



Removing the Slide Screw Insert Nut when the Internal Threads Are Gone

The brass slide screw insert and anti-backlash nuts are designed to be the parts that wear out first. We rarely ever have a customer who has entirely worn out the thread of the slide screw insert. However, if the threads of your slide screw insert no longer exist, you can't use the slide screw to remove the slide screw insert from the saddle. In this case, follow the instructions below.

Excessive wear generally happens either from many hours of use, constant rapid movements over time, or from lack of lubrication. You will generally notice a larger amount of backlash in the axis that is wearing out. To remove the backlash, you adjust the anti-backlash nut. Keep track of how many times you have adjusted the anti-backlash nut. If you have adjusted it 4 or 5 times, it is probably time to replace them (before the threads are entirely gone).

Removing a Worn Slide Screw Insert Nut

The slide screw is either 1/4" or 6.3mm. The clearance hole in the saddle is just under .300". If you use a drill that is 17/64" to 9/32", the drill will be larger than the slide screw OD and smaller than the clearance hole in the saddle.

Place the drill in the clearance hole "shank end in." Then tap the end of the drill bit to force the slide nut out (see Figure 1).

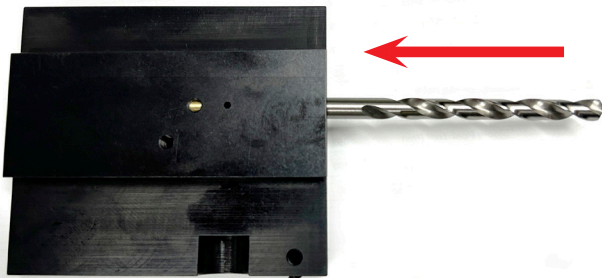


FIGURE 1—Tap the drill bit in the direction of the red arrow to force the slide screw insert nut out (mill X/Y saddle show for reference).

While you have your machine apart, now would be a good time to replace the slide nut and anti-backlash nut on the Y-axis as well.

Thank you,
Sherline Products Inc.

Instructional Videos

Before you replace the worn parts, please look at some of the instructional videos that we have on our website.

[Backlash and Gib Adjustment on Lathe Saddle](#)
[Adjusting Backlash on Sherline Lathes and Mills](#)

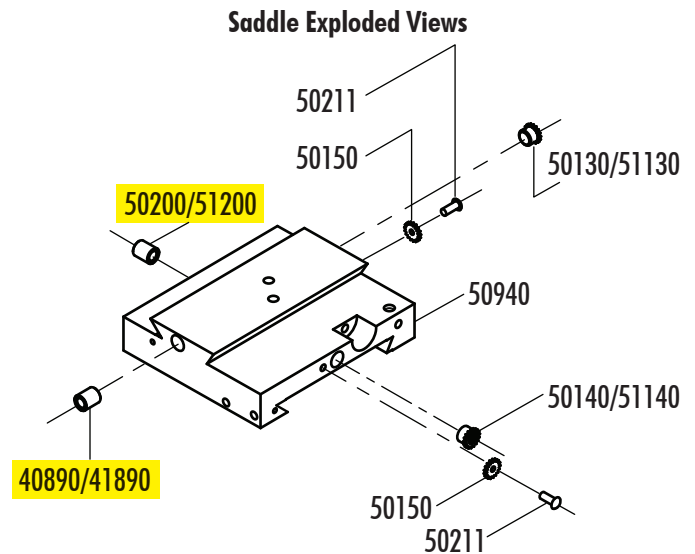


FIGURE 2—Mill X/Y saddle. The slide screw insert nuts are highlighted in yellow. Additional listed parts: X-axis Backlash Nut (P/N 50130/51130), Y-axis Backlash Nut (P/N 50140/51140), Anti-Backlash Lock (P/N 50150), 8-32 X 1/4" Button Socket Screw (P/N 50211), Mill X/Y Saddle (P/N 50640).

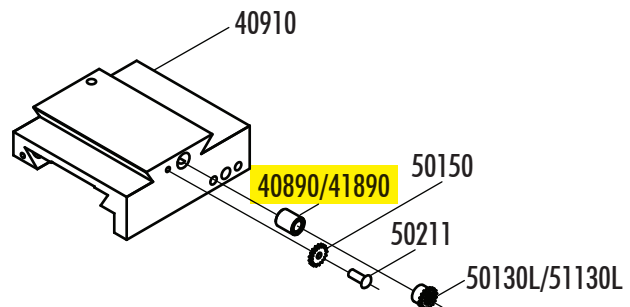


FIGURE 3—Lathe saddle. The slide screw insert nut is highlighted in yellow. Additional listed parts: Lathe Backlash Nut (P/N 50130L/51130L), Anti-Backlash Lock (P/N 50150), 8-32 X 1/4" Button Socket Screw (P/N 50211), Lathe Saddle (P/N 40910).

NOTE: Where different, Inch part number is given first, followed by Metric part number.