



Enabling Your Ideas

# Technical Document

## PCNC 770 Flood Coolant Kit Installation

**Product Identification:** There are two possible PCNC 770 flood coolant configurations:

- PCNC 770 Flood Coolant Kit with Backsplash and Table Guard (PN 31192)<sup>1</sup>
- PCNC 770 Flood Coolant Kit (PN 31367)

**Purpose:** This document details installation of the two different kit options.

Qty	PCNC 770 Flood Coolant Kit w/ Backsplash, Table Guard (PN 31192)	PN
1	Coolant Chute	—
1	Coolant Tank	—
1	Chip Tray	—
1	Coolant Hose Adapter	32832
1	Plastic Bracket	—
1	M5 x 8 mm Screw	—
2	M5 x 20 mm Screw	—
4	M6 x 10 mm Screw	—
1	M6 x 12 mm Fixing Screw	—
1	Chrome Armored Hose	30725
1	1/4" Coolant Hose	32833
1	Coolant Hose Mount Bracket	31105
1	Left Backsplash Guard	—
1	Right Backsplash Guard	—
12	M6 x 10 mm Screw	—
2	M6 Nut	—

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

**NOTE:** Backsplash and Table Guard kits are packed in separate boxes. Table guard installation instructions are packed with table guard.

**IMPORTANT!** Complete PCNC 770 Machine Stand (PN 31191) assembly prior to start of installation.

<sup>1</sup> **NOTE:** Flood Coolant Kit with Backsplash and Table Guard (PN 31192) arrives in three crates. Wait until all crates are received before beginning installation.

Qty	PCNC 770 Flood Coolant Kit (PN 31367)	PN
1	Coolant Chute	—
1	Coolant Tank	—
1	Chip Tray	—
1	Coolant Hose Adapter	32832
1	Plastic Bracket	—
1	M5 x 8 mm Screw	—
2	M5 x 20 mm Screw	—
4	M6 x 10 mm Screw	—
1	M6 x 12 mm Fixing Screw	—
1	Chrome Armored Hose	30725
1	1/4" Coolant Hose	32833
1	Coolant Hose Mount Bracket	31105

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

### Required Tools:

- Phillips screwdriver
- Flat-blade screwdriver
- Wire cutter
- Adjustable wrench

## Backsplash Guard Install (Flood Coolant Kit PN 31192 only)

1. Position backsplash guards near Stand and test fit; Left Backsplash Guard and Right Backsplash Guard are different (see **Figure 1**).
2. Using five M6 x 10 mm Screws, attach Right Backsplash Guard to right chip pan.
3. Repeat step 2 for Left Backsplash Guard.
4. Using two M6 x 10 mm Screws and two M6 Nuts, connect two backsplash guards together at rear joint.

**NOTE:** Do not use butyl tape for the joint between the backsplash guards and chip pans.

**NOTE:** If any holes on the backsplash guards do not line up, loosen surrounding screws as needed. Once all screws are started, tighten to approximately 3 ft-lbs of torque.

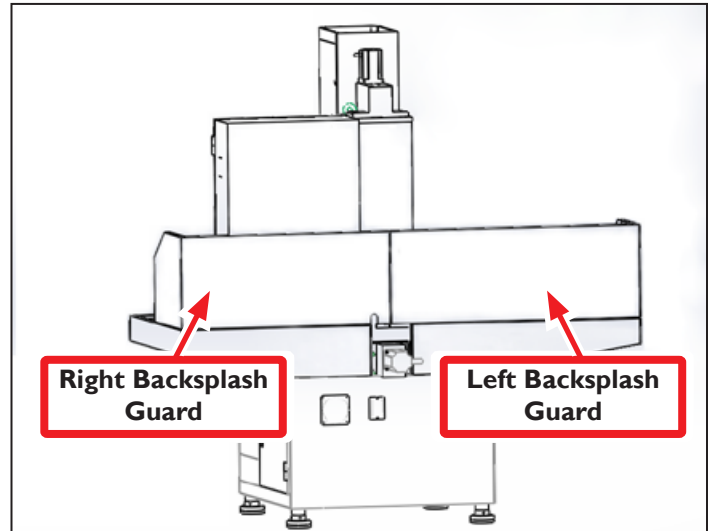


Figure 1

## Flood Coolant Kit Install

**NOTE:** Coolant Pump is 115 VAC.

1. Remove accessories from Coolant Tank's Chip Tray; set aside (see **Figure 2**).
2. Identify location for Coolant Tank behind Stand; using four M6 x 10 mm Screws, attach Coolant Chute to Stand beneath coolant trough exit hole (see **Figure 3**). Check alignment to avoid coolant spills.

