

Sleeve

SL-19.05×25×6.5L  
SL-19.05×25×21.5L

OPERATION MANUAL

Thank you for purchasing the Sleeve SL-19.05×25×6.5L / SL-19.05×25×21.5L. This sleeve is designed exclusively for the BM-319F motor spindle, for use with CNC lathes from CITIZEN MACHINERY CO., LTD. Read this operation manual and the manuals for the BM-319F carefully before use for proper and long-term operation. Keep this manual in an accessible place for future reference.

1. CAUTIONS FOR HANDLING AND OPERATION

- Read these warnings and cautions carefully and only use in the manner intended.
- These warnings and cautions are intended to avoid potential hazards that could result in personal injury to the operator or damage to the device. These are classified as follows in accordance with the seriousness of the risk.

Class	Degree of Risk
<b>WARNING</b>	<b>A safety hazard could result in bodily injury or damage to the device if the safety instructions are not properly followed.</b>
<b>CAUTION</b>	<b>A hazard that could result in light or moderate bodily injury or damage to the device if the safety instructions are not followed.</b>

**WARNING**

- ① This product is not a hand tool. Use this sleeve to mount the BM-319F motor spindle onto a compatible CNC lathe. Do not mount it to other motor spindles or machines.
- ② Never handle or remove this product until safety has been confirmed as described below.
  - 1) Before handling this product, confirm the safety of the entire machine to prevent injury and damage.
  - 2) Before removing this product, confirm the machine is safe, shut off all power and air supplies, and then exhaust all residual compressed air from the system.

**CAUTION**

- ① Do not drop or strike this product. Deformation can impair its performance and lead to motor spindle failure.
- ② Before use, inspect this product for any deformation, chips, or scratches. If any such damage is found, replace it with a new one.
- ③ If any looseness or abnormal vibration occurs during operation, stop work immediately and check that the motor spindle is not loose.
- ④ As part of daily start-up and shut-down inspections, ensure the motor spindle is not loose.
- ⑤ Do not modify this product. If modified, performance cannot be guaranteed thereafter.

2. PACKAGE CONTENTS

After opening the package, confirm that all items listed in “Table 1 Package Contents List” are included. If any package contents are missing, please contact “4. CONTACT US” or your purchasing dealer.

Table. 1 Package Contents List (Listed by sleeve type)

SL-19.05×25×6.5L	
Sleeve • • 1 pc (SL-19.05×25×6.5L)	Hexagon socket bolt (M5×12)(low head) • • 2 pcs (For fixing the Sleeve)
SL-19.05×25×21.5L	
Sleeve • • 1 pc (SL-19.05×25×21.5L)	Hexagon socket bolt (M5×25) • • 2 pcs (For fixing the Sleeve)
Common Items	
Operation manual • • 1 pc	Hexagon socket bolt (M4×22) • • 2 pcs (For mounting the BM-319F)

3. WARRANTY

We do not provide a warranty for our products; however, we will provide product replacement or free repair in the following cases (1)–(3). Please contact “4. CONTACT US” or your purchasing dealer.

- (1) Manufacturing defects by our company.

(2) Shortage of package contents.

(3) Product damage found when opening the package.
- (However, product replacement and free repair do not apply if the package was dropped due to customer negligence.)

4. CONTACT US

For your safety and convenience when purchasing our products, we welcome your questions. If you have any questions about operation, maintenance and repair of the product, please contact us.

Contact Us

- For U.S. Market

Company Name : **NSK America Corp.**  
Industrial Div.  
Business Hours : 8:00 to 17:00 (CST)  
(closed Saturday, Sunday and Public Holidays)  
U.S. Toll Free No. : +1 800 585 4675  
Telephone No. : +1 847 843 7664  
Fax No. : +1 847 843 7622  
Website : [www.nskamericacorp.com](http://www.nskamericacorp.com)
- For Other Markets

Company Name : **NAKANISHI INC.**  
Business Hours : 8:00 to 17:00 (JST)  
(closed Saturday, Sunday and Public Holidays)  
Telephone No. : +81 289 64 3520  
e-mail : [webmaster-ie@nsk-nakanishi.co.jp](mailto:webmaster-ie@nsk-nakanishi.co.jp)

