INSTALLATION GUIDE

COLLET CLOSER FOOT PEDAL KIT

TORMACH.COM

TECHNICAL DOCUMENT

1.1 PURPOSE

This document gives instructions on installing the Collet Closer Foot Pedal Kit on a 15L Slant-PRO.

1.2 PRODUCT INFORMATION

Product: Collet Closer Foot Pedal Kit (PN 39407)

Quantity	Description
1	Foot Pedal
1	Foot Pedal Control Box
2	M8 Fastener
1	USB Cable

> **Note:** If any of these 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. Make sure that you have them available before you begin.

- 6 mm hex wrench

1.4 BEFORE YOU BEGIN

- **Automatic Collet Closer Kit for 15L Slant-PRO (PN 38690) Required** You must first install the Automatic Collet Closer Kit. For information, see the product's documentation.
- **PathPilot v2.2.2 or Later Required** PathPilot v2.2.2 and later has settings required to use the Collet Closer Foot Pedal Kit. If you haven't yet done so, download and install the latest version of PathPilot.

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2.1 INSTALL THE COLLET CLOSER FOOT PEDAL KIT

1. Power off the machine and the PathPilot controller.

    a. Push in the Emergency Stop button on the operator panel, which disables movement of the axes and the spindle.

    b. From the PathPilot interface, select **Exit**.

    c. Turn the Main Disconnect switch to **OFF** on the side of the electrical cabinet.

2. Find the two M8 fasteners and the foot pedal control box provided with this kit.

3. Open the controller cabinet door.

4. Inside the controller cabinet, on the back wall, identify the four holes (originally used to raise the machine off of its shipping pallet). To mount the foot pedal control box, you'll use the top two holes.
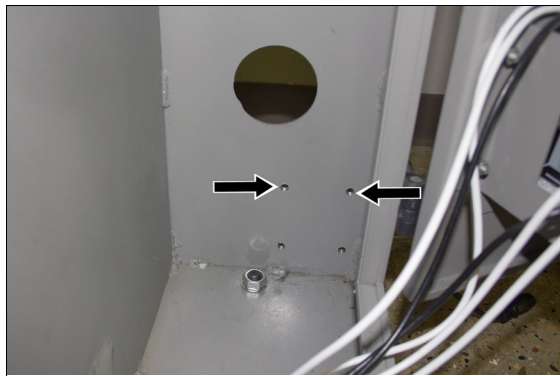

Figure 2-1: Mounting hole location on the back wall of the controller cabinet.

5. Mount the foot pedal control box to the controller cabinet with two M8 fasteners and a 6 mm hex wrench. Verify that the foot pedal control box is oriented as shown in the following image. The USB port must point toward the bottom of the controller cabinet.
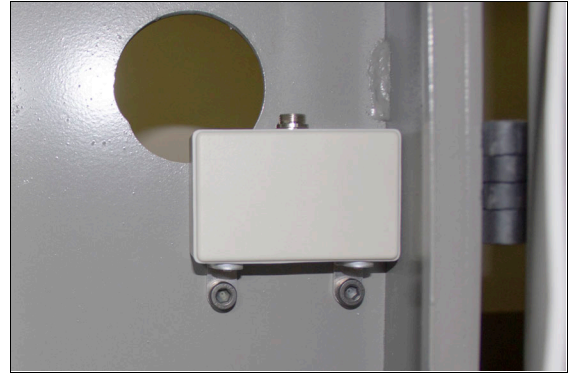

Figure 2-2: Foot pedal control box mounted to the controller cabinet.

6. Put the foot pedal in the desired location (near the front of the electrical cabinet).

7. Route the foot pedal cable around the back of the machine and toward the access hole in the controller cabinet.

> *NOTICE!* Don't route the foot pedal cable underneath the machine. If you do, it could interfere with the casters on the coolant tank, which may cause damage to the foot pedal cable.

8. Route the foot pedal cable through the access hole in the controller cabinet and toward the foot pedal control box that you mounted in Step 5.
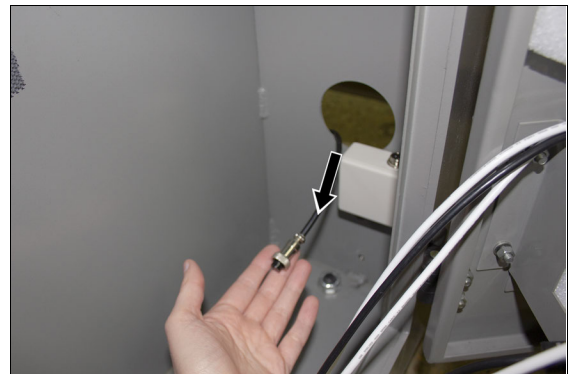

Figure 2-3: Moving the foot pedal cable through the access hole in the controller cabinet.

9. Connect the cable to the control box, and then secure it with the locking collar.

10. Find the USB cable provided with this kit. Then, connect one end to the USB port on the foot pedal control box.
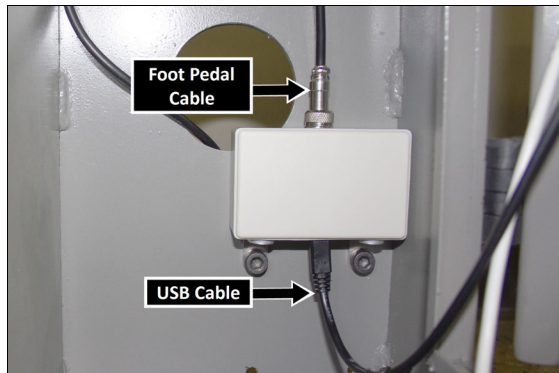

Figure 2-4: Cable connections on the foot pedal control box.

11. Connect the loose end of the USB cable to a USB port on the PathPilot controller.

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3.1 VERIFY THE INSTALLATION

1. Power on the machine and the PathPilot controller.

    a. Turn the Main Disconnect switch to **ON** on the side of the electrical cabinet.

    b. Twist out the Emergency Stop button on the operator panel, which enables movement to the machine axes and the spindle.

    c. Press the Start button on the operator panel.

    d. Bring the machine out of reset and reference it.

2. Press and release the foot pedal.
    The collet unclamps.

3. Press and release the foot pedal.
    The collet clamps.

4. Depending on the outcome of Steps 2 through 3, do one of the following:

    - **Collet Unclamps and Clamps** You've completed the installation of the Collet Closer Foot Pedal Kit.

    - **Collet Doesn't Unclamp or Clamp** Examine the connections on the foot pedal control box and the PathPilot controller. Then, repeat Steps 2 through 4.

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4.1 OPERATION

➤ Press and release the foot pedal to toggle between clamping and unclamping the collet.

4.1.1 Operation Requirements

To use the Collet Closer Foot Pedal Kit, you must verify that:

- The Automatic Collet Closer Kit for 15L Slant-PRO is installed and functional.
- The machine is powered on and out of reset mode.
- The spindle is stopped.
- Before unclamping the collet while a G-code program is running, the program is in an M00 or M01 break.