G801 USER'S MANUAL for WELLS GOLD CHROME BRACKET ASSEMBLY ON A RED WING LATHE

## 3.0 SPECIFICATIONS

COLLET SIZES .....	3/32" (standard), 1/16", 1/8" or 3mm
SPINDLE SPEEDS .....	12,000 and 24,000 RPM
LATHE SPEEDS .....	1725 and 3450 RPM
ELECTRICAL RATING .....	115 Volts, 3.3 Amps, 60 Hz, Single Phase
UNIT DIMENSIONS .....	approx. 12 x 12 x 26"
WEIGHT .....	46 lbs
SHIPPING WEIGHT .....	55 lbs

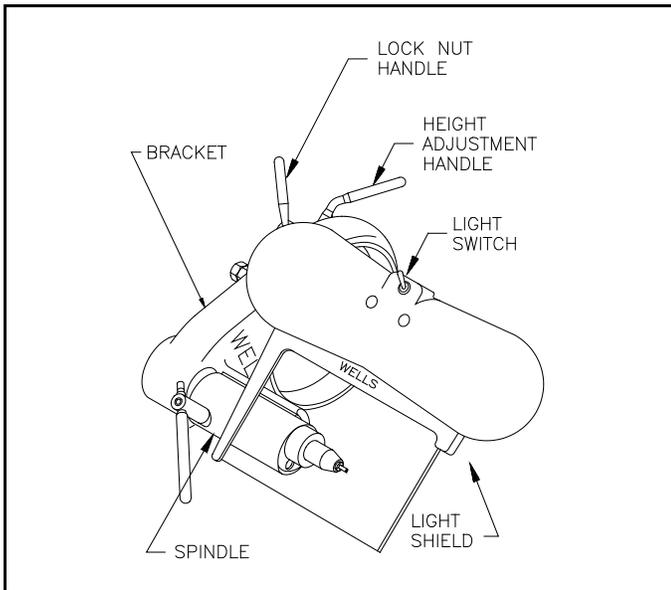


Figure 1. Bracket Assembly features

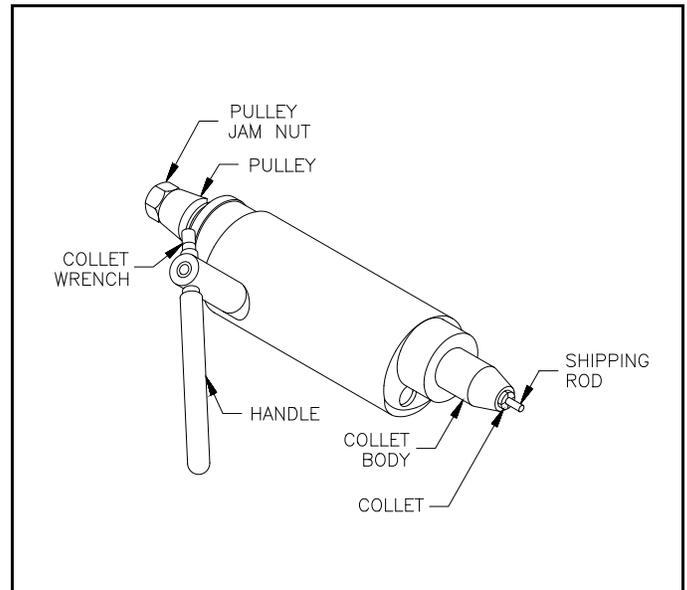


Figure 2. Spindle features

## 4.0 INSTALLATION

Please refer to the separate technical bulletin, G800 INSTALLATION OF WELLS GOLD CHROME BRACKET ASSEMBLY ON A RED WING LATHE.

## 5.0 OPERATION



**WARNING:** READ ALL INSTRUCTIONS BEFORE OPERATING. FAILURE TO COMPLY WITH INSTRUCTIONS COULD RESULT IN SEVERE PERSONAL INJURY AND/OR PROPERTY DAMAGE.



**CAUTION:** The High Speed Spindle is driven by a belt that increases the speed by seven times the Lathe speed. When the Lathe is on **LOW** (1725 RPM), the Spindle runs at **12,000 RPM!** When the Lathe is on **HIGH** (3450 RPM), the Spindle runs at **24,000 RPM!** Because of these high speeds, it is extremely important to take the following precautions:

### 5.1 HIGH SPEED PRECAUTIONS

- 5.1.1 Use **ONLY** tools that are rated above the speed of the Spindle. **Always consult the tool manufacturer's literature** for the maximum operating speed of the tool. For example, a thin parting disk with a diameter of 1-1/2" rated for 25,000 RPM is safe to use on either high or low speed. Heavier or larger diameter tools than this, however, are probably rated for lower speeds and are **extremely dangerous** if operated over their rated speed.
- 5.1.2 Make sure the tool is perfectly straight. A slightly bent tool will bend sharply, break or fly out of the collet.
- 5.1.3 Insert the tool shank into the collet to the **maximum depth** that will allow free rotation of the tool. Larger diameter and heavier tools especially must be held very closely to the collet.
- 5.1.4 Do not use excessive force on the tool.

