



3707848 INFEEED CONTROL KIT - INFEEED MOTOR CONTROL INSTALLATION INSTRUCTIONS

This applies to all 632 Accu-Pro series Reel Grinders built between 2004-2013 that have a VOLTAGE REGULATOR ASSEMBLY installed.

This instruction is designed for technicians who have the necessary electrical knowledge and skills to reliably test and repair the ACCU-Pro electrical system. For those without that background, service can be arranged through your local distributor. READ ALL INSTRUCTIONS BEFORE STARTING.

The VOLTAGE REGULATOR ASSEMBLY (VRA) has been replaced with a INFEEED CONTROL BOARD (ICB). To replace the VRA with the ICB follow the steps below:

STEP 1.  **WARNING REMOVE POWER TO THE MACHINE BY UNPLUGGING THE UNIT. FAILURE TO REMOVE POWER COULD RESULT IN INJURY OR DEATH AND MAY RESULT IN DAMAGE TO THE MACHINE.**

STEP 2. Open the control panel and locate the VRA. Disconnect the four wires that come out of the VRA and go to the terminal strip and BRIDGE DIODE (BD-). Then remove the VRA from the sub panel (save the 2 screws).

STEP 3. Remove the yellow wire #131 and black wire #132 (connected from the grind motor relay (REL) to terminal blocks #17 and #19). Then, remove wire #133 which is connected to the BD- and terminal block #20. Dispose of these wires and the VRA in accordance with your local laws and regulations.

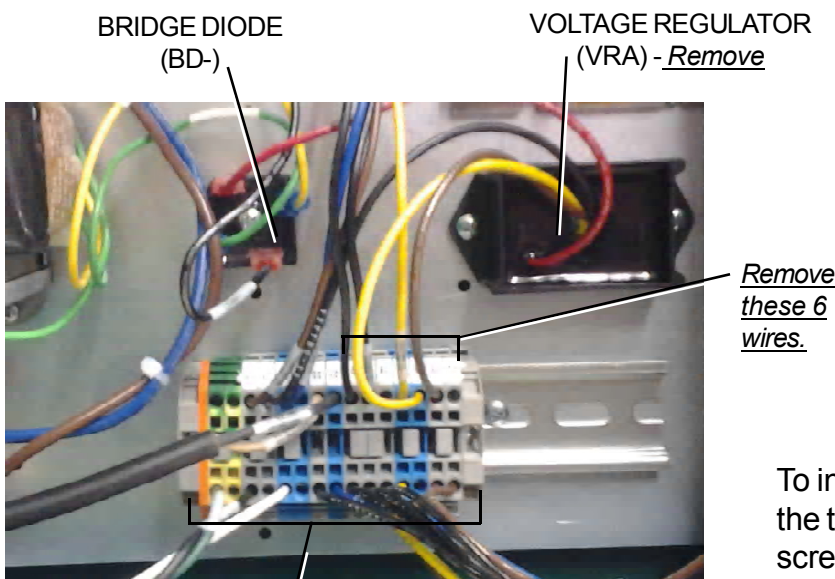
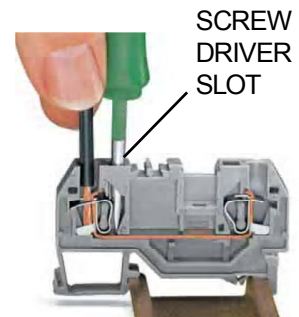


Fig 1.

TERMINAL BLOCKS
BLUE (TBB), GREY (TBG)



TERMINAL BLOCKS: Fig 2.

To insert or remove a wire from the terminal block, insert a small screw driver into the square hole. Then insert or remove the wire from the round hole. To lock the wire in place remove the screw driver.

STEP 4. Use a small screw driver to remove the jumper between terminal block grey #18 and #19.

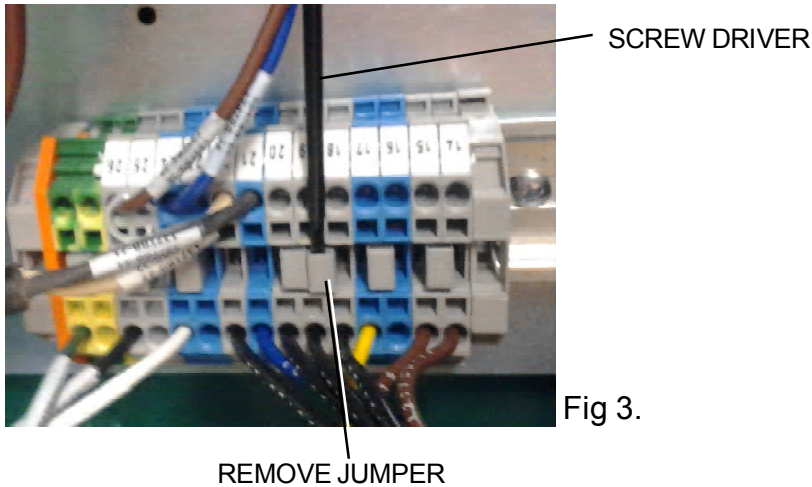


Fig 3.

