

# 4609545 STEPPER CONTROL REPLACEMENT KIT INSTALLATION INSTRUCTIONS

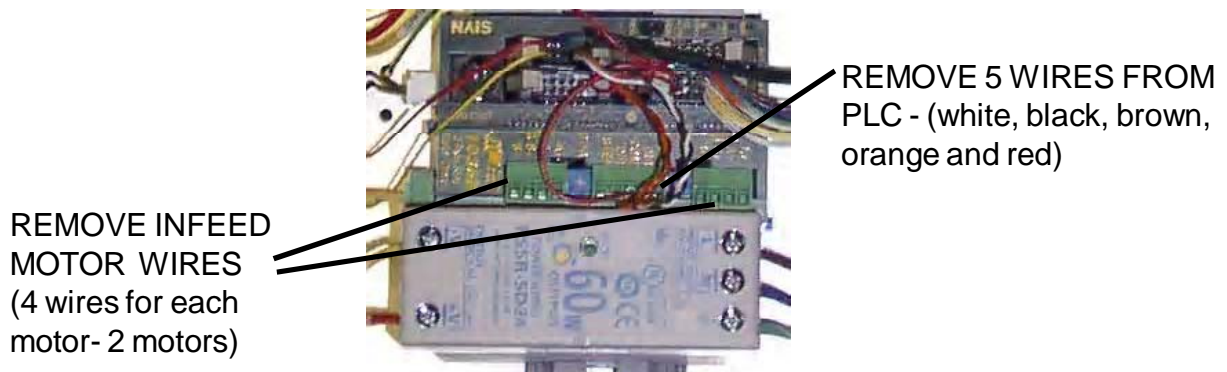
## REPLACEMENT OF STEPPER CONTROL IN THE AUTOMATED ROTARY BLADE GRINDER.

This stepper control assembly will replace the current stepper control. This kit is designed to be installed by somebody with knowledge of the machine and has necessary electrical knowledge and skill to reliably test and repair the electrical system. For those without this background, service should be arranged through your local distributor.

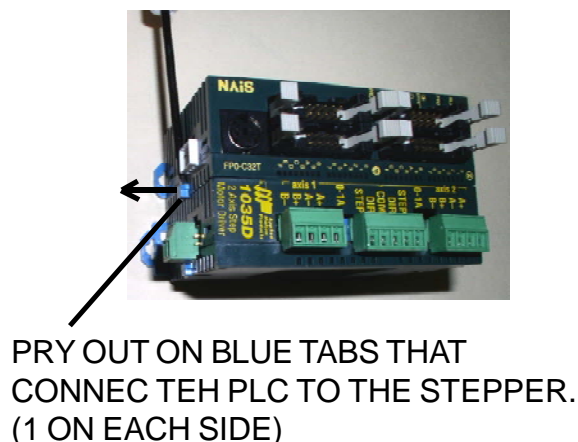
### INSTRUCTIONS:

**STEP1: REMOVE POWER TO THE MACHINE!** Unplug the machine. **!! FAILURE TO REMOVE POWER MAY RESULT IN INJURY, DEATH OR DAMAGE TO THE MACHINE!! READ ALL STEPS BEFORE STARTING TO FULLY UNDERSTAND WHAT IS REQUIRED.**

**STEP 2:** Open the Control box and disconnect wires at the stepper Drive. (Note, it may be easier to remove the green connector first, and then remove the wires from the connector. The green connectors should pull straight out from the Stepper Unit.)

