



Technical Document

Enabling Your Ideas

PCNC 770 Stand Assembly

Product Identification: PCNC 770 Machine Stand (PN 31191)

Purpose: This document details the assembly of the PCNC 770 stand.

Qty.	PCNC 770 Machine Stand	PN
1	Stand	—
1	Stainless Steel Wear Guard	—
2	M6 Nut	—
8	M12 Flat Washer	—
4	M12 Spring Washer	—
4	Foot	35259
4	Spacer	32092
4	M12 x 50 mm Screw	—
2	M6 x 20 mm Screw	—
12	M6 x 10 mm Screw	—
1	Adjusting Rod	—
12	M6 Washer	—
4	M5 x 10 mm Screw	—
1	Left Chip Pan	—
1	Right Chip Pan	—
2	Key for Stand	—
1	Butyl Tape	34428
4	M12 Threaded Stud	32648
4	M12 Nut	—



NOTE: If any of these items are missing, contact Tormach Customer Service at (608) 849-8381 for a replacement.

NOTE: Discard 12 M6 Flat Washers included with PCNC 770 Machine Stand. Butyl tape replaces these items.

Required Tools:

- Pallet jack
- Phillips screwdriver
- Tape measure
- Carpenter's level
- Metric taps and handle
- Hammer
- Flat-blade screwdriver
- Metric hex wrench set
- Adjustable wrench
- Shears
- Pry bar
- Multi-purpose grease

Receiving Stand



WARNING! Transport and Lift Hazard: The transport, lifting, and moving of stand should be done by qualified professionals. Failure to do so may result in machine damage, serious injury or death.



WARNING! Sharp Objects: Wear gloves when uncrating mill. Failure to do so may result in serious injury.

1. The PCNC 770 stand is delivered in a wooden shipping crate banded with steel bands. Using a pallet jack or fork truck, transport the crate to the installation site.
2. Remove top of crate first, followed by four sides; set aside Left and Right Chip Pans, Stainless Steel Wear Guard, and accessories box located on top of stand.
3. Carefully tip stand on its side; unbolt pallet from bottom of Stand (see **Figure 1**).

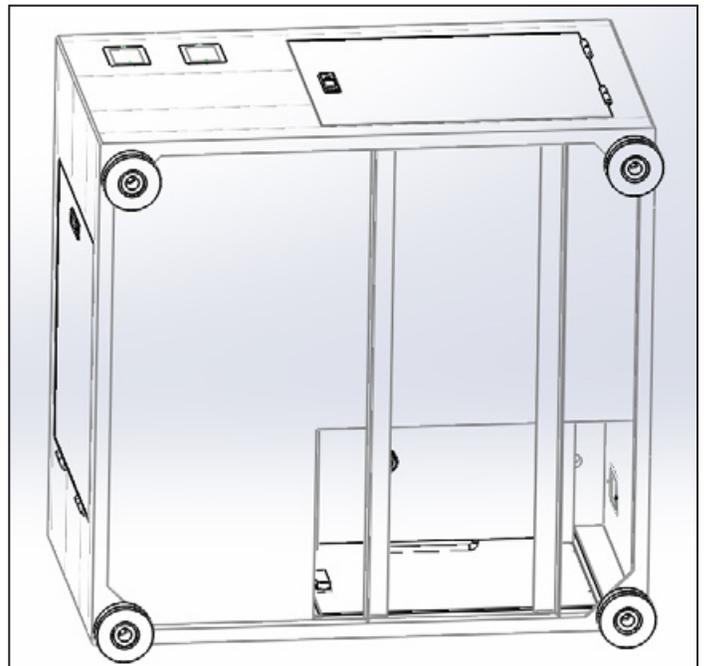


Figure 1

Attaching Feet to Stand

NOTE: Attach feet to Stand after the pallet is removed and while Stand is still on its side (see **Figure 1**).

1. Apply multi-purpose grease to locations indicated in **Figure 2** and join parts together.
2. Insert one M12 Threaded Stud into each foot and slide on Spacer (see **Figure 2**).
3. Attach feet to Stand using assembly shown in **Figure 2**.
4. Carefully return Stand upright so it rests on feet; position Stand where you plan to complete assembly.