### 5.2 GENERAL OPERATION



**CAUTION:** Always wear industrial certified safety glasses for all work and maintenance.

**CAUTION:** Always put the clear safety shield between the Spindle and your face for protection in case of tool breakage.

- 5.2.1 **Always keep a tool in the collet.** The Spindle may be damaged if the collet is closed without a tool.
- 5.2.2 To run the Lathe at **HIGH** speed, always switch to **LOW** first until the Lathe is up to speed, then switch to **HIGH**. Do not switch directly from **OFF** to **HIGH**.
- 5.2.3 Work is done with the handle in the operating position at approximately 5:00 o'clock. See Figure 3.
- 5.2.4 The clutch disengages when the handle is moved clockwise to approximately 6:00 o'clock (straight down).
- 5.2.5 The brake is applied when the handle is moved to approximately 7:30 o'clock.
- 5.2.6 The collet opens when the handle is moved to 9:00 o'clock (straight back).

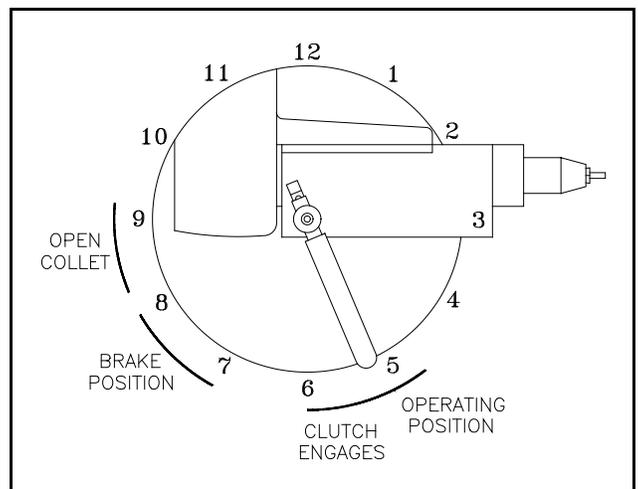


Figure 3.

### 5.3 CHANGING A TOOL

Any tool such as a burr or stone may be changed while the Lathe is running.

- 5.3.1 From the operating position move the handle clockwise to the open collet position (9:00 o'clock). See Figure 3.
- 5.3.2 Remove the tool.
- 5.3.3 Insert a selected tool that is rated for the speed of the Spindle.
- 5.3.4 Move the handle to approximately 7:00 o'clock to close the collet.

- 5.3.5  **DANGER: REMOVE YOUR HAND** from the tool before moving the handle past 7:00 o'clock. Holding a tool when the clutch engages could cause serious personal injury.

- 5.3.6 Ease the handle counterclockwise to the operating position. Do not let the handle snap shut.

### 5.4 CHANGING POINTS, STONES AND PARTING DISKS

By applying the brake, points, stones and parting disks may be loosened or tightened **when the Lathe is stopped only**.

- 5.4.1 Turn the Lathe off.
- 5.4.2 From the operating position move the handle clockwise to about 7:30 o'clock where the resistance of the brake is felt. This disengages the clutch, locks the shaft and keeps the collet closed.
- 5.4.3 Hold the handle in this position to loosen or tighten points, stones or parting disks.

### 5.5 ADJUSTING SPINDLE HEIGHT

- 5.5.1 Turn the Lathe off.
- 5.5.2 Hold the Spindle and loosen the height adjustment handle. See Figure 1.
- 5.5.3 Adjust the Spindle to the desired height and tighten the handle.

## 6.0 MAINTENANCE

**CAUTION:** The bearings in the WELLS High Speed Spindle are permanently lubricated with special compounds. If anything enters the bearings, they will be damaged. **KEEP OIL, SOLVENT AND COMPRESSED AIR AWAY** from the WELLS High Speed Spindle.



NO OIL



NO SOLVENT



NO AIR

**CAUTION:** There are no user serviceable parts inside the Spindle except as described below. **DO NOT DISASSEMBLE** the Spindle.

### 6.1 RUNNING HOT

A WELLS High Speed Spindle may run hot for several reasons:

- 6.1. 1A new or rebuilt Spindle will run hot when first put into operation until the bearings are broken in. This condition may last several days depending upon the amount of use.
- 6.1.2 A worn or loose collet or a stop that is too long may cause tools to slip. The brake may drag causing the collet to spin inside the collet body. The overheating will be noticed at the collet and front of the collet body. If the tools slips, follow the procedures in section 6.3, FITTING A STOP TO ADJUST THE COLLET DIAMETER.

