



Technical Document

Enabling Your Ideas

LED Spindle Light Kit for PCNC Mills

Product Identification: LED Spindle Light Kit for PCNC mills (PN 34846)

Purpose: This document details installation of the LED Spindle Light Kit on any PCNC mill. There are two sections to this document: *PCNC 1100 / PCNC 770 Kit Installation*, and *PCNC 440 Kit Installation*.

Qty. LED Spindle Light Kit

1	Low Profile LED Spindle Light
1	12V DC Power Supply with 4' Cord (100-240 VAC 50/60 Hz)
2	3' Power Extension Cord
8	Cable Tie
8	Cable Tie Mounting Pad
1	Alcohol Wipe (packet)
1	Epoxy (packet)
3	Magnet



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

NOTE: The LED spindle light is not compatible with the BT30 spindle (PN 30505).

PCNC 1100 / PCNC 770 Kit Installation

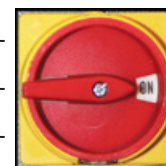
1. Move spindle head to lowest position and power off mill according to *Power Off/On Procedure* (below).



WARNING! Electrical Shock Hazard: Be sure to power off machine before making any electrical modifications. Failure to do so may result in serious injury or death.

Power Off/On Procedure

Power Off	1. Push red E-stop button in
	2. Click <i>Exit</i> on screen; when prompted click <i>OK</i> to power off
	3. Turn Main Disconnect <i>Off</i> (see image at right)
Power On	1. Turn Main Disconnect <i>On</i> (see image at right)
	2. After software loads, turn red E-stop clockwise to release
	3. Press green <i>Start</i> button
	4. Click <i>Reset</i> on screen



2. Clean spindle nose with Alcohol Wipe.
3. Epoxy Magnets to back of spindle light per instructions on Epoxy packet (see **Figure 1**). Spindle light can also be epoxied to spindle.

NOTE: The electrical connector on light contains corrosion resistant grease (see **Figure 1**). Do not remove grease and do not allow grease to come in contact with cleaned surfaces.

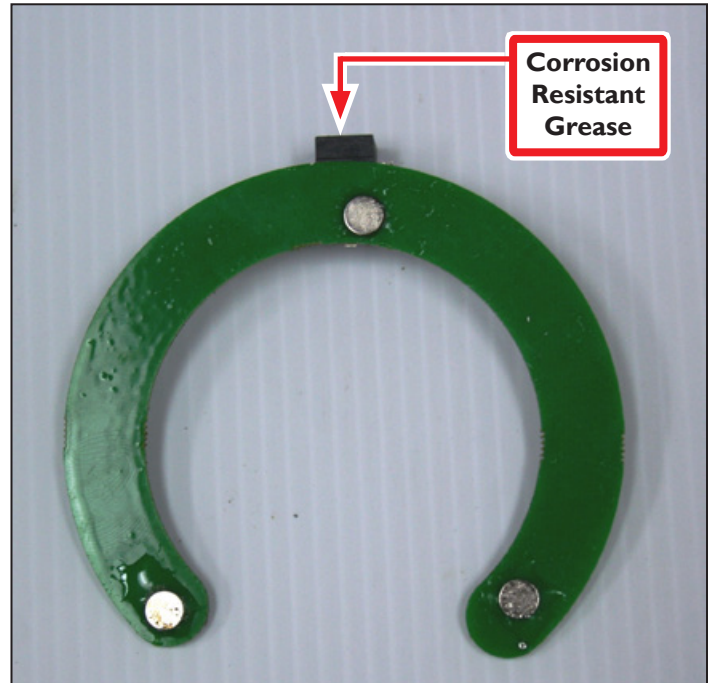


Figure 1

4. Attach spindle light to spindle (see **Figure 2**).
5. Connect together two Power Extension Cords and plug into light (see **Figure 2**).

NOTE: Opening on spindle light must face the Automatic Tool Changer (ATC), if installed.

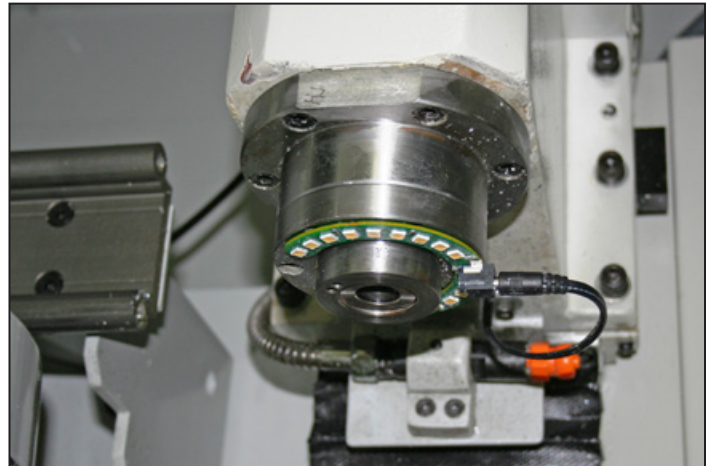


Figure 2

6. Weave opposite end of Power Extension Cord through spindle head, over and down back of mill (see **Figure 3**).

NOTE: The Power Extension Cord enters spindle head below motor pulley. Be sure to route cord with enough clearance from pulley.

