

INSTALLATION GUIDE

TTS TO BT30 POWER DRAWBAR CONVERSION KIT

TECHNICAL DOCUMENT

1.1 PURPOSE

This document gives instructions on installing a TTS to BT30 Power Drawbar Conversion Kit.

1.2 PRODUCT INFORMATION

Product: TTS to BT30 Power Drawbar Conversion Kit (PN 50474)

Quantity	Description
3	BT30 Power Drawbar Standoff, M14 × 2 - 145 (PN 39710)
1	Nut, Jam, M16 × 1.5 (PN 50466)
1	Screw, Shoulder (10 mm Dia. - 30 mm), M8 × 1.25 (PN 50434)
1	Spring, Power Drawbar Plate (PN 50435)



Note: If any items are missing, we can help. Email support@tormach.com to contact Tormach Technical Support for guidance on how to proceed.

1.3 REQUIRED TOOLS

This procedure requires the following tools. Collect them before you begin.

- 17 mm open-ended wrench
- Impact driver
- Metric hex wrench set

TECHNICAL DOCUMENT

2.1 INSTALL THE POWER DRAWBAR STANDOFFS

1. Remove the three M14 flat head cap screws that secure the Power Drawbar cylinder assembly's mounting plate with a 10 mm hex wrench. Set the mounting plate and its hardware aside.
2. Remove the three 105 mm Power Drawbar standoffs from the pneumatic cylinder with a 17 mm open-ended wrench. Discard the standoffs.

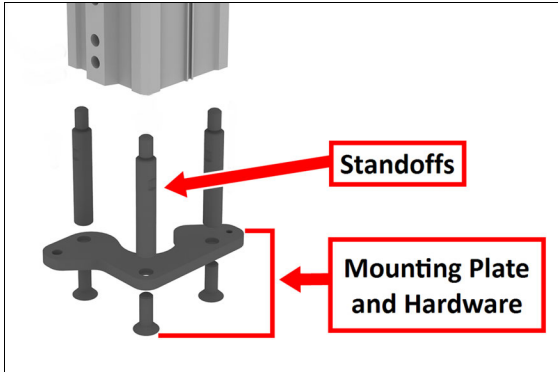


Figure 2-1: Power Drawbar exploded view.

3. Remove the hex head screw from the Power Drawbar cylinder's rod with a 24 mm wrench.

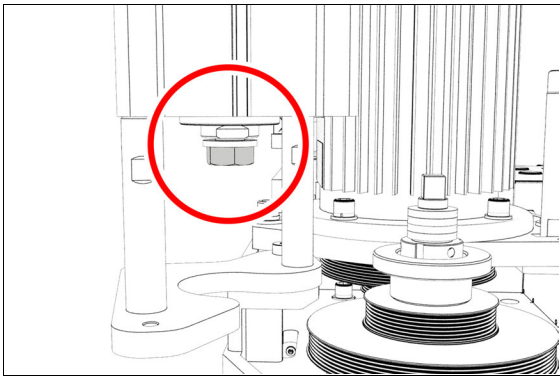


Figure 2-2: Hex head screw.



Note: You may need an impact driver to loosen the hex head screw.

4. Remove and discard the M16 washer.

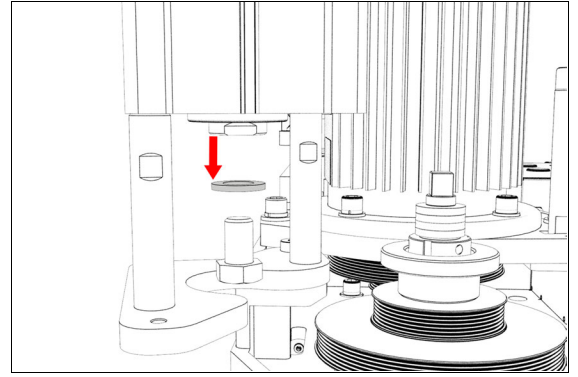


Figure 2-3: M16 washer.

5. Install the hex head screw and jam nut onto the Power Drawbar cylinder's rod with a 24 mm wrench.
6. Install the three provided 152 mm power drawbar standoffs with a 17 mm open-ended wrench.
7. Find the mounting plate and its hardware that you set aside in Step 1. Then, install the mounting plate onto the Power Drawbar cylinder assembly.
8. Install the Power Drawbar cylinder assembly onto the mill's spindle head with the provided shoulder screw, compression spring, and the quick-release pin that you removed from the original Power Drawbar.
9. Connect the air lines to the Power Drawbar cylinder.
10. Adjust the hex head screw with a 24 mm hex wrench so that it projects 0.020 in. to 0.040 in. (0.5 mm to 1 mm) beyond the edge of the Power Drawbar cylinder's rod. Then, secure the jam nut with a 20 mm hex wrench.