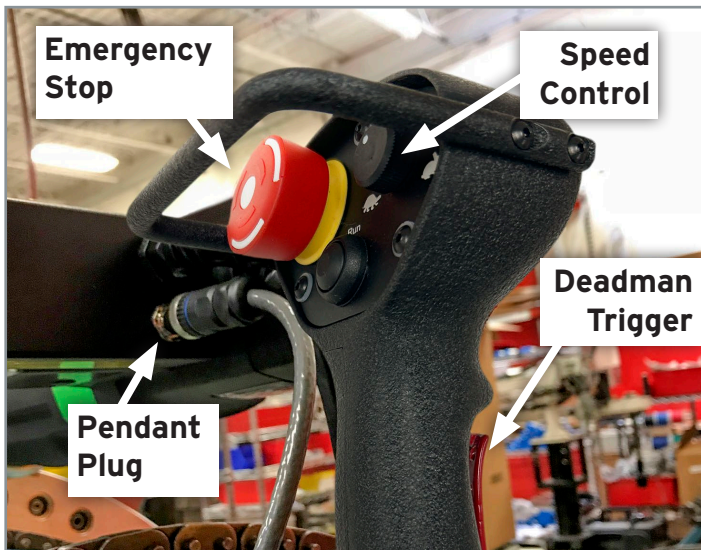
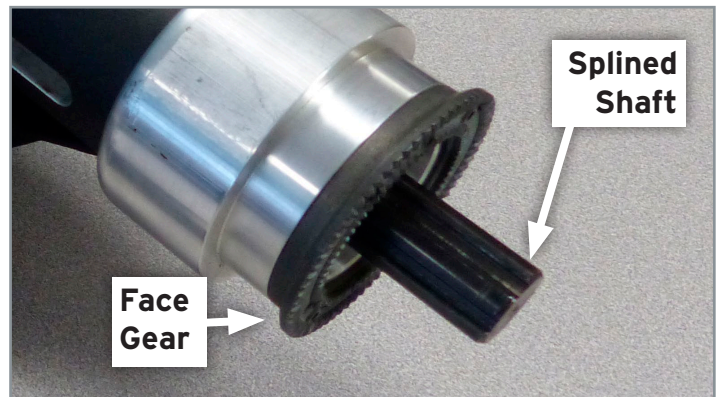
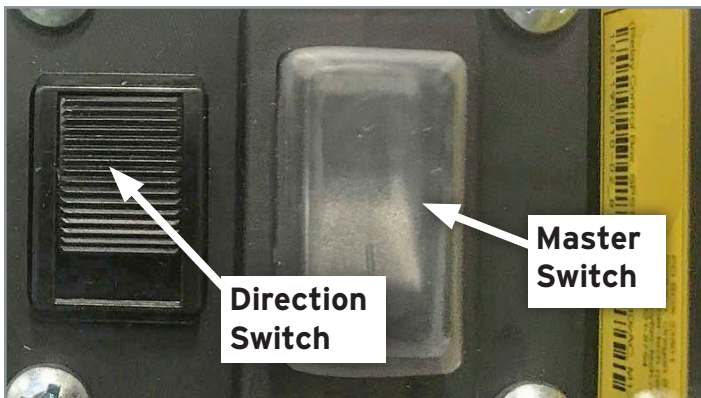


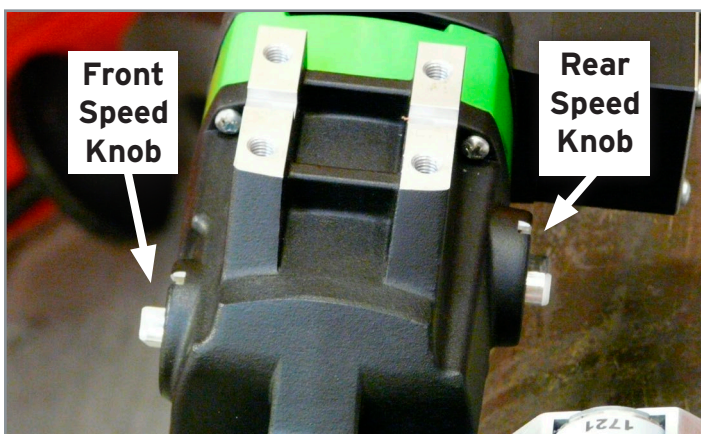


WARNING - Before you install the Wachs HD drive motor, make sure it is completely de-energized: unplugged, master switch off (O), emergency stop button pressed in (power disabled position).