### 6.2 CLEANING THE COLLET (MONTHLY)

To prevent the collet from sticking and slipping, periodic cleaning and lubrication is essential. Neglected collets can get frozen into the shaft requiring factory service.

- 6.2.1 Turn off the Lathe and disconnect the power cord.
- 6.2.2 Use a 3/32" hex wrench to loosen the set screw that holds the handle and remove the collet wrench. See Figure 4.
- 6.2.3 Insert a 3/32" rod into the hole in the collet wrench to make a tee handle.
- 6.2.4 Move the handle to the open collet position (9:00 o'clock). Remove the tool.
- 6.2.5 Insert the collet wrench into the collet and turn counterclockwise to unscrew. If the collet turns but will not unscrew, see section 6.4, REMOVING A STUCK COLLET.
- 6.2.6 Remove the collet. Remove the small brass stop tube behind the collet with the stop removing tool provided in the accessory kit or a size #1 screw extractor (Easyout).
- 6.2.7 Wash the collet and stop tube in solvent. Solvent may be used on these parts **ONLY** when removed from the collet body. Dry the collet and stop tube thoroughly.
- 6.2.8 Clean the inside of the collet body so the collet will seat against the stop properly. Clean the threads using the tube brush provided in the accessory kit. Rotate the brush into the threads a few times. Use a pipe cleaner or Q-tip to clean out all the debris in the bottom of the hole. Do not use solvent here.
- 6.2.9 Put a **THIN** film of grease or Vaseline on the outside of the collet including the threads. **DO NOT** use oil.
- 6.2.10 Insert the stop tube and collet then tighten with the collet wrench.
- 6.2.11 Insert a tool into the collet and put the handle into the operating position.
- 6.2.12 Put the collet wrench in the end of the handle and tighten the set screw. Connect the power cord.

**CAUTION:** Do not run the Spindle without a collet.

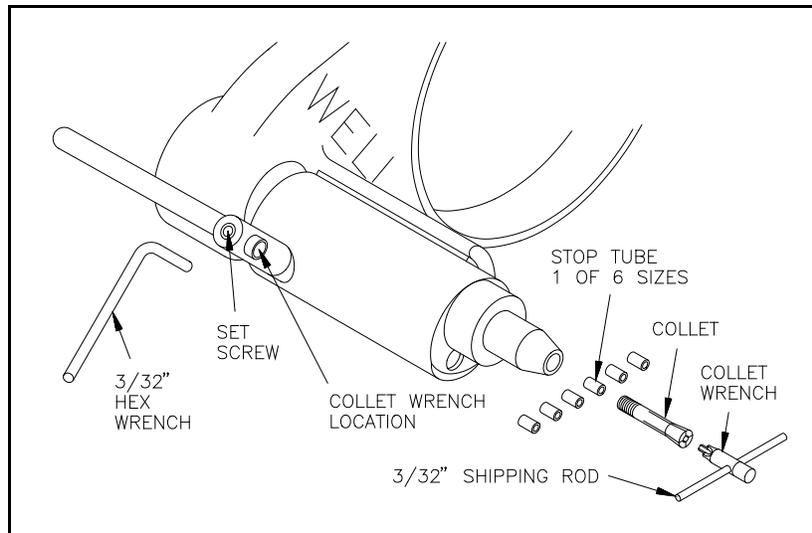


Figure 4.

### 6.3 FITTING A STOP TO ADJUST THE COLLET DIAMETER

When the collet wears, tools may slip. The brake may drag causing the collet to spin inside the collet body. A shorter stop must be installed to compensate for the wear. The shorter stop will allow the collet to thread further into the collet body so it grips more tightly. A set of 6 stops of different lengths (S152) is included with the accessory kit.

6.3.1 Follow steps 6.2.1 through 6.2.10 for CLEANING THE COLLET.

6.3.2 Make sure that the handle is in the open collet position (9:00 o'clock straight back). Insert a tool with the correct size shaft into the collet. If it is loose, remove the collet and replace the stop tube with the next shorter size. Check the fit again. If it is still loose, install a shorter stop tube. If it is too tight, install the next longer size. Install the shortest stop tube that will allow the tool to just slip into the collet.

6.3.3 With a tool in the collet, put the handle into the operating position. The collet should protrude a little from the face of the collet body. If it is flush or recessed, the collet is worn out and must be replaced.

6.3.4 Put the collet wrench in the end of the handle and tighten the set screw. Connect the power cord.

6.3.5 If the collet still slips or overheats, replace the collet. Follow the procedure above for fitting a stop when a new collet is installed.

### 6.4 REMOVING A STUCK COLLET

If the Spindle is run without a tool in the collet or the collet is not cleaned and lubricated periodically it may get stuck in the spindle shaft. The collet may turn but not unscrew.

