

SECTION A-A SABRE ERO & ARROW ERO- 8000 RPM M/C.S ONLY

GREASE PACK WITH
CHEVRON SRI #2

SABRE OR ARROW ERO-
8000 RPM M/C.S ONLY

SHOW IN TOOL
CLAMP POSITION.
8500N (+15%/-7.5%)
TOOL CLAMP.
10250N (+15%/-7.5%)
TOOL KNOCK-OUT

LOCTITE TO DRAWBAR.
BEARING FIT 641

CRITICAL PART

PEEN LEAD WEIGHT IN
HOLE AFTER BALANCING.
TO PREVENT WEIGHT FROM
FALLING OUT WHEN KEY
IS REMOVED.

FRONT OF MACHINE

NOTE - SABRE 1250/1500/2000
SNOUT SHOWN

NO LUGS ON SABRE 500/750/1000 ERO
& ARROW ERE OR ERO STD OR 8000RPM
MACHINES.

LOCTITE - SCREWLOCK
TORQUE TO 15 NM

LOCTITE - SCREWLOCK
SABRE & ARROW 8000
RPM MACHINES ONLY.

CRITICAL PART
LUBRICATE SPRINGS WITH
MOLYKOTE 321R SOLID
FILM LUBRICANT.

LOCTITE - SCREWLOCK
TORQUE TO 120 NM
OVERTORQUE TO NEXT SLOT

STANDARD SABRE & ARROW.
ERO. 8000 RPM M/C.S ONLY.

HIGH TORQUE SABRE ERO AND
ARROW ERE & ERO (NOT 8000
RPM) MACHINES ONLY.

ARROW 500/750 (STD. 6000 RPM)

SABRES & ARROW 8000 RPM M/C.S

SABRE & ARROW ERO 8000
RPM MACHINES ONLY.

SABRE 500/750/1000 ERO M/C.S
ARROW 500/750 ERO 8000 RPM

SABRE 1250/1500/2000 ERO

ARROW 500/750 ERE & ERO M/C.S
(NOT ERO 8000 RPM) MACHINE

QTY 3-SABRES & ARROW ERO.
QTY 2-ARROW ERO M/C.S (BUT
ERO 8000 RPM)

SABRE ERO & ARROW ERO.
8000 RPM MACHINES ONLY.

ARROW ERO (BUT NOT ERO.
8000 RPM) M/C.S ONLY

FITTED TO ARROW
ERE & ERO M/C.S
ONLY (2 PLACES)
(NOT ERO 8000 RPM) SEE

IMPORTANT NOTE -
LOCTITE - SCREWLOCK &
TORQUE TO 30 NM (SABRE
& ARROW ERO 8000 M/C.S)
LOCTITE - SCREWLOCK &
TORQUE TO 19 NM (ARROW
ERO (BUT NOT ERO 8000
RPM) M/C.S ONLY.

LOCTITE - SCREWLOCK
TORQUE TO 15 NM

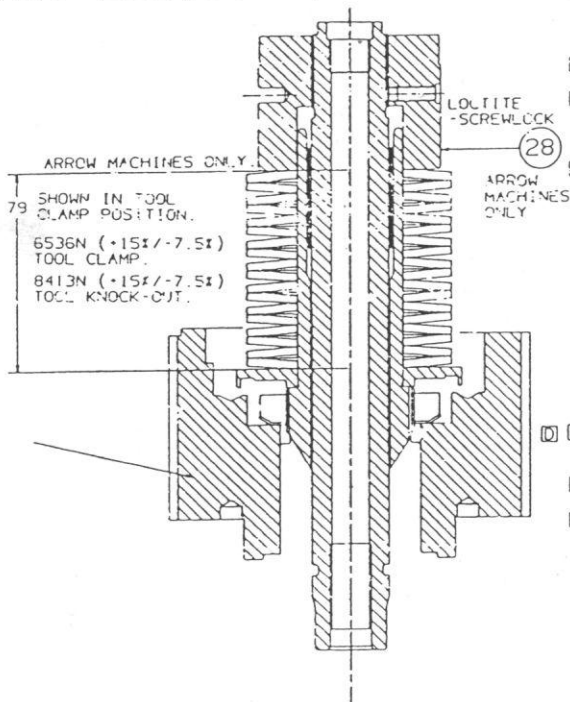
NOTE - DRIVE KEY MUST BE LOCATED
IN ITS INNER MOST POSITIO
DO NOT USE KEY TO BALANCE
SPINDLE.