NOTE: Position the Stand at least 12" away from walls or other obstructions.

Foot Assembly

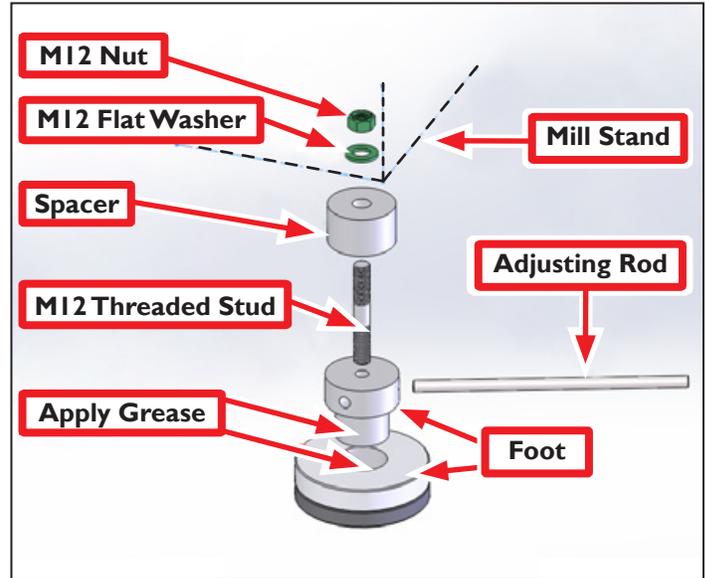


Figure 2

5. When Stand is in its final location, level Stand using a carpenter's level. Adjustments to feet are made using Adjusting Rod to increase or decrease height on each corner (see **Figure 2**).
6. Deburr and grease four mill mounting pads to prevent rust (see **Figure 3**).

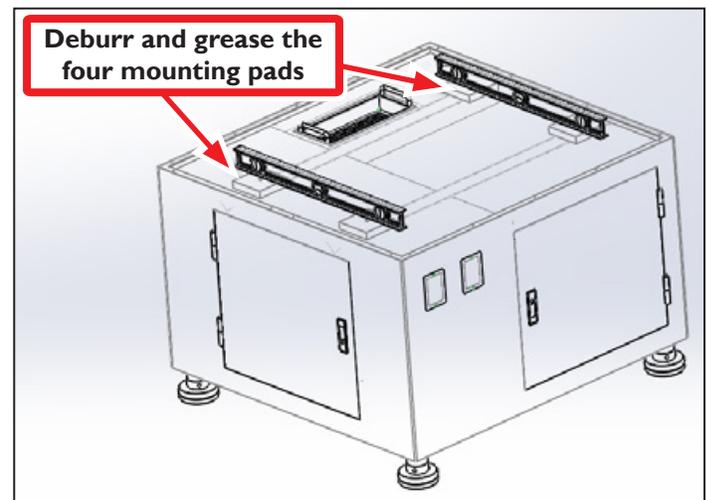


Figure 3

Lifting Mill onto Stand



WARNING! Transport and Lift Hazard: The transport, lifting, and moving of mill should be done by qualified professionals. Failure to do so may result in machine damage, serious injury or death.



WARNING! Crush Hazard: Keep hands and body parts clear when lowering mill onto stand. Failure to do so could result in serious injury or death.

There are several recommended ways to lift mill onto stand. For further information, refer to mill *Operator Manual* chapter 3, *Installation*.

Installing Manual Oiler (optional)

Qty.	PCNC 770 Manual Oiler (PN 31302)	PN
1	Manual Oiler	—
4	Tubing Clips	—
6	M5 x 10 mm Screw	—

NOTE: If any of these items are missing, contact Tormach Customer Service at (608) 849-8381 for a replacement.

NOTE: For information on installation and use of the 115 VAC Automatic Oiler (PN 31373), refer to documentation that ships with product.