6.4.1 Turn off the Lathe and disconnect power cord.

6.4.2 Move the handle to the open collet position (9:00 o'clock). Remove the tool.

6.4.3 Insert the collet wrench. Tap the end of the collet wrench **LIGHTLY** while turning the collet wrench counterclockwise. See Figure 5.

6.4.4 If the collet cannot be removed by this method, the Spindle must be sent in for factory service.

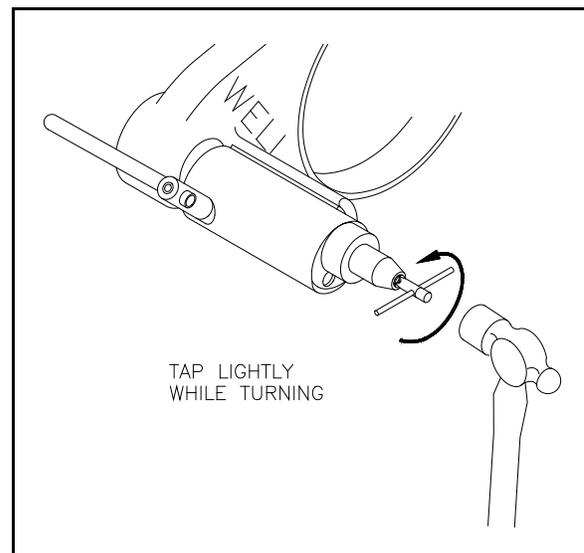


Figure 5.

## 6.5 BELT MAINTENANCE

The life of spindle bearings, motor bearings and pulleys are greatly affected by the tension of the belt. If the tension is too great, stress is put on the bearings that will considerably shorten their life. If the tension is too little, the belt will slip wearing both the belt and pulleys or will cause noise and vibration.

- 6.5.1 Check the tension of the belt regularly. Loosen the lock nut handle and let the weight of the Spindle tighten the belt. Do not apply additional pressure. The weight is sufficient to tighten the belt to the proper tension. Tighten the lock nut handle.
- 6.5.2 Belts become impregnated with grinding dust and may be replaced periodically to extend pulley life. The frequency depends on the type of dust and the severity of service. If a belt has cracks or is frayed, it should be replaced.

## 6.6 SPINDLE PULLEY REPLACEMENT

Spindle pulleys should be replaced when the vees are worn to a sharp edge. A worn pulley can drastically reduce belt life.

- 6.6.1 Disconnect the power cord.
- 6.6.2 Remove the two spindle mounting screws and remove the Spindle.
- 6.6.3 Insert a 1/8" hex wrench into the end of the spindle shaft and loosen the pulley jam nut with a 1/2" box wrench.
- 6.6.4 Install the new pulley and tighten the pulley jam nut.
- 6.6.5 Loosen the height adjustment handle. Rotate the bracket to the position pictured in Figure 6 and tighten the handle.
- 6.6.6 Loosen the lock nut handle, lift the bracket until it stops and tighten the handle.
- 6.6.7 Install the Spindle with the rubber mounting pad between the Spindle and the bracket.
- 6.6.8 Tighten the mounting screws alternately until the rubber bushings just begin to compress. Do not over tighten.
- 6.6.9 Install the belt over the motor pulley and the spindle pulley. Loosen the lock nut handle and let the weight of the Spindle tighten the belt. Do not apply additional pressure. The weight is sufficient to tighten the belt to the proper tension. Tighten the lock nut handle.

