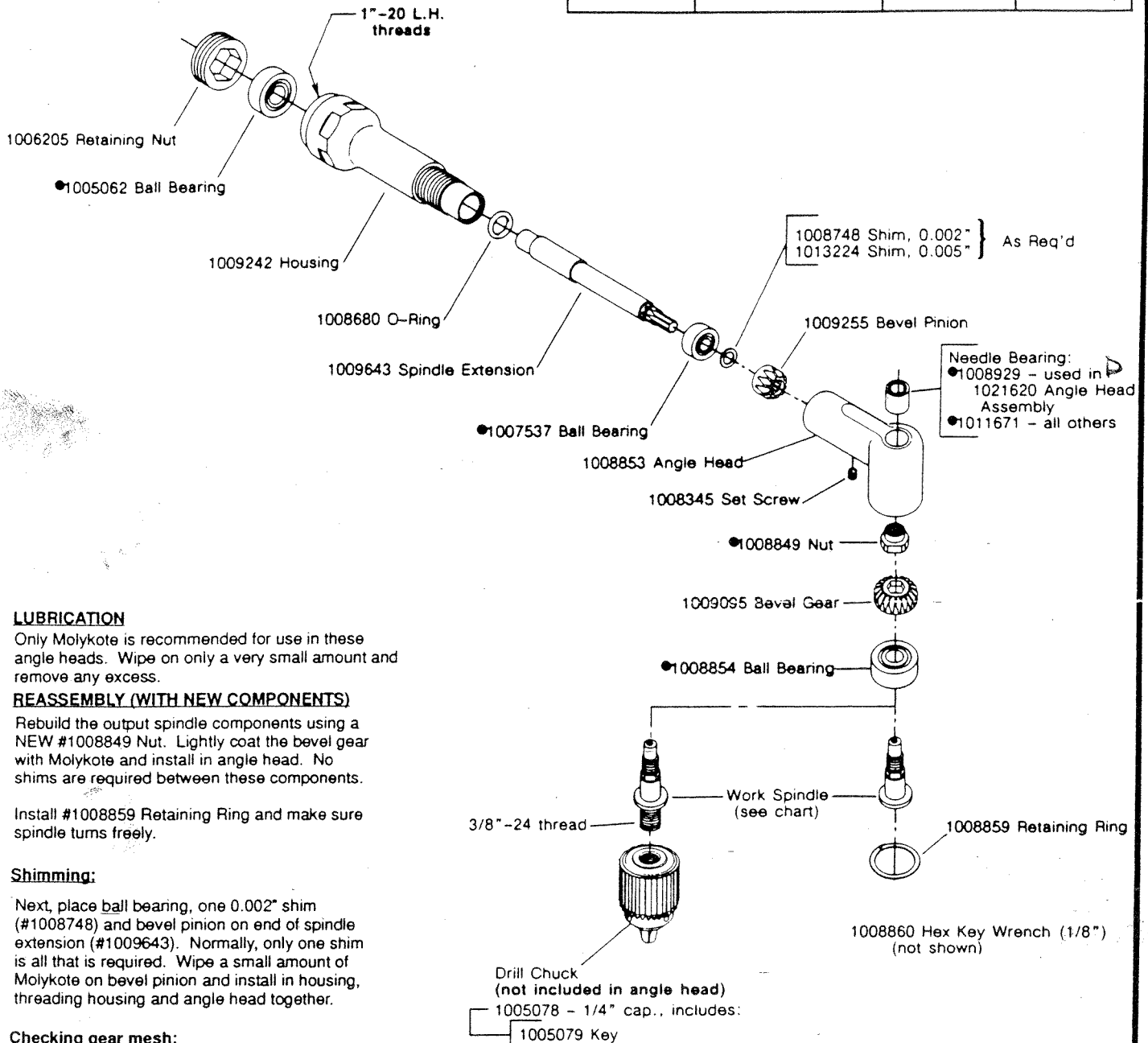


**DOTCO®**  
**Model 15LS & 15LN Series Angle Drills**  
**90° Heavy Duty Angle Heads**

| Angle Head Assembly Part Number | Assembly Includes Output Spindle Part Number | Spindle Thread Size (Internal) | Termination Code |
|---------------------------------|----------------------------------------------|--------------------------------|------------------|
| 1025547                         | 1110062                                      | #10-32                         | -51              |
| 1021289                         | 1008850                                      | 1/4"-28                        | -52              |
| 1021292                         | 1008948                                      | 9/32"-40                       | -53              |
| 1021291                         | 1008856                                      | 5/16"-24                       | -54              |

(male thread)

|         |         |         |     |
|---------|---------|---------|-----|
| 1021620 | 1015703 | 3/8"-24 | -59 |
|---------|---------|---------|-----|

**LUBRICATION**

Only Molykote is recommended for use in these angle heads. Wipe on only a very small amount and remove any excess.

**REASSEMBLY (WITH NEW COMPONENTS)**

Rebuild the output spindle components using a NEW #1008849 Nut. Lightly coat the bevel gear with Molykote and install in angle head. No shims are required between these components.

Install #1008859 Retaining Ring and make sure spindle turns freely.

**Shimming:**

Next, place ball bearing, one 0.002" shim (#1008748) and bevel pinion on end of spindle extension (#1009643). Normally, only one shim is all that is required. Wipe a small amount of Molykote on bevel pinion and install in housing, threading housing and angle head together.

**Checking gear mesh:**

Hold end of spindle extension with fingers and turn output spindle back-and-forth. Acceptable play is 0.005", or less. Add only one shim at a time (or take out one shim) until play is correct.

(\*) Indicates recommended spare part. Order one (1) or one set for every 6-10 tools. Small, low cost or easily lost parts should also be ordered on the basis of 3-4 per 10 tools.