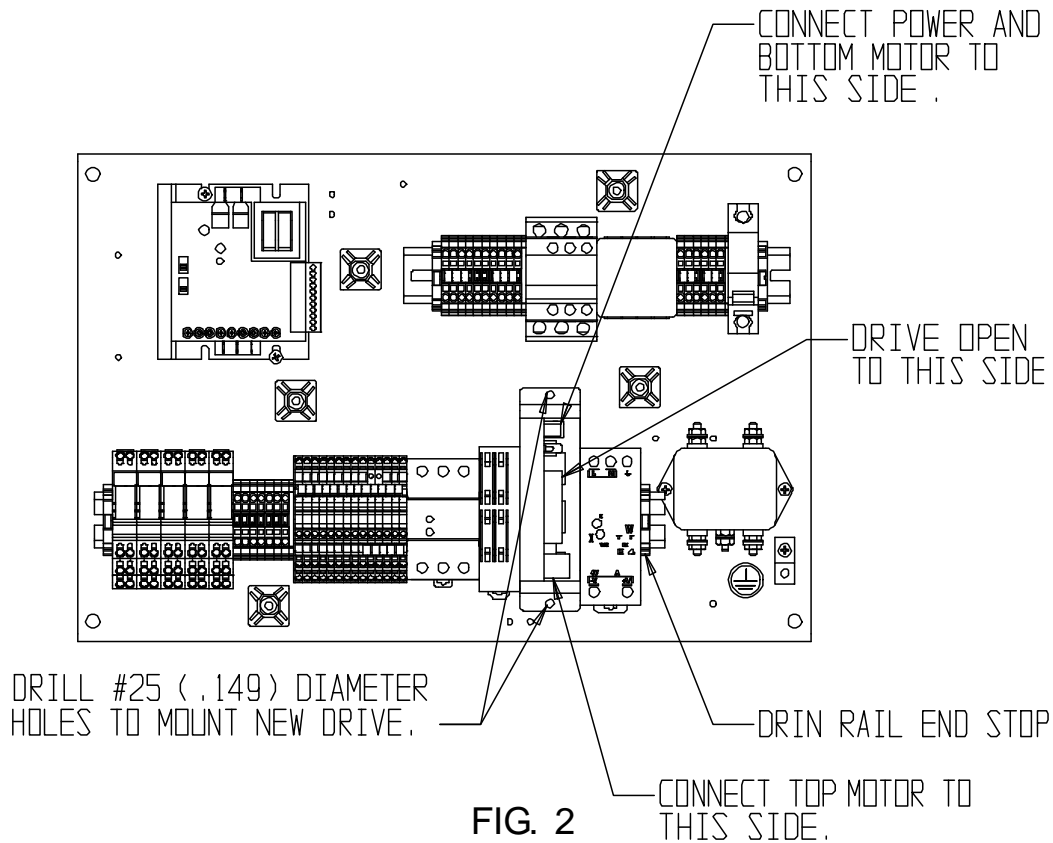


**STEP 3:** Remove the old Stepper Control. To Remove stepper controller, first pry out on bluetabs that connect the Stepper Controller to the PLC. You should now be able to separate the stepper from the PLC. To removed the Stepper Controller from the din rail use a screw driver to pull the large blue tab at the base out until it clicks. The Stepper controller should not be able to be removed from the din rail.



- CONTINUED FROM OTHER SIDE

STEP 4: Use the new Stepper Controller Mounting Bracket to mark the position for the 2 new mounting hole. **Cover the electrical parts to avoid any metal drill shavings fall into and short out any of the components.** Next pre-drill the new mounting hole with a #25 (.149 dia) drill bit. Note: you may need to remove the din rail stop on the bottom so the DC Power supply can be moved to make room for the bracket. The new controller is about 1/2" larger than the old one was. To remove the end stop use a flat head screw drive, and insert it in the side of the din rail stop, then pry the bottom of the stop away from the din rail.



STEP 5: Clean up any debris, then mount the new stepper control to the stepper basket using the 2 socket head screws and nuts. Next, connect the 2 motors, power wires and the control wires to the new Stepper Controller. Reference the Wiring diagrams on the following pages.

- Verify that all wires are in place and tight.

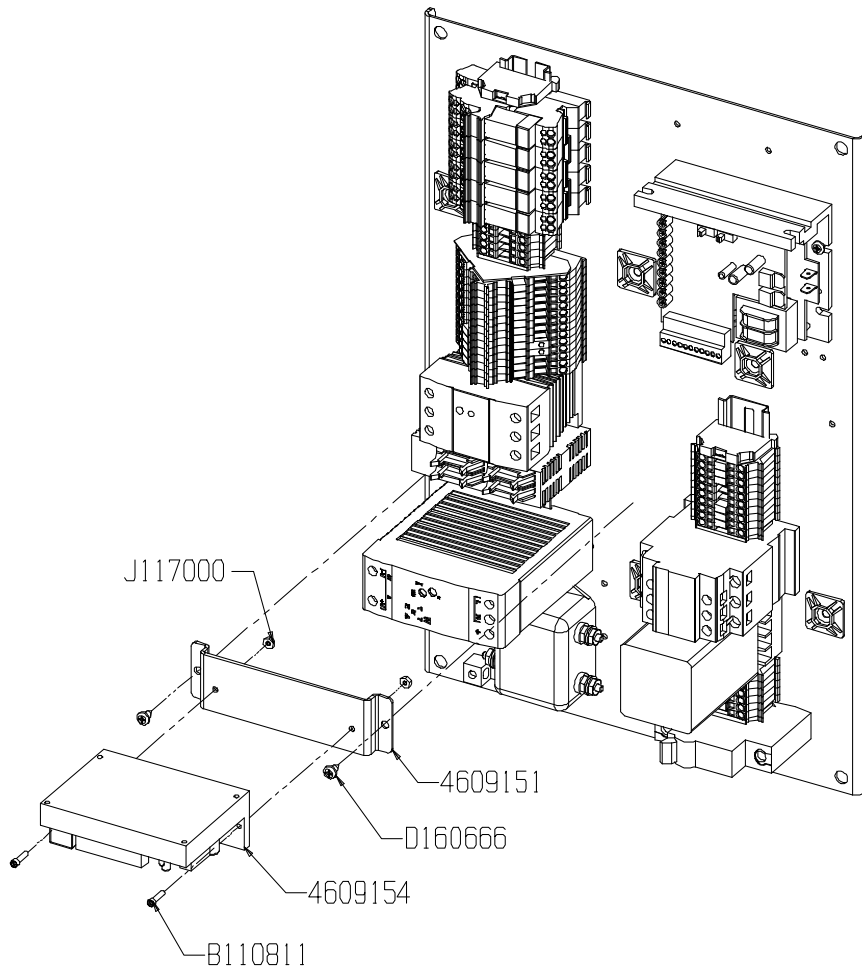
STEP 6: Use the 2 self tapping screws to mount the bracket to the control sub panel.