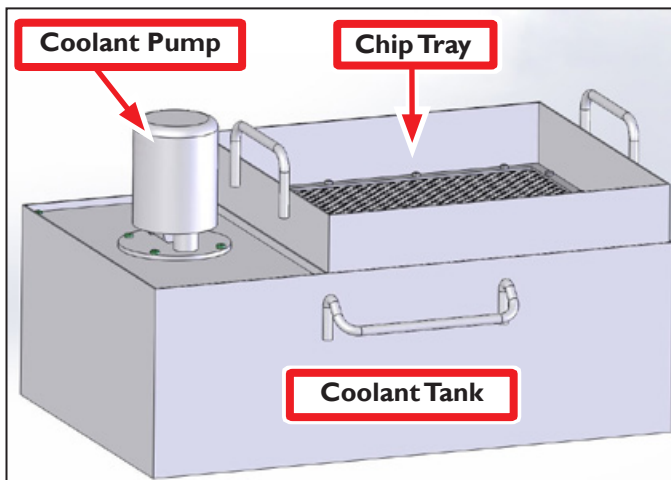


Figure 2

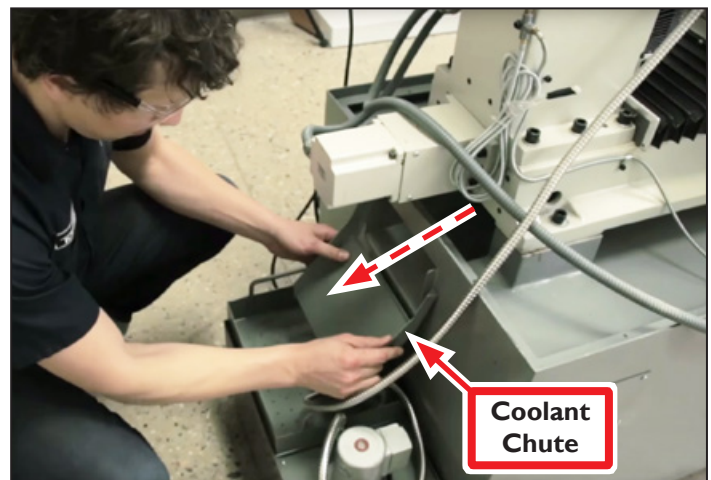
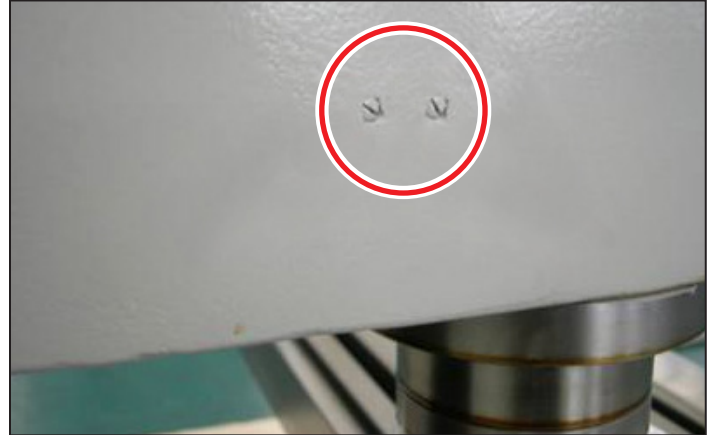


Figure 3

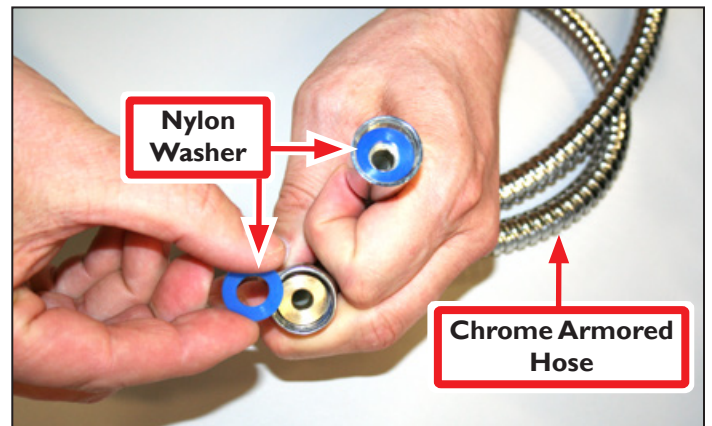
3. Locate, remove, and discard two screws on the side of the spindle head (see **Figure 4**).

