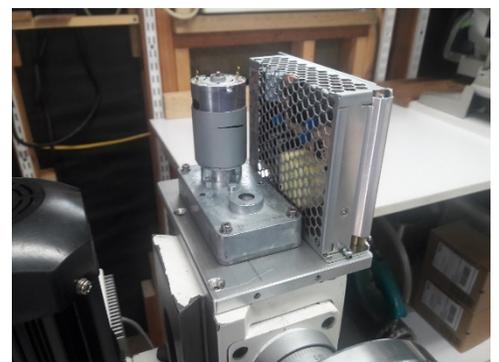
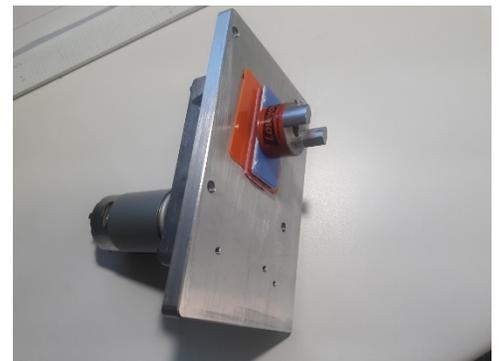
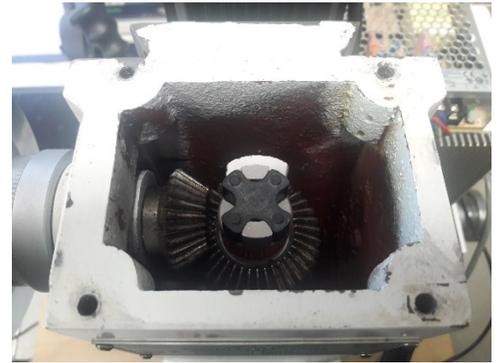


Power Lift PM-25MV Installation Instructions

6. Slide the 12mm hub down onto the threaded shaft at the top of the Z lead screw. Press down to make sure the hub is seated onto the washers below and tighten the set screw. Turning the Z hand wheel slightly back and forth will help to get the best angle to insert the 3mm hex L-key into the set screw socket. Tighten the set screw firmly.
7. Install the black rubber hub spider onto the 12mm hub.
8. Install the motor onto the plate as shown with the shaft extending down through the plate using the supplied 6-32x1" socket cap screws and washers.
9. Install the 5/16" hub with prongs down using the supplied spacers as shown. This will space the top flat surface of the hub 7/32 from the bottom surface of the plate. Tighten the set screw of hub firmly onto the flat of the motor shaft. Remove the spacers.
10. This next part is a bit tedious and is done "blind". Hold the motor/plate/hub assembly over the top of the mill column and visually align the prongs on the 5/16" hub with how they will mesh with their mating spaces on the rubber spider. Turn the Z hand wheel to align the hub prongs with the rubber spider. Lower the assembly down onto the top of the column feeling for the hub prongs to mesh with the spider. Once aligned, the plate should sit flush on top of the mill column.
11. Secure the plate to the top of the mill column using the 4, 5mm socket cap screws removed earlier. Note that back-driving the motor with the Z hand wheel will be stiff. Rotate the Z hand wheel back and forth to make sure the hub assembly is installed correctly.
12. Mount the power supply onto the plate as shown using the 2 supplied M3-.5x6mm pan machine screws.
13. Remove 2 screws on front left side of the control box.
14. Mount the supplied switch mounting plate to the front left side of the control box using 2 of the supplied M4-.7x14mm flat machine screws as shown.
15. Remove the switch enclosure cover.
16. Remove the screws and flange from the metal cable clamp.
17. Install cable clamp onto rear hole of switch enclosure, tighten.
18. Thread switch wire leads through rear hole and cable clamp of switch enclosure.
19. Re-install cable clamp screws and flange removed earlier and secure cable.
20. Remove the round knurled and hex nuts from the toggle switch. The hex nut takes a 14mm wrench.
21. Insert the toggle switch shaft through the front of the switch enclosure with the slot facing up.



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22. Slide the “UP DOWN” legend plate onto the toggle switch shaft aligning the slot in the shaft with the tab on the legend plate. “UP” should be up.
23. Secure the toggle switch shaft with the hex nut removed earlier.
24. Install the cover on the switch enclosure.
25. If a motor enclosure was not ordered, then attach the supplied wire clip to the power cord and switch wires, and secure to the edge of the motor plate using the supplied 6-32 pan machine screw and washer as shown in the picture below.
26. If a motor enclosure was purchased, complete the following steps, otherwise skip to the Wire Power Supply and Motor Section below.
27. Remove the screws and flange from the supplied metal cable clamp.
28. Install the cable clamp into the hole in the side of the enclosure with the nut on the inside and tighten.
29. Pull the power cord and switch wire leads through the cable clamp and enclosure and work the enclosure up onto the top of the motor plate. Secure the enclosure to the motor plate using the 4, 6-32 flat machine screws.
30. Re-install the cable clamp screws and flange removed earlier and secure the cables.



Wire Power Supply and Motor

1. **Make certain the power cord is disconnected from the wall outlet.**
2. When making the connections to the power supply, support the back of the power supply with one hand while tightening the connections.
3. Make sure the female flag connectors are positioned properly onto the male motor male terminals before seating these connections.
4. Make the switch and power cord connections to the power supply and motor according to the following list.

<u>Power Cord</u>	<u>Power Supply</u>
Brown	L (Line in)
Blue	N (Neutral)
Yellow/Green	Ground
<u>Switch Wires</u>	<u>Power Supply</u>
Green & White wires	12V -
Black & Red Wires	12V +
<u>Switch Wires</u>	<u>Motor</u>
Blue	Terminal without red dot
Brown / Orange	Terminal with red dot

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5. Install the supplied small plastic cover across the power supply terminals.
6. Enclose the power cord and switch wires with the supplied split corrugated tubing.
7. Test the Power Lift. Plug the power cord into the wall outlet. Operate the Power Lift using the motor control switch up and down. Congratulations, installation of the Power Lift is complete.

Trouble Shooting

- Motor turning unevenly. If the motor is not turning smoothly and evenly, disconnect and remove the motor from the mounting plate and check the alignment of the top of the coupling hub with the hole in the motor plate. Loosen the motor plate mounting screws and adjust accordingly, reassemble, and test.
- Motor stopping while traversing the Z-axis. Make sure the Z-axis locking screws are loose. Adjust (loosen) the Z-axis gib to allow free and controlled movement of the mill head along the Z-axis. Thoroughly clean the Z-axis ways and lead screw and lubricate with way oil.
- Motor control switch and motor direction not synchronized. Exchange the terminal connections on the motor.
- Motor turning but Z-axis not turning. Check the tightness of the set screws on both hubs.
- Note: The Z-axis hand wheel operation will be stiff due to the motor being back-driven while turning the hand wheel.

