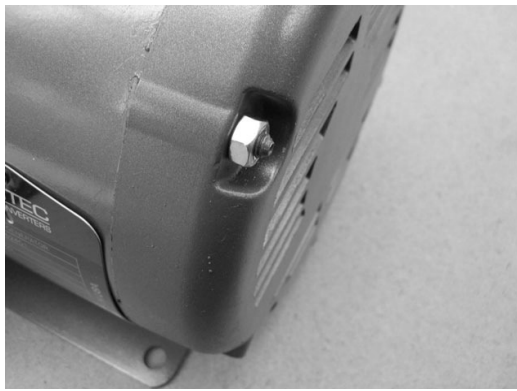


ALL PURPOSE CNC/HEAVY DUTY

ROTARY PHASE CONVERTER

**IDLER MOUNTING KIT
INSTALLATION MANUAL**



- 1a. 2.2kW (3HP) through 11kW (15HP):
Remove the upper nut and through bolt (one side at a time). For 11kW (15HP), remove the lift rings, they may be moved to the lower through rods for safe keeping.
Proceed to step 2.
- 1b. 15kW (20HP) through 22kW (30HP):
Skip to step 6.
- 1c. 30kW (40HP) through 45kW (60HP):
Skip to step 9.



- 2. Locate and tighten the nuts provided leaving the distance specified in Table 1. Tighten to the torque specified in Table 1.



- 3. Carefully insert the rod through the entire idler.



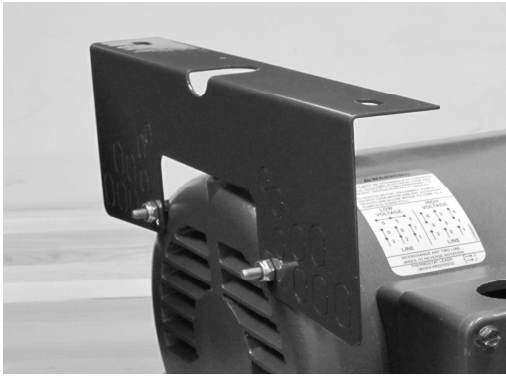
- 4. Assemble one nut on the opposite side; tighten to the torque specified in Table 1. Assemble the second jam nut; tighten to the torque specified in Table 1.



- 5. Repeat steps 1 through 5 on the other top bolt. Proceed to step 11.



- 6. 15kW (20HP) through 22kW (30HP) remove lift rings and use the existing idler nuts to assemble the mounting brackets. The lift rings may be moved to the lower through rods for safe keeping.



7. Install the mounting bracket as shown using supplied nylock nuts. Refer to Figure 1 for which holes to use. Tighten to torque as specified in Table 1.



8. Install the other mounting bracket as shown. The bracket holes are designed to allow for some adjustment. Make sure the top of the brackets are flush and level. Adjust if needed. Proceed to step 11.



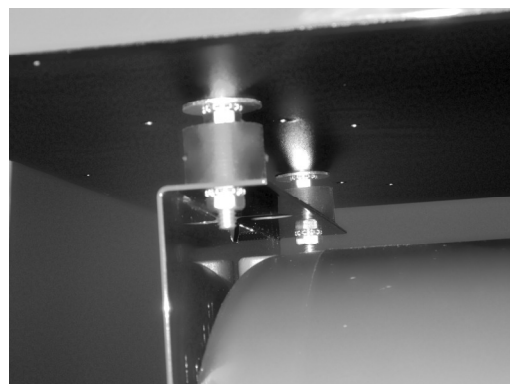
9. Remove the upper through rod nuts and lift rings, place aside for use later. Place the mounting brackets onto through rods with flange pointing toward the center of idler.



10. Place the lift rings back onto the idler through rods and align with large slot on the mounting bracket. Use the existing rod nuts to secure lift rings and mounting brackets. Tighten nuts to torque as specified in Table 1.

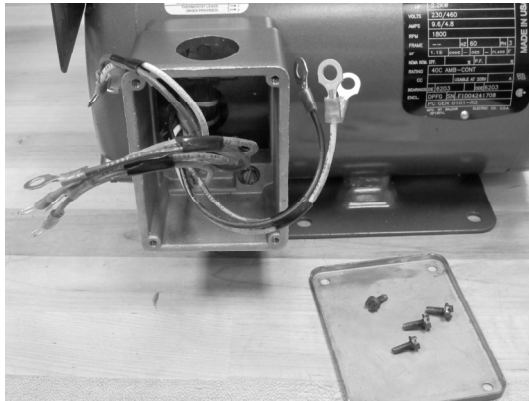


11. Attach rubber isolation mounts (4) to the threaded studs on enclosure base.

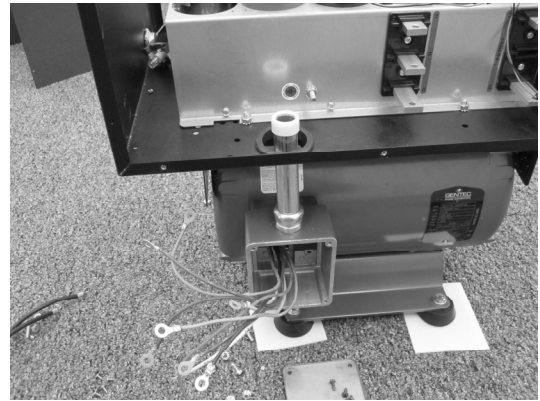


12. Secure the enclosure to the idler mounting brackets using 1/4" washer and 1/4" - 20 k-lock nut.

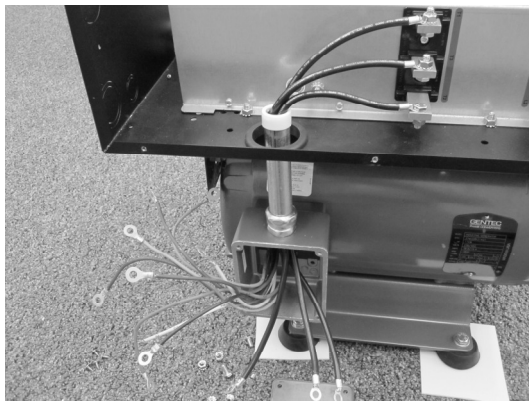
Electrical Connections



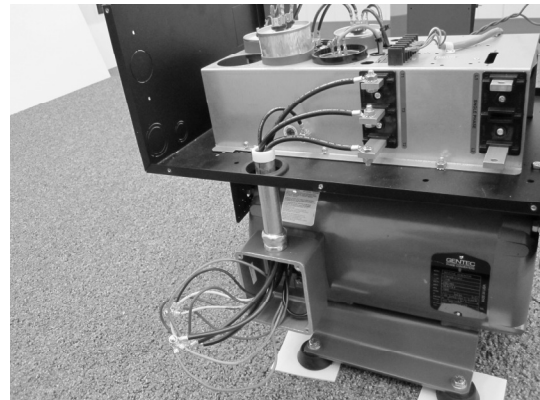
1. Remove cover on idler junction box.