Installing the Wachs Electric HD Drive

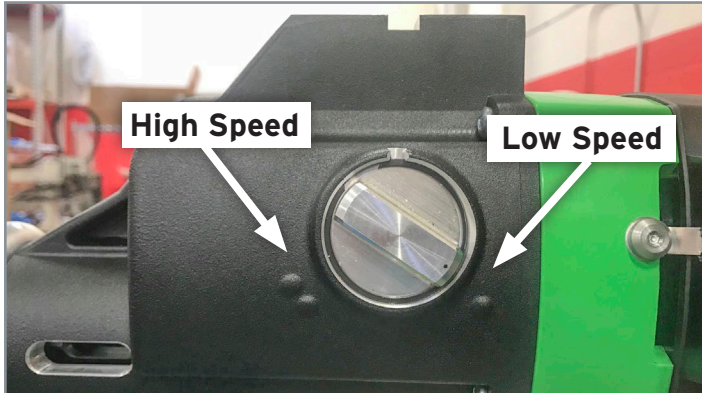
1. Do not apply force to the drive motor control box during installation, operation or removal.
2. Hold the drive motor securely, and insert the motor shaft into the pinion gear socket.
3. Position the face gear on the drive motor flush to the pinion. Motor mounts in any orientation.
4. Secure the motor to the machine by closing the quick clamping lever.
5. Connect the control pendant to the drive motor control box with the screw-on collar.
6. Drive motor direction switch is to remain set to forward at all times.
7. Set the front speed selector knob to low speed, (single raised dot). **The front speed selector should remain in the low speed setting at all times.**
8. For parting and beveling, set the rear speed selector knob to low speed (single raised dot). For single point beveling and flange facing, set the knob to high speed (double raised dots).



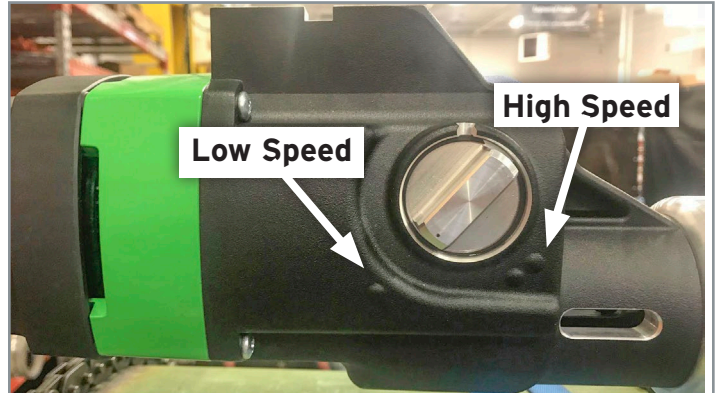
NOTICE - It may be necessary to energize the drive motor and "bump" the motor to align the gears before rotating the gear selector knob. Do not force the gear selector knobs.



Rear Speed Selector Knob



Front Speed Selector Knob



Gearbox Settings

Speed Setting	Rear Speed Knob	Front Speed Knob	Application
Setting 1 Slowest	Low Speed	Low Speed	Parting & Beveling
Setting 2 Slow	High Speed	Low Speed	Single Point Beveling, Flange Facing



WARNING - Any time you stop the machining process, push in the emergency stop button to disable power.



CAUTION - Drive motor housing may become hot during extended operation. Use care not to touch hot drive motor surfaces.

Operating Wachs Electric HD Drive

1. Plug the Wachs Electric HD into a recommended 20 amp electrical circuit (15 amp minimum).
2. Turn master switch on the drive motor housing to the on (I) position.
3. Set the drive motor rotational speed control on the control pendant to the slowest setting (turtle symbol).
4. Rotate emergency stop button on control pendant clockwise to release, enabling power. To stop power to the motor, push the emergency stop button.
5. Squeeze the deadman trigger on the pendant to energize the drive motor. Release the trigger to stop the drive motor.
6. Rotate the machine tool slowly to confirm clearances and tooling position.
7. Set the drive motor rotational speed control on the control pendant to the ideal machining speed.
8. Engage tool slide trip and begin machining operation.

Removing Wachs Electric HD Drive

1. Push the emergency stop button on the control pendant to disable power.
2. Set master switch on the motor housing to the off (O) position.
3. Unplug the drive motor from the electrical circuit. Allow the motor to cool as required.
4. Disconnect the control pendant from the drive motor control box with the screw-on collar.
5. Hold the drive motor securely, and open the quick clamping lever that secures the motor to the machine. Remove the drive motor from the machine.
6. Clean and dry the Wachs Electric HD drive motor and control pendant before storage.