- Using two M5 x 10 mm Screws, mount Manual Oiler to pre-drilled holes on left side of mill.
- Route oil line (pre-installed at back of mill near Y-axis motor) down back of stand and along left side as shown in **Figure 4**.
- Using four M5 x 10 mm screws, mount Tubing Clips to pre-drilled holes; connect oil line (see **Figure 4**).
- Fill manual oiler reservoir with ISO VG68 Machine Oil (PN 31386).
- Retract and release plunger until oil is pushed through system. After that, pull plunger:
 - Each time mill is powered on
 - Every four hours of operation



Figure 4

Installing Chip Pans

NOTE: If using the Automatic Tool Changer (PN 32570) and/or Power Drawbar (PN 32436), install now; chip pans may hinder installation.

1. Position chip pans near Stand and test fit; the Left Chip Pan and Right Chip Pan are different.
2. Seal joints between top of Stand and Chip Pans with Butyl Tape as indicated in **Figure 5** prior to installing Left Chip Pan and Right Chip Pan.
3. Using six M6 x 10 mm Screws, attach Right Chip Pan to Stand.
4. Repeat step 2 for Left Chip Pan.
5. Add a strip of Butyl Tape where chip pans meet in front (see **Figure 5**).
6. Using two M6 x 20 mm Screws and two M6 Nuts, join chip pans together.

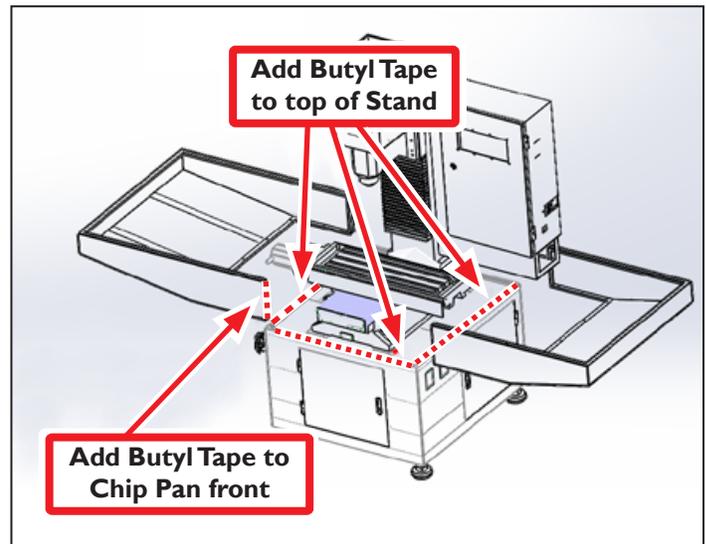


Figure 5

7. Using four M5 x 10 mm screws, attach Stainless Steel Wear Guard across front of chip pans (see **Figure 6**).

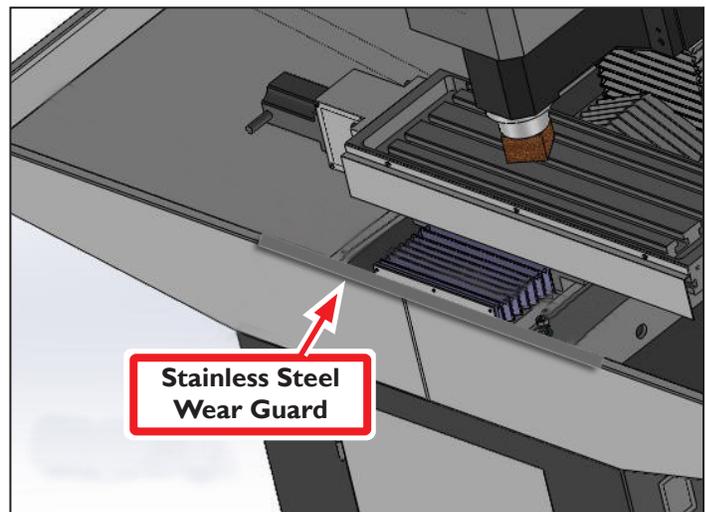


Figure 6