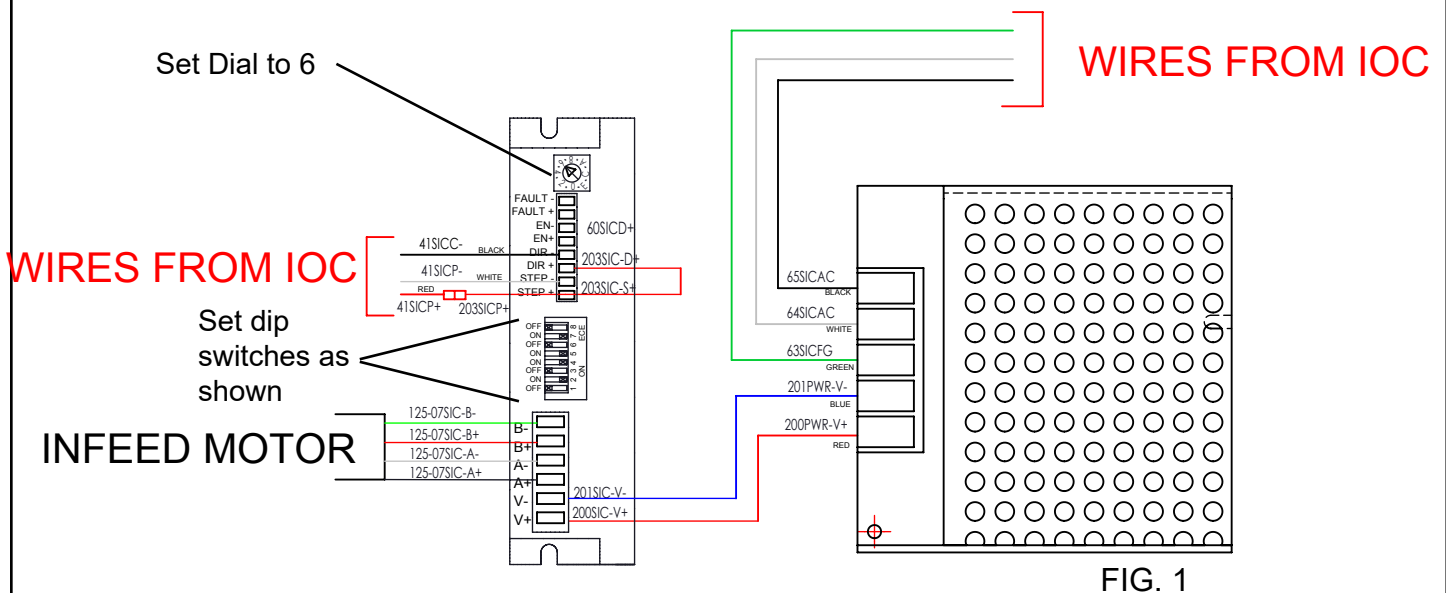


6500901 STEPPER CONTROL & MOTOR KIT - 6500502 INSTRUCTION SHEET

The supplier of the Stepper Control and Motor for the Model 6500901 has discontinued this product. Foley United offers this Stepper Control and Motor Kit Part number 6500502 as a replacement for the old system. Because of differences in design, we must replace the Stepper Control and the Stepper Motor. The instructions for replacement are:

1. Unplug grinder and open control panel.
2. Remove the old stepper control and the old stepper motor. **IMPORTANT!!** When removing the old stepper motor, cut the cord off from the motor at the motor, cut the cable ties that hold the cord to the inside of the frame, tape the new stepper motor cord to the old cord and pull the old cord out from inside the control box which will also pull the new cord into the control box for connection. Secure the new cord with cable ties supplied in the kit.
3. Install the new motor to the infeed actuator in reverse sequence of removal. See Assembly and Service Manual, adjustments section under "stepper motor clamp collar adjustment".
4. Use the template on page 2 of these instructions to drill two 11/64 (.172) dia. holes in the bottom of the box. Place the template on the inside of the control box, align the four .140 diameter holes of the template with the existing Stepper control mounting holes in the bottom of the box. Then use the template to drill two new .172 dia. holes. Deburr the holes on both sides of the box. Install the Stepper Control standing vertically with the terminals to the right side with the (2) # 8 screws and nuts provided in the kit.
5. Connect the wires to the Stepper Control according to the wiring diagram. See FIG. 1 below.
6. Verify the dip switches on the Stepper Control are correct. See FIG. 2 below.



MOUNT STEPPER CONTROL AS SHOWN.