7. Connect 12 V DC Power Supply with 4' Cord to extension cord.
8. Use Cable Ties and Mounting Pads as necessary to secure cord; plug into a power strip (not included).
9. Power on mill according to *Power Off/On Procedure* detailed earlier in this document.
10. After installation is complete, slowly run spindle head up and down to ensure cord cannot get caught in any part of mill.

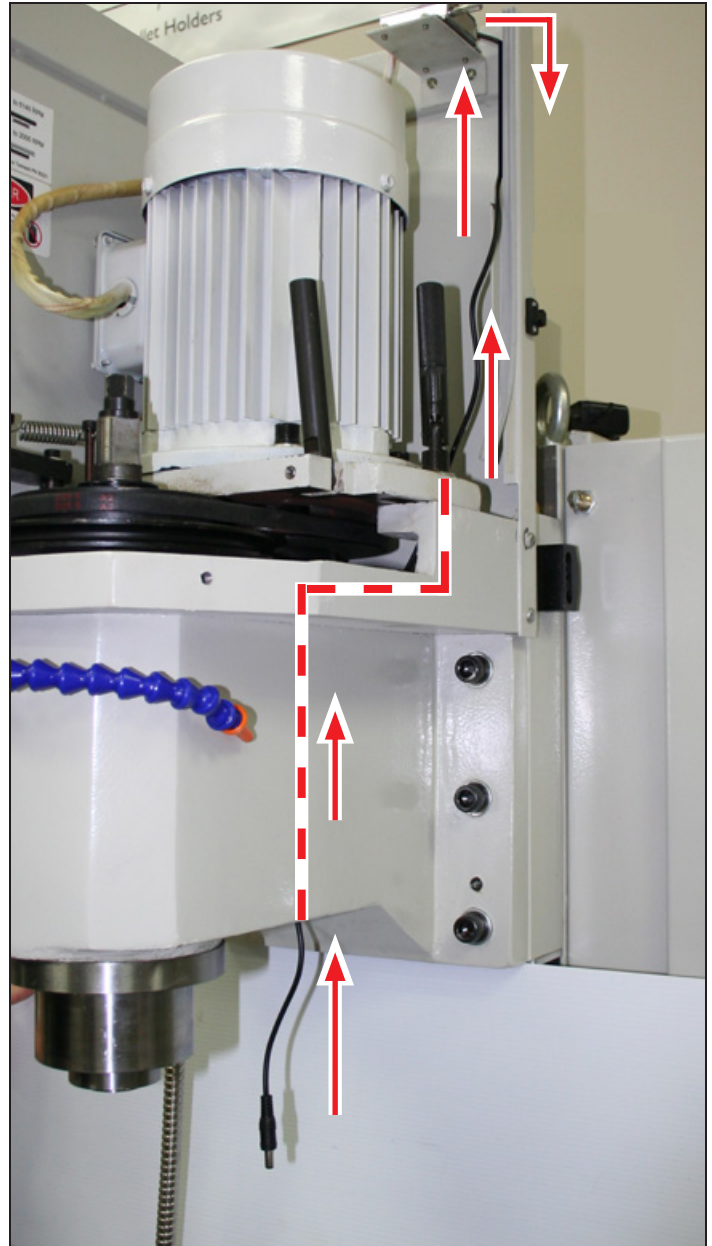


Figure 3

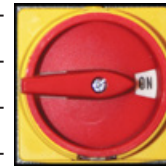
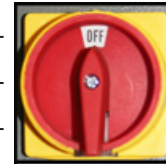
PCNC 440 Kit Installation

1. Move spindle head to lowest position and power off mill according to Power Off/On Procedure (below).

⚠ WARNING! Electrical Shock Hazard: Be sure to power off machine before making any electrical modifications. Failure to do so may result in serious injury or death.