COVER FIXING AND
EXTRACTOR HOLES. MB (3)

BALANCE SPINDLE
BALANCE QUALITY
ITEMS IN BALANCE
MAXIMUM PERMISSIBLE
CORRECTIVE PLANE
27 g MM (HIGH TORQUE)

NOTE - MAX SPEED OF SPINDLE = 10.6
NOTE - MAX SPEED OF SPINDLE =

ARROW ERE MACHINES ONLY
BUT NOT ERO,8000,RPM.M/C.S)



NOTE 'A'

ON END FACES USE OUTER PART
OF PLUG ONLY AND LOCTITE
IN POSITION USING LOCTITE 603

SECTION C-C

SEE NOTE 'A'

SECTION A-A

SEE NOTE 'A'

DRAIN HOLE

SNOUT SECTIONS A-A & C-C SHOWING
INTERDRILLING PLUGS ON SABRE ERO
& ON ARROW, ERO, 8000, RPM, M/C ONLY.

QTY	001	002	ITEM	001	PART NUMBER	PART NAME	SHEET NO	REV
1	1	1	1	1	1234C28	SCREW - CAP M6 X 20		
6	6	6	2	6	1234045	SCREW - CAP M8 X 20		
1	1	1	3	1	1267669A	SPINDLE		
1	1	1	4	1	1261719A	KEY		
1	1	1	5	1	1266594	CAP - BEARING		
1	1	1	6	1	1268595	GASKET		
1	1	1	7	1	1430232	BEARING - OIL LUBRICATED		12
2	3	3	8	3	1500119	O-RING		
1	1	1	9	1	1268611	SNOUT		
1	1	1	10	1	1268601	SPACER - BEARING		
1	1	1	11	1	1425223	KEY 16 X 10 X 45		
1	1	1	12	1	126860	PULLEY - STANDARD		
1	1	1	13	1	1261730	WASHER - LOCKING		
REF	REF	REF	REF	REF	1261729	LOCKNUT - M50 X 1.5 PITCH		
1	1	1	15	1	1258503	PLATE - SPRING		
18	18	18	16	18	1264436	SPRING - DISC		12
1	1	1	17	1	1258602	COLLAR - SPRING		
2	2	2	18	2	1234377	SCREW - GRUB #46 X 16		
1	1	1	19	1	1263902	WEIGHT - LEAD		
4	4	4	20	4	13665	BALL - STEEL		
1	1	1	21	1	1268052	DRAWBAR		
1	1	1	22	1	1500067	NU-LIP SEAL		17
1	1	1	23	1	1268606	PUSH ROD		
1	1	1	24	1	1264991	BEARING - BALL CAGE		12
1	1	1	25	1	1268628	PULLEY - HIGH TORQUE		
1	1	1	26	1	1268632	SNOUT		
1	1	1	27	1	1268633	SNOUT		
1	1	1	28	1	1268630	COLLAR - SPRING		
6	6	6	29	6	1268631	PLUG - INTERDRILLING		
1	1	1	30	1	1430211	BEARING - GREASE LUBRICATED		12
2	2	2	31	2	1425058	PAD - NYLON		
2	2	2	32	2	1420164	PLUG	Rc3/8	
2	2	2	33	2	1420162	PLUG	Rc1/8	
1	1	1	34	1	1264786	SPACER - BEARING		
			35					
			36					
			37					
			38					
			39					
			40					