5. FEATURES

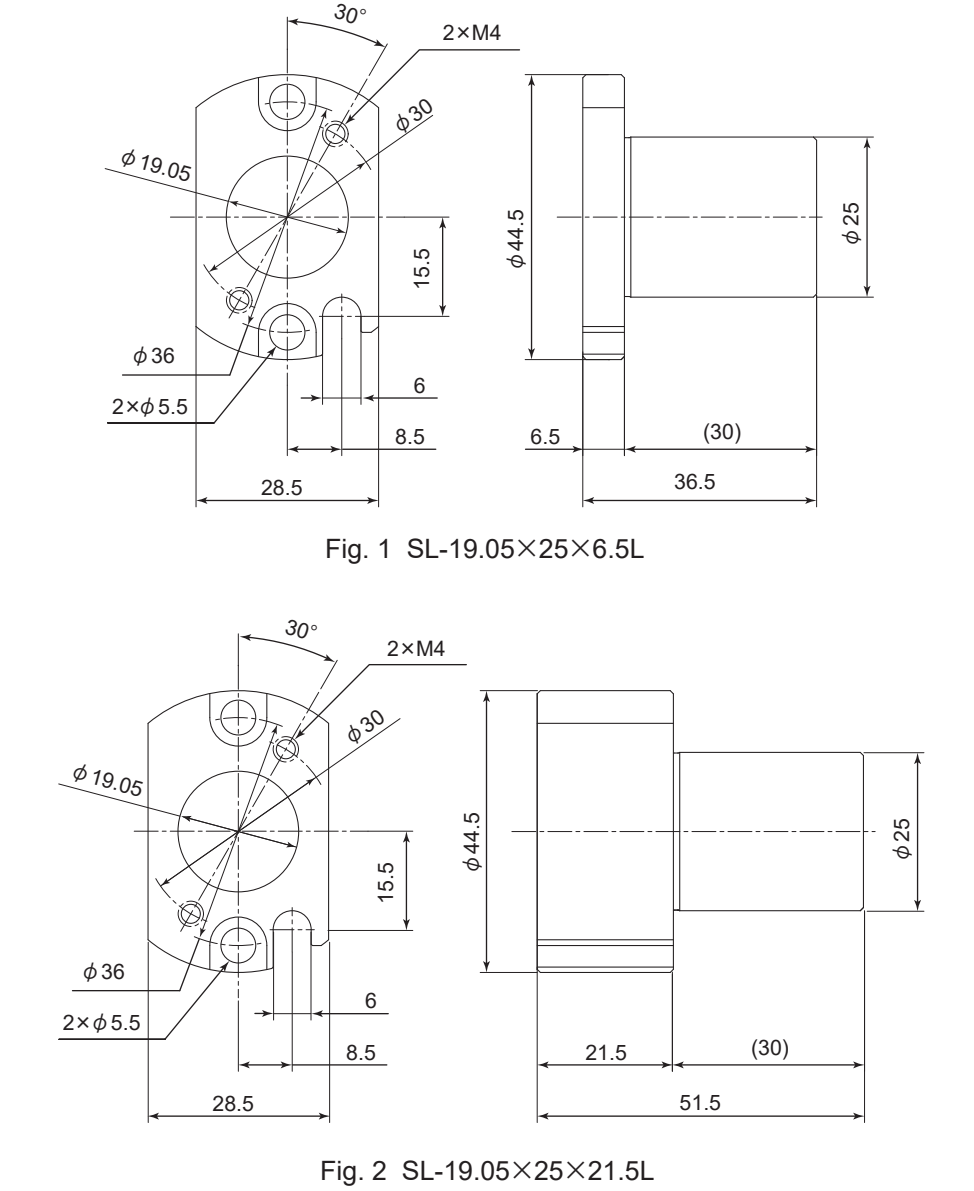
- ① This is a stainless steel (SUS) sleeve with a 19.05 mm inner diameter and a 25 mm outer diameter.
- ② This sleeve can be mounted on compatible CITIZEN MACHINERY CO., LTD. CNC lathes.
- ③ This sleeve allows for easy mounting and removal of the motor spindle.

6. SPECIFICATIONS AND DIMENSIONS

6 - 1 Specifications

Product Name	Sleeve		
Model	SL-19.05×25×6.5L	SL-19.05×25×21.5L	
Applicable CNC Lathes	CITIZEN MACHINERY CO., LTD.: L12, L20, M16, M20, M32, etc.		
Compatible Rotary Tool	MSC507		
Compatible Motor Spindle	BM-319F		
Net Weight	85 g	175 g	
	Temperature	Humidity	Atmospheric Pressure
Operation Environment	0–40°C	MAX.75 % (No condensation)	700–1,060 hPa
Transportation and Storage Environment	-10–50°C	10–85 %	500–1,060 hPa

6 - 2 Outside View



7. INSTALLATION

**CAUTION**

- Follow the installation procedure exactly.Failure to do so may prevent this product from being installed correctly.

- ① Insert this sleeve into the CNC lathe’s holder.

② Align the two mounting holes on the sleeve with those on the holder. Secure it using two M5 hexagon socket bolts.

③ Insert the body of the motor spindle into the sleeve.

④ Align the two mounting holes on the motor spindle’s flange with those on the sleeve. Secure it using two M4 hexagon socket bolts (see Fig. 3).

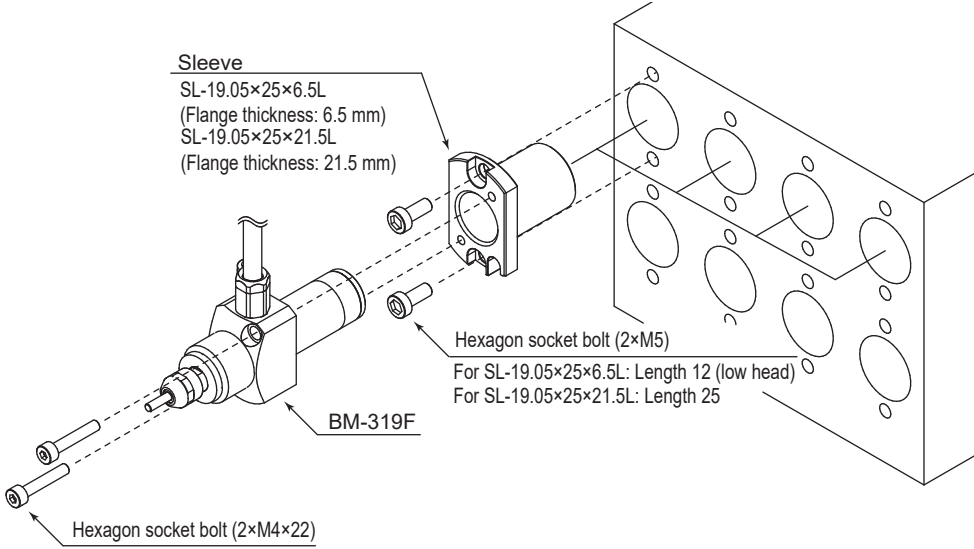


Fig. 3

8. DISPOSAL OF THE SLEEVE

When disposal of a Sleeve is necessary, follow the instructions from your local government agency for proper disposal of industrial components.