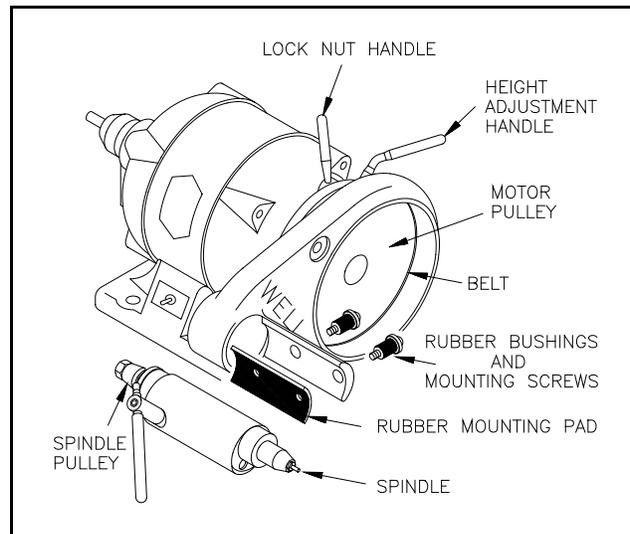


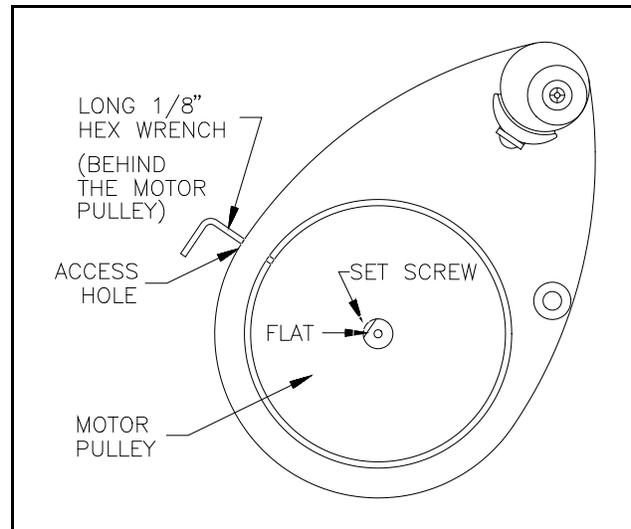
Figure 6.

## 6.7 MOTOR PULLEY RECROWNING

When the edge of the motor pulley becomes worn so there are sharp vees, it should be replaced or sent to WELLS DENTAL, INC. to be recrowned.

- 6.7.1 Disconnect the power cord.
- 6.7.2 Loosen the lock nut handle and remove the belt.
- 6.7.3 Center the large hole in the bracket with the pulley so it can be removed. Tighten the lock nut handle.
- 6.7.4 Loosen the height adjustment handle and rotate the bracket so the Spindle is at the top and to the back. See Figure 7. Insert the long 1/8" hex wrench through the access hole and loosen the set screw in the motor pulley hub. Remove the motor pulley. (Use a screw driver through the access hole to pry the pulley outward.)

- 6.7.5 To install the new or recrowned pulley, first rotate the lathe shaft so the flat faces the access hole. See Figure 7.
- 6.7.6 Slide the motor pulley onto the shaft with the hub on the inside.
- 6.7.7 Keep the flat aligned with the access hole and rotate the pulley so the set screw will tighten on the flat.
- 6.7.8 Tighten the set screw with the long 1/8" hex wrench then back it off a just a little so the pulley can slide.
- 6.7.9 Place the belt over the spindle pulley and the motor pulley. Slide the motor pulley in or out until the belt is aligned.
- 6.7.10 Loosen the lock nut handle and pull the Spindle forward to tighten the belt. Tighten the lock nut handle.
- 6.7.11 Turn the Lathe shaft until the motor pulley completes a full revolution. Check the alignment of the belt. Move the pulley in or out so the belt tracks along the center of the motor pulley.
- 6.7.12 Tighten the set screw onto the flat with the long 1/8" hex wrench. Again, check that the belt tracks along the center of the motor pulley. If necessary, loosen the set screw and re-align the motor pulley. Finally tighten the set screw securely using a pair of pliers on the hex wrench.
- 6.7.13 Loosen the height adjustment handle and position the Spindle as illustrated in Figure 6.
- 6.7.14 Loosen the lock nut handle and let the weight of the Spindle tighten the belt.
- 6.7.15 Make sure a tool or shipping rod is securely held in the collet.
- 6.7.16 Switch the lathe toggle to **LOW**. After the Lathe is up to speed, switch the toggle to **HIGH**. If there is excessive noise or vibration, tighten each of the mounting screws a quarter turn alternately until it stops.
- 6.7.17 Check that the belt tracks along the center of the edge of the motor pulley. If not, adjust the spindle mounting screws by loosening one and tightening the other a little until the belt is centered and there is no excessive noise.



**Figure 7. Remove and install the motor pulley**

## 6.8 EXCESSIVE NOISE

- 6.8.1 Check that the belt has the correct tension. See step 6.5.1.
- 6.8.2 Make sure the mounting system is properly adjusted. Loosen the spindle mounting screws then tighten the mounting screw alternately until the rubber bushings just begin to compress. Do not over tighten. Follow steps 6.7.15 through 6.7.17.
- 6.8.3 A stop that is too long will cause the collet to slip which will make a squealing noise. It may also cause the brake to drag which can squeak. See section 6.3 FITTING A STOP TO ADJUST THE COLLET DIAMETER.
- 6.8.4 Worn out spindle bearings will usually cause a high pitched noise. Also the spindle housing (the large main body of the Spindle) may get excessively hot with bad bearings. Bearing replacement requires factory service.