61262420 005 ARROW 500/750 ERE

61262420 004 SABRE 500/750/1000 ERO HIGH TORQUE

61262420 003 SABRE 500/750/1000 ERO STD. TORQUE & ARROW, ERO, 8000, RPM, M/C

61262420 002 SABRE 1250/1500/2000 ERO HIGH TORQUE

61262420 001 SABRE 1250/1500/2000 ERO STANDARD TORQUE

PLA NUMBER DESCRIPTION OF UNIT

* NOTE: - THIS ARROW 500/750 ERO (IS LIMITED TO 9000, RPM BY ITS SOFTWARE)

ARROW ERO SPINDLE BEARING RUN-IN PROCEDURE (6000RPM SPINDLE)				
SPEED RPM	DURATION (HRS)	TOTAL (HRS)	BELT TENSION	
250	0.25	0.25	150 N	
500	0.5	0.75		
1000	0.5	1.25		
2000	0.5	1.75		
3000	0.5	2.25		
4000	0.75	3.00		
5000	0.75	3.75		
6000	0.75	4.5	150 N	

ARROW ERO SPINDLE BEARING RUN-IN PROCEDURE (8000RPM SPINDLE)				
SPEED RPM	DURATION (HRS)	TOTAL (HRS)	BELT TENSION	
250	0.25	0.25	150 N	
500	0.5	0.75		
1000	0.5	1.25		
2000	0.5	1.75		
3000	0.5	2.25		
4000	0.75	3.00		
5000	0.75	3.75		
6000	0.75	4.5		
7000	0.75	5.25		
8000	0.75	6.0	150 N	

SABRE ERO SPINDLE BEARING RUN-IN PROCEDURE (10000RPM SPINDLE)				
SPEED RPM	DURATION (HRS)	TOTAL (HRS)	BELT TENSION	
500	0.25	0.25	150 N	
1000	0.25	0.50		
2000	0.25	0.75		
3000	0.25	1.00		
4000	0.5	1.50		
5000	0.5	2.00		
6000	0.5	2.50		
7000	0.5	3.00		
8000	0.75	3.75		
9000	0.75	4.50		
10000	1.25	5.75	150 N	

A213566	8/11/95	G T J	J	RUNIN DATA ADDED FOR 10000RPM M/C S.
A211866	20/6/95	G P S	H	NOTE ADDED (G4)
A211706	12/6/95	I COK	2	#1264786 WAS #1268601 (WAS ONLY) NOTE ADDED.
				#1500119 QTY 2 WAS 3 (005 ONLY)
A211626	22/5/95	G T J	F	SUFFIX 003 NOW INCLUDES ARROW, ERO 8000, M/C
A211326	10/5/95	G P S	E	NOTE ADDED
				ITEM 29-QTY 6 WAS 8 -001-002-003-004
A207666	MAR 95	W H	D	SECTION E-E DELETED
A208256	FEB 95	CHANN	NEW	
A209556	01 95	DOM	NEW	-003 & -004
A207666	12 94	DOM	NEW	ITEM 29 8 WAS 6 SECTION E-E ADDED.
A207666	12 94	DOM	NEW	ITEM 14 REF WAS QTY 1
A207666	7/12/94	I COK	A	#1420164 (2 OFF) ADDED TO -001-002 ONLY
A207666	10 94	DOM	NEW	-001 & -002

IN-PROCESS PAINTING REQUIREMENTS

DATE: 27.10.94

61262420

1/55.Y
GRADE G2 S TO B55265. PART 1. 1979 & 150 1940
NCEED UNIT: - 1, 14, 11, 3, 4, 12/25, 13
RE RESIDUAL UNBALANCE (TOL 1 & TOL 2) AT EACH
NOT TO EXCEED 11 u. mm. (STANDARD TORQUE)
(005)
0000 RPM (STANDARD TORQUE) 5000 RPM HIGH TORQUE
GG (STANDARD TORQUE) 13.6 KG (HIGH TORQUE)
3000 RPM (ARROW ERO) BALANCED UNIT W.T. 10.6 KG