**Spindle Head**



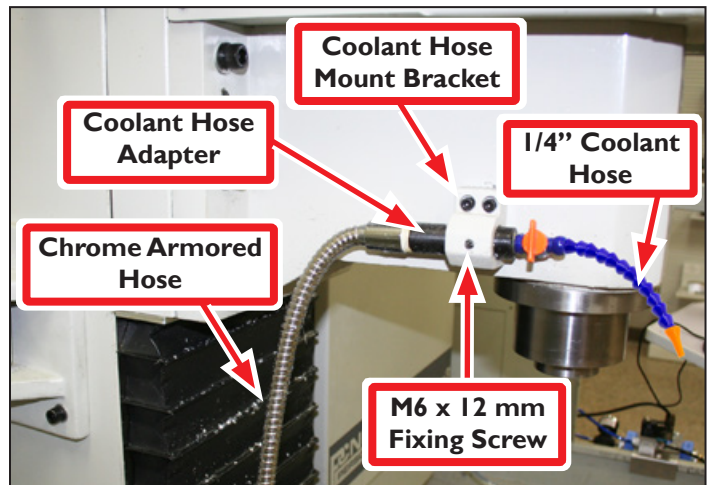
**Figure 4**

4. Insert Nylon Washer into both ends of Chrome Armored Hose (see **Figure 5**).



**Figure 5**

5. Using two M5 x 20 mm Screws, attach Coolant Hose Mount Bracket to spindle head (see **Figure 6**).
6. Using one M6 x 12 mm Fixing Screw, attach Coolant Hose Adapter to Coolant Hose Mount Bracket (see **Figure 6**).
7. Wrap Coolant Hose Adapter with thread seal tape (PTFE tape).
8. Connect Chrome Armored Hose to Coolant Hose Adapter (see **Figure 6**).
9. Connect 1/4" Coolant Hose to Coolant Hose Adapter (see **Figure 6**).



**Figure 6**

10. Wrap threads of Elbow Adapter on Coolant Pump (see **Figure 7**) with thread seal tape (PTFE tape).
11. Insert loose end of Chrome Armored Hose through hole in stand (see **Figure 8**); connect to Elbow Adaptor (PN 31382).

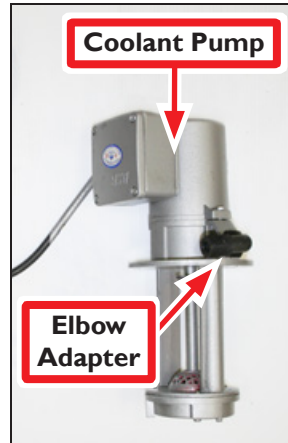


Figure 7



Figure 8

12. Connect Coolant Pump's 3-prong plug into outlet shown in **Figure 9**.

**NOTE:** Power Connection Panel is located on bottom of electrical cabinet.

### Power Connection Panel

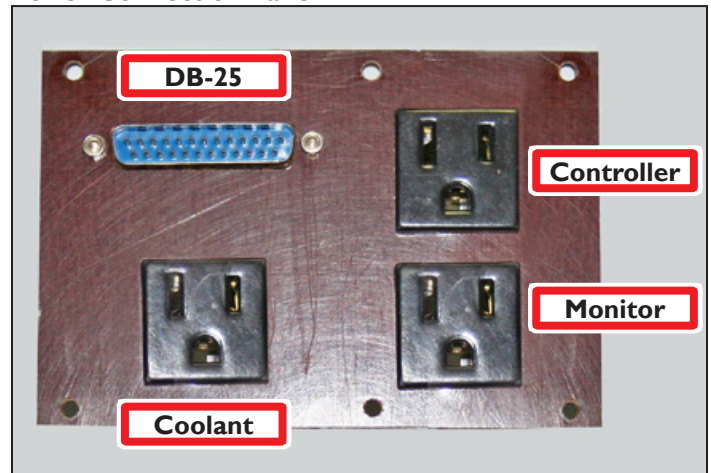


Figure 9