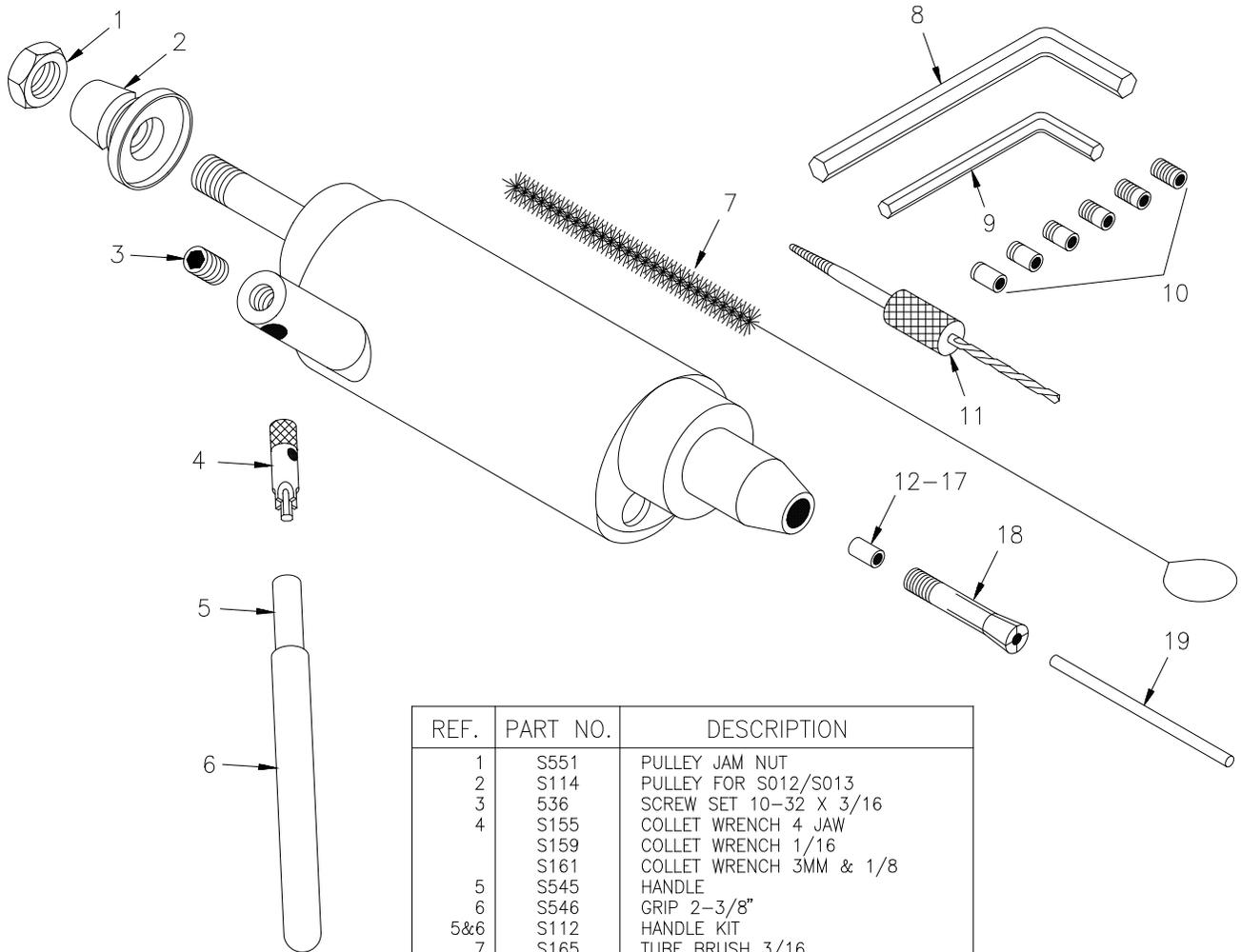
**For further maintenance or repairs, send the machine to WELLS DENTAL, INC. for factory service.**

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 P.O. BOX 106  
 COMPTCHE, CA USA 95427  
 PHONE (707) 937-0521  
 1 800 233-0521  
 FAX (707) 937-2809