Power Off/On Procedure

Power Off	1. Push red <i>E-stop</i> button in
	2. Click <i>Exit</i> on screen; when prompted click <i>OK</i> to power off
	3. Turn PathPilot Controller power strip off
	4. Turn Main Disconnect <i>Off</i> (see image at right)
Power On	1. Turn PathPilot Controller power strip on
	2. After software loads, turn Main Disconnect <i>On</i> (see image at right)
	3. Turn red <i>E-stop</i> button clockwise to release
	4. Press green <i>Start</i> button
	5. Click <i>Reset</i> on screen



2. Epoxy Magnets to back of spindle light per instructions on Epoxy packet (see **Figure 4**). Spindle light can also be epoxied to spindle.

NOTE: Electrical connector on light contains corrosion resistant grease (see **Figure 4**). Do not remove grease and do not allow grease to come in contact with cleaned surfaces.

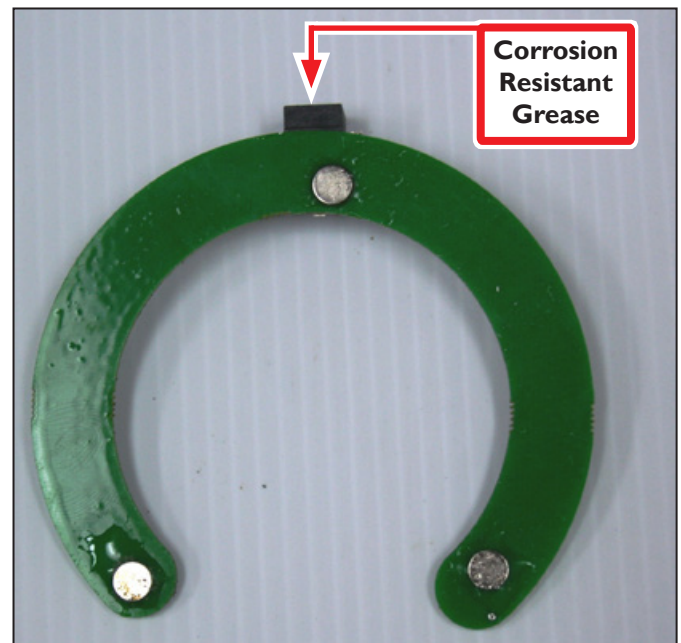


Figure 4

3. Clean spindle nose with Alcohol Wipe and attach spindle light (see **Figure 5**).
4. Connect three electrical cords together and plug into spindle light (see **Figure 5**).
5. Plug opposite end into a power strip (not included).
6. Use Cable Ties and Mounting Pads as necessary to secure cord in locations shown in **Figure 5**; plug into a power strip (not included).

NOTE: Opening on spindle light must face Automatic Tool Changer (ATC), if installed.

7. Power on mill according to *Power Off/On Procedure* detailed earlier in this document.
8. After installation is complete, slowly run spindle head up and down to ensure cord cannot get caught in any part of mill.

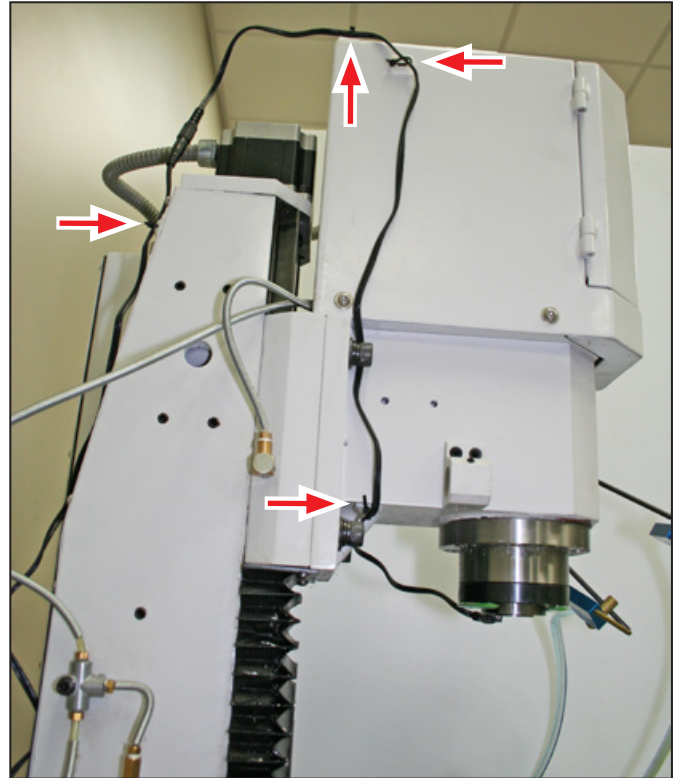


Figure 5