STEP7: - Close the control box and reconnect the power.

- Test the stepper drive.

\*\* Discard the old wires and Stepper Controller per your local code and regulations.

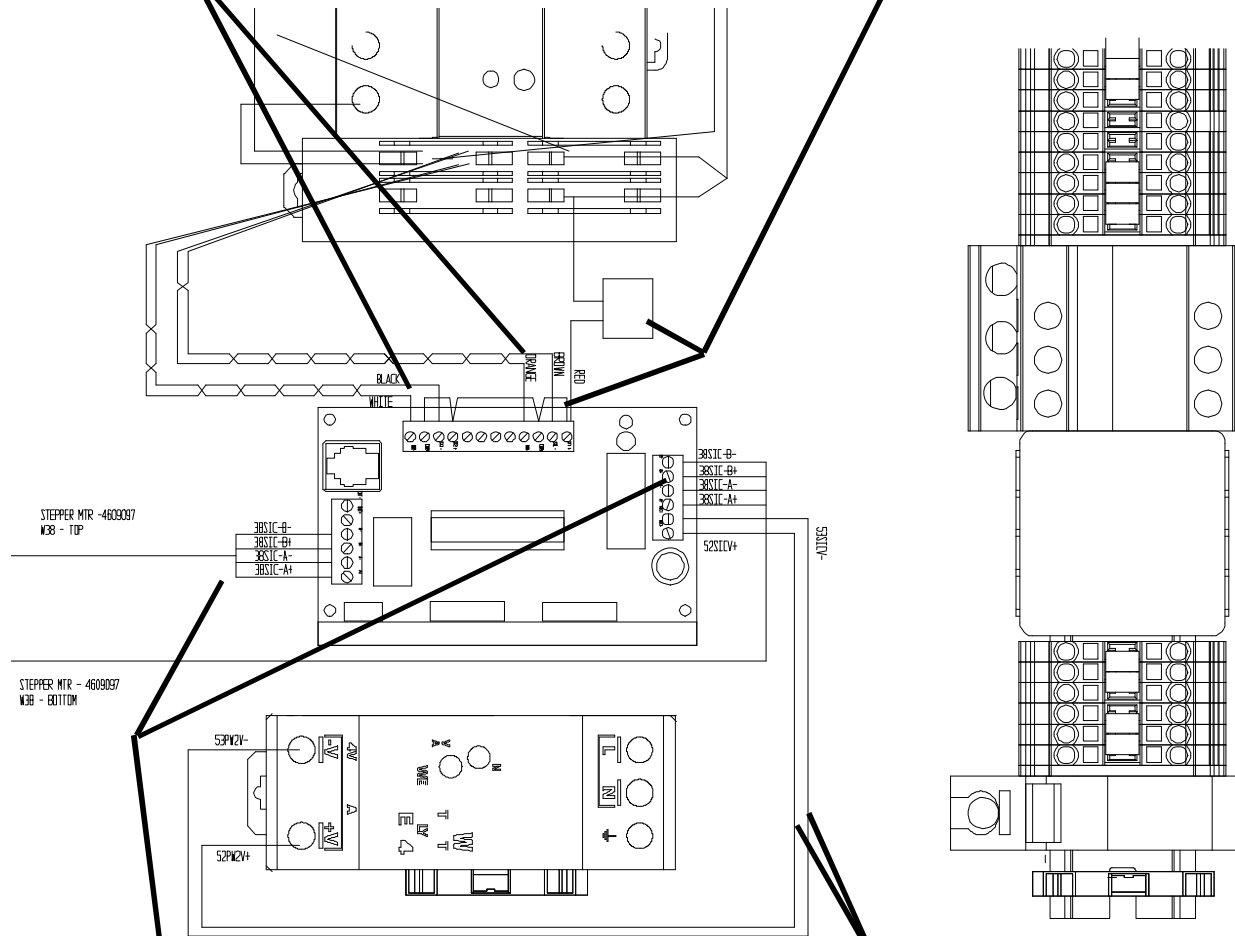
INSTALL PARTS AS SHOWN.



# NEW STEPPER WIRING

CONNECT STEPPER CONTROL WIRES

CONNECT RED JUMPER WIRE TO DRIVE AND CONNECT TO RED WIRE FROM PLC WITH CONNECTOR



CONNECT INFFED STEPPER MOTORS

INSTALL NEW WIRES FROM POWER SUPPLY TO STEPPER

# STEPPER CONNECTIONS