## PARTS LIST for WELLS HIGH SPEED SPINDLE Product No. S013



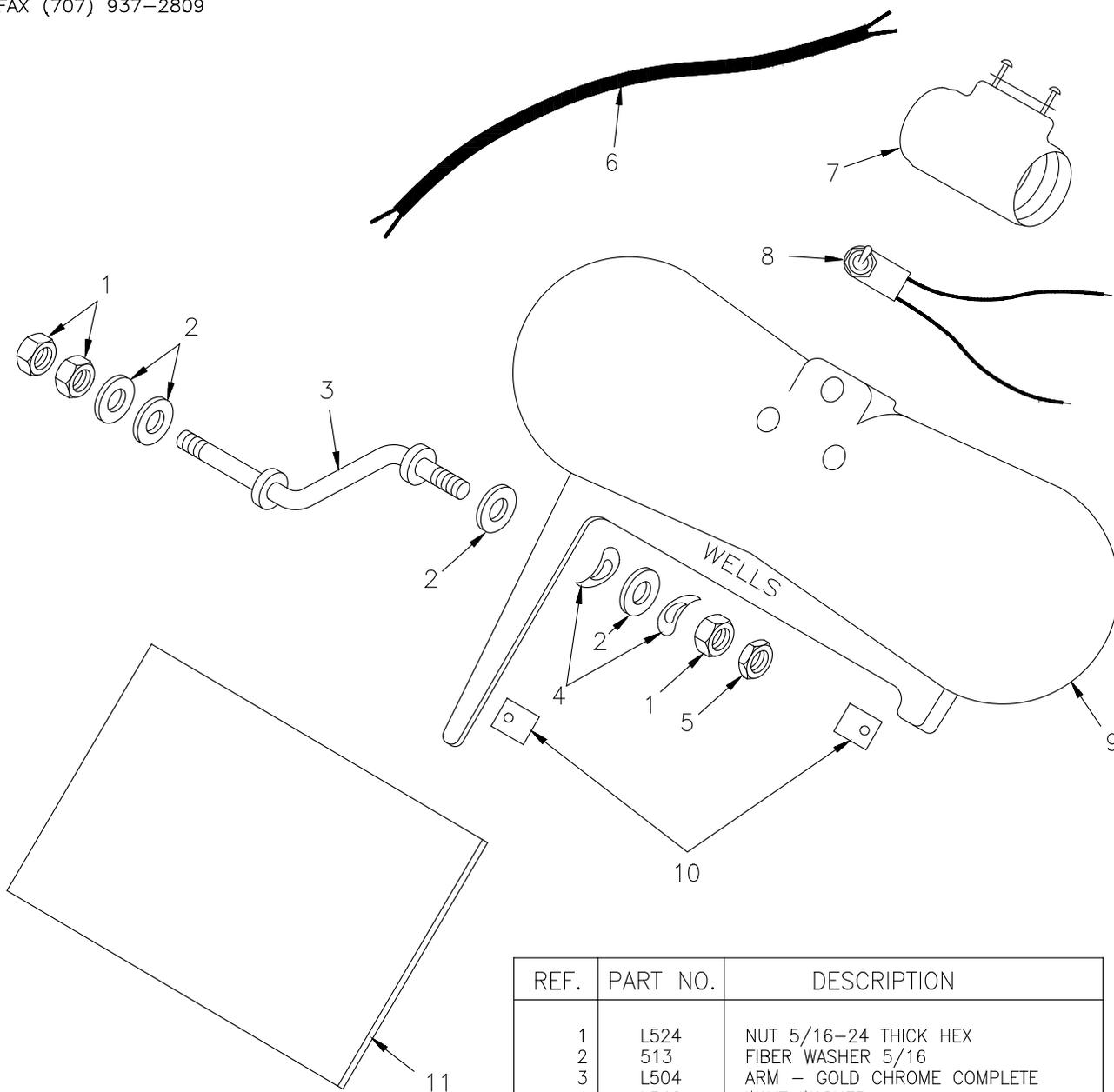
REF.	PART NO.	DESCRIPTION
1	S551	PULLEY JAM NUT
2	S114	PULLEY FOR S012/S013
3	536	SCREW SET 10-32 X 3/16
4	S155	COLLET WRENCH 4 JAW
	S159	COLLET WRENCH 1/16
	S161	COLLET WRENCH 3MM & 1/8
5	S545	HANDLE
6	S546	GRIP 2-3/8"
5&6	S112	HANDLE KIT
7	S165	TUBE BRUSH 3/16
8	159	HEX WRENCH 1/8
9	151	HEX WRENCH 3/32
10	S152	STOP TUBES SET OF 6
11	S153	STOP REMOVING TOOL
7-11	S250	ACCESSORY KIT
12	S142	STOP TUBE .245 BLUE 1 MARK
13	S143	STOP TUBE .255 YELLOW 2 MARKS
14	S144	STOP TUBE .265 ORANGE 3 MARKS
15	S146	STOP TUBE .275 RED 4 MARKS
16	S148	STOP TUBE .285 GREEN 5 MARKS
17	S150	STOP TUBE .295 BRASS 6 MARKS
18	S106	COLLET 3/32
	S105	COLLET 1/16
	S108	COLLET 3MM
	S110	COLLET 1/8
19	138	SHIPPING ROD 3/32

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 COMPTCHE, CA USA 95427  
 PHONE (707) 937-0521  
 1 800 233-0521  
 FAX (707) 937-2809