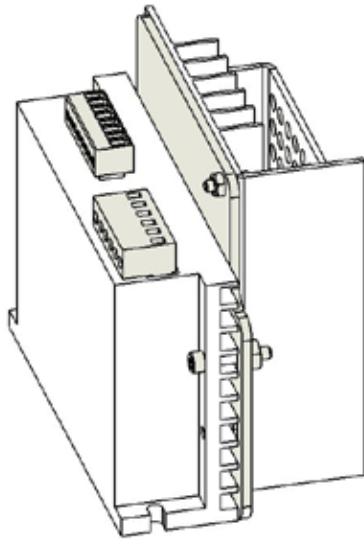


FIG. 2

ϕ .17 NEW HOLES
THAT NEED TO
BE DRILLED

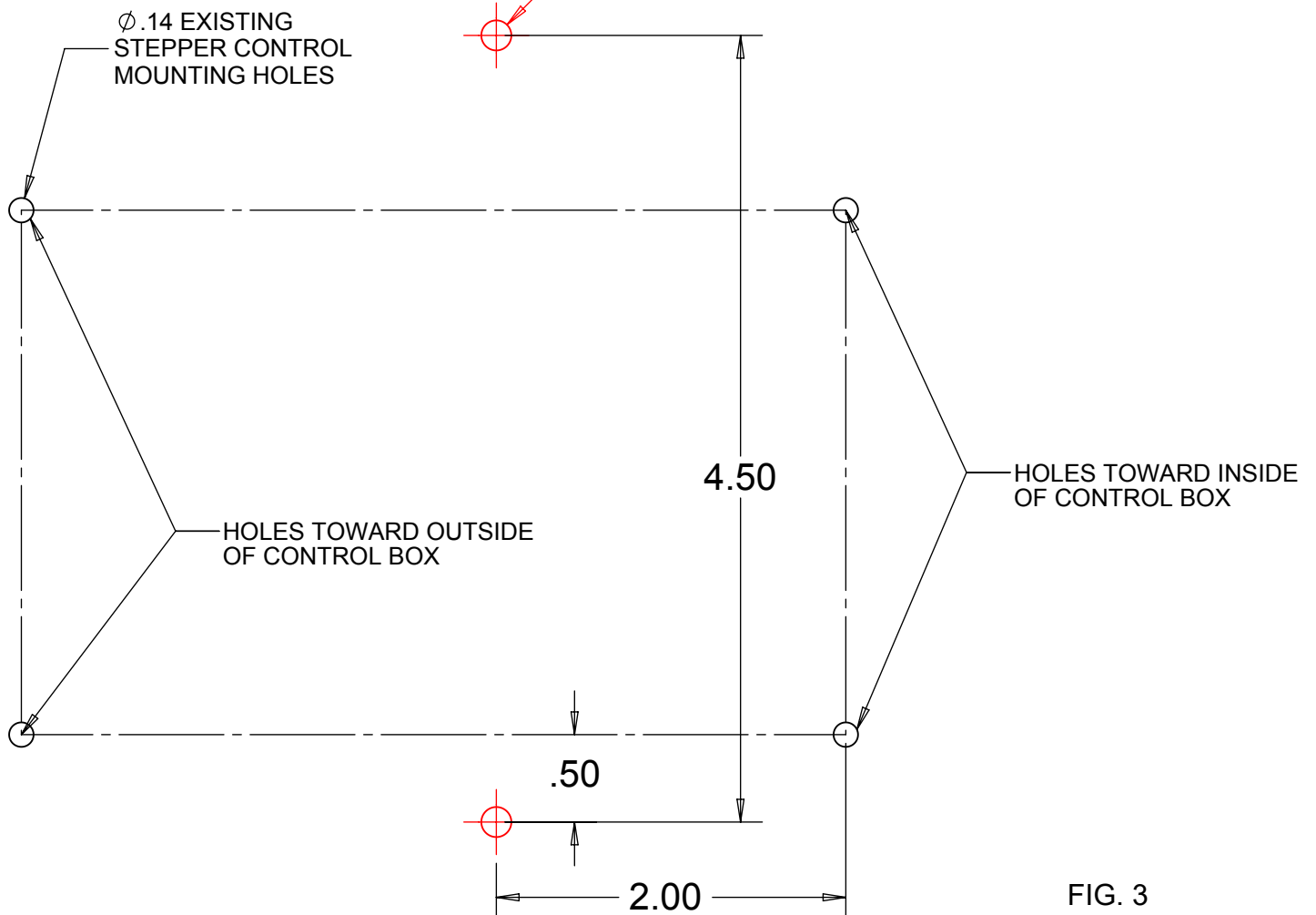


FIG. 3