STEP 5. Mount the new ICB with the wires facing down using the screws removed in step 2.

STEP 6. Connect the 6 wires from the ICB to the terminal block and the BRIDGE DIODE. The label on the end of the wire indicates the connection point of each wire. See figure 4 and figure 5.

IMPORTANT: the red wire must be connected to the + terminal of the BRIDGE DIODE. The + corner of the BRIDGE DIODE is slightly different from the other 3 corners.

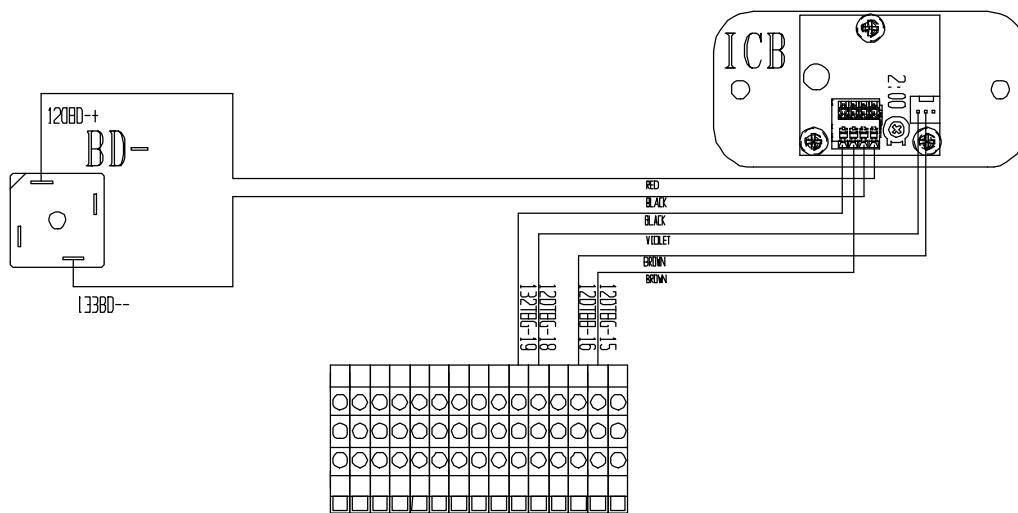


Fig 4.

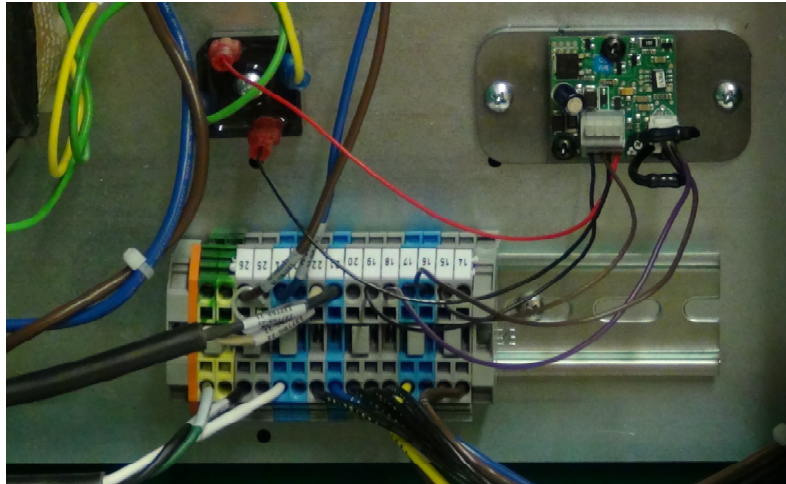


Fig 5.

STEP 7. Remove the INFEED JOG SELECTOR slow/fast switch and rotate it 180°. To remove the switch, press on the tabs on the ends of the switch (on the inside of the control panel) and push up and away from the top of the control panel. See figure 6.



Fig 6.

STEP 8. Close and secure the control box with the appropriate fasteners. Then carefully plug the machine into the designated outlet.

STEP 9. Verify that the INFEED JOG SELECTOR works in both slow and fast, and that the INFEED JOG SELECTOR works both up and down.



To view a video of this install.