## PARTS LIST for LIGHT SHIELD



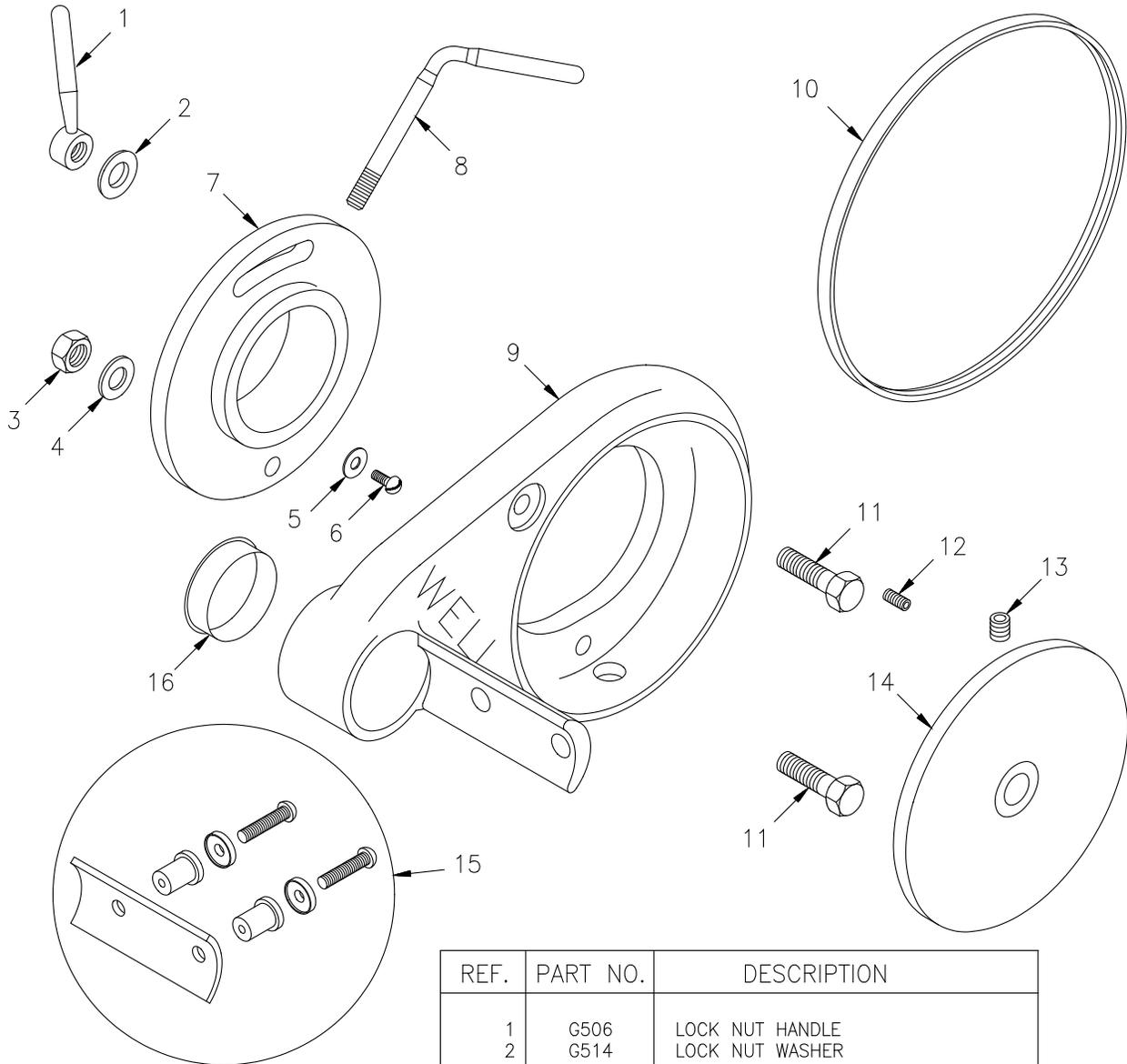
REF.	PART NO.	DESCRIPTION
1	L524	NUT 5/16-24 THICK HEX
2	513	FIBER WASHER 5/16
3	L504	ARM - GOLD CHROME COMPLETE
4	L540	WAVE WASHER
5	L526	NUT 5/16-24 THIN HEX
6	L106	LIGHT CORD KIT (with connectors)
7	L118	LIGHT SOCKET KIT (with screws)
8	L120	TOGGLE SWITCH KIT (with connectors)
9	L512	LIGHT SHIELD RH
10	L102	SHIELD CLIPS PKG-2 (with screws)
11	L110	GLASS SHIELD FOR WELLS

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**PARTS LIST for BRACKET ASSEMBLY  
 for RED WING LATHE**



REF.	PART NO.	DESCRIPTION
1	G506	LOCK NUT HANDLE
2	G514	LOCK NUT WASHER
3	G507	PIVOT JAM NUT
4	513	FIBER WASHER 5/16
5	512	WASHER #8 FLAT
6	527	SCREW 10-32 X 1/4 RHZC
7	G500	FLANGE
8	G110	HEIGHT ADJUSTMENT HANDLE
9	G503	BRACKET
10	S406	BELT 2/3M475
11	G501	BOLT HEX 5/16-18 X 1-1/8 ZC
12	G512	SCREW SET 10-32 X 1/2
13	570	SCREW SET 1/4-28 X 1/4
13&14	S482	MOTOR PULLEY 2V-V/B/RW
15	S220	SPINDLE MOUNTING KIT
16	G120	HOLE PLUG