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Technical Document

Series I Axis Driver Replacement

Product Identification: Axis Driver Replacement Kit for PCNC 1100 (PN 35357)

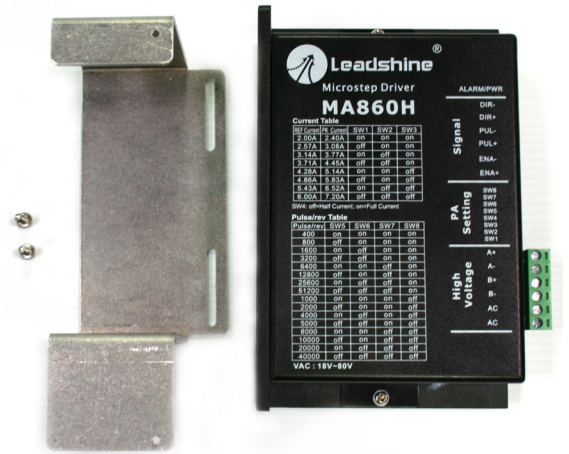
Purpose: The purpose of this document is to detail the installation of a replacement axis driver on a Series 1 PCNC 1100 mill (see important note below).

Axis Driver

Replacement Kit (PN 35357)	Qty.	PN
Axis Driver	1	32793
Bracket	1	32273
Screws	2	30521

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

IMPORTANT! This installation procedure applies only to PCNC 1100 mills with serial numbers between 001-999 and that are equipped with original Series 1 Axis Drivers as shown in **Figure 2**. If you upgraded your mill to poly-phase (series 3) axis drivers, do not use the Axis Driver included in this kit.





Driver Installation

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

2. Identify and remove the *Series 1 Axis Driver* that needs replacement from the electrical cabinet (see **Figure 1**).

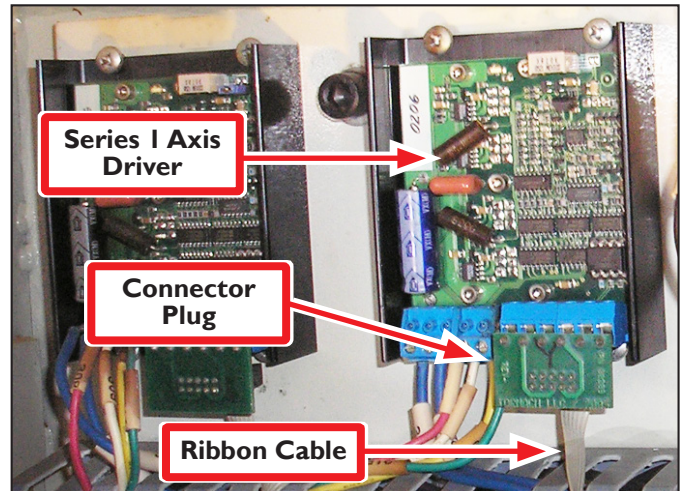


Figure 1

3. Remove the *Connector Plug* from the drive and the *Ribbon Cable* from the connector; discard the *Connector Plug* (see **Figure 1** and **Figure 2**).

NOTE: Some very early series mills may be missing the *Connector Plug* on the *Ribbon Cable*, or the *Ribbon Cable* may be too short to reach the new *Axis Driver*. In this situation, replace the *Ribbon Cable* (J6 Cable, PN 30686).

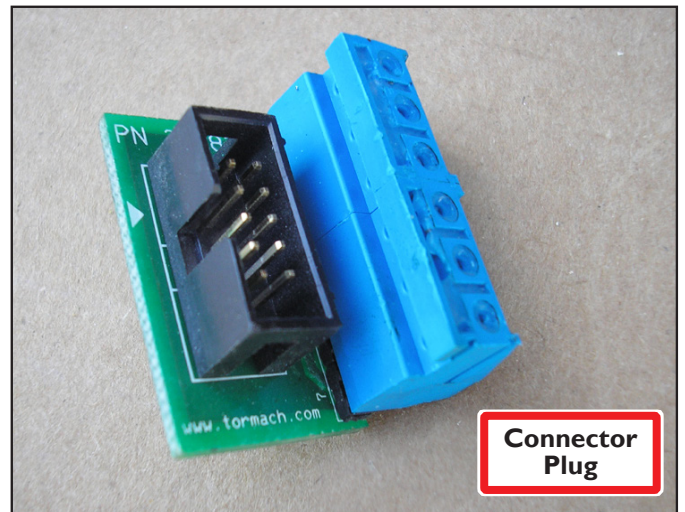


Figure 2

4. Use the two provided Screws to attach the *Axis Driver* to the *Bracket* (see **Figure 3**).

NOTE: To properly align the *Bracket*, the *Axis Driver* is mounted in the electrical cabinet with all text upside down.

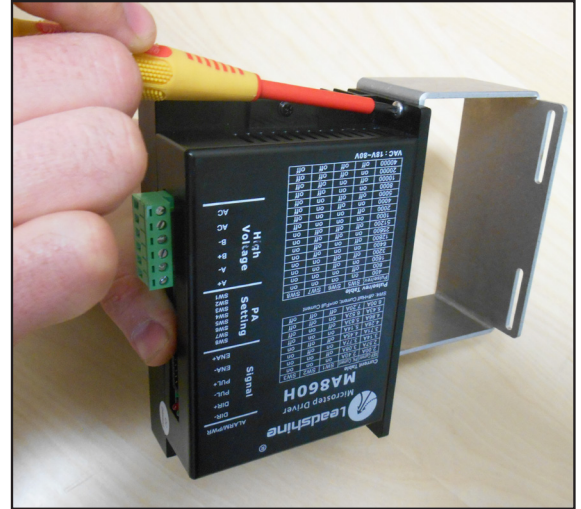


Figure 3

5. Install the replacement *Axis Driver* and attached *Bracket* in the electrical cabinet (see **Figure 4**).
6. For additional instructions on making the driver connections and proper microswitch settings, refer to Tormach document *Driver Replacement Installation Instructions* that is included with the *Axis Driver* in this kit: TD10173.

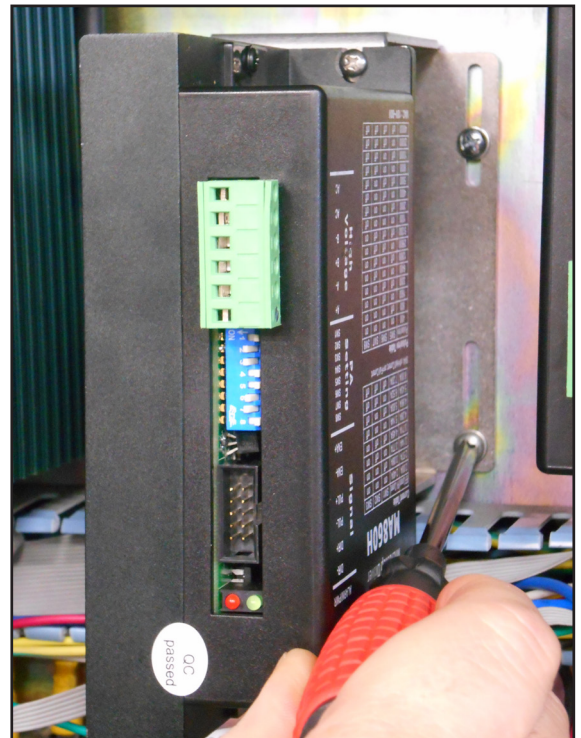


Figure 4