

Installation Instructions for Chuck Motor Update Kit - PN 012-1045-09

Study the attached drawing and wiring diagram prior to installation of the Kit.

The new KW Chuck Motor, PN 012-1045-09, replaces the earlier version 001-1945-10. The older motors are no longer made. The new motors are larger and fit tightly into the available space.

Remove the Chuck Cover. Remove the chuck yoke spring **Item 1** and then the pivot bolt **Item 2**, and then remove the Chuck Yoke **Item 3**

Remove the set screw **Item 4** from the chuck shaft hand wheel **Item 5** and remove the hand wheel and gear belt **Item 6**. Now remove the chuck shaft. **Item 7**

Remove the old chuck motor, **Item 8** and discard the Allen head bolts **Item 9** which hold the motor to the bracket as (4) new, PN 000-0163-14, are provided. Remove the snap ring from the end of the motor shaft and remove the pulley **Item 10** and thrust washers **Item 11**. You will be reusing the pulley and thrust washers again, also make note of the direction of rotation of the pulley as removed, **IT MUST** go onto the new motor shaft with the same rotational direction as to have the one way clutch perform correctly.

Remove the limit switch **Item 12** from the bracket **Item 13** and discard the bracket. Retain the limit switch and hardware for reuse.

Install the limit switch **Item 12** to the new bracket PN 012-1044-21 **Item 13** and then install the switch with bracket to the chuck plate so that the switch is on a slight angle.

Install the pulley **Item 10** and one-way clutch (Internal in pulley) so as the direction of rotation is correct and the thrust washers are placed in the same location as they were when removed. Install the lock collar **Item 14** PN 000-1452-03 provided with the kit. Allow a slight amount and pulley side clearance to the thrust washers (.020 -.030), and then tighten the lock collar set screw.

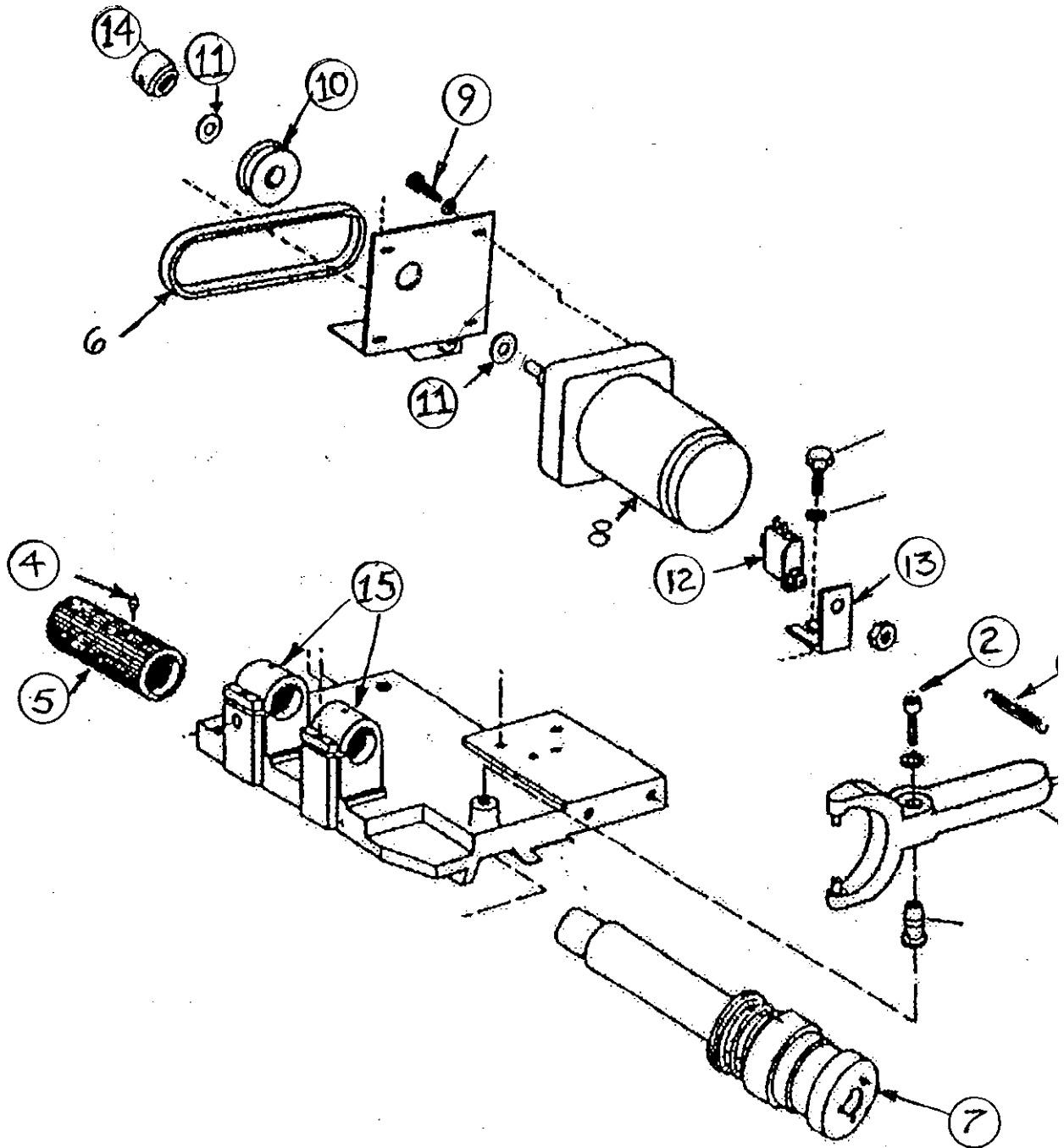
Attach the new motor to the bracket plate using the new hardware.

Install the chuck shaft **Item 7** into the bearing supports **Item 15** and then slide the hand wheel **Item 5** with gear belt **Item 6** onto the chuck shaft. Install the new hand wheel set screw PN 012-1044-21 w/brass tip **Item 4** and tighten. Make sure there is NO end movement (back and forth) of the chuck in the bearing supports. Endplay is removed by holding the hand wheel tight up against the side of the rear support. Not so tight as to bind, but tight enough to prevent any lateral movement.

Install the yoke **Item 3** and yoke pivot bolt **Item 2**, and tighten the bolt and attach return spring **Item 1**. Adjust air cylinder plunger if required

Attach wires as per diagram.

Note: If the chuck rotation is not correct after completing the wiring you will need to reverse the motor leads. This is a DC motor so reversing the leads will cause the motor to turn in the opposite direction.

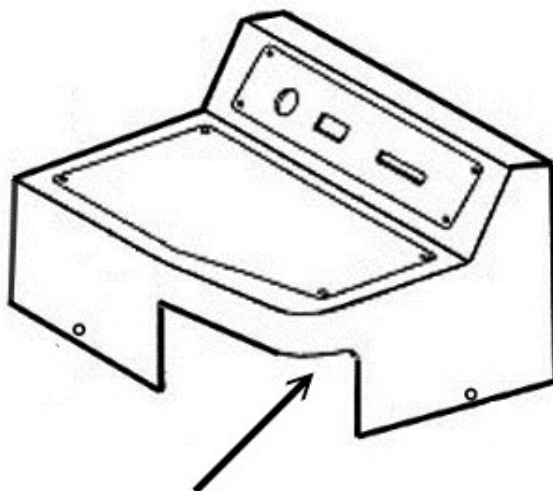
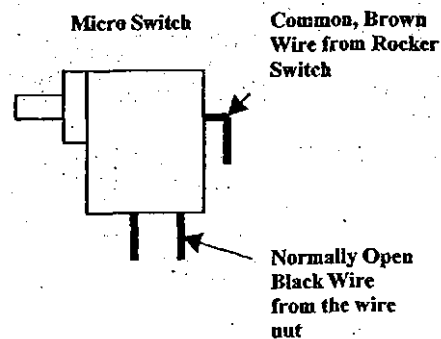
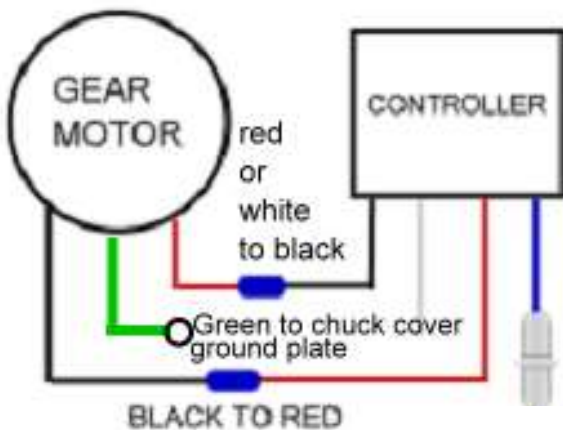


Packing List

SVSII Gear Motor Kit Part Number 012-1045-09

| Item | Part Number | Description | Qty |
|------|-------------|----------------------------|-----|
| 1) | 001-1945-09 | Gear Motor | 1 |
| 2) | 012-1044-21 | Bracket, Gear Motor Switch | 1 |
| 3) | 000-1452-03 | Collar | 1 |
| 4) | 000-0515-36 | Set Screw, Brass Tip | 1 |
| 5) | 000-0163-14 | Socket Head Cap Screws | 4 |
| 6) | 012-2060-09 | Instruction Sheet | 1 |

Wiring Instructions



Ground plate located on inside of cover along the back. Attach ground on the corner screw that hold the grounding plate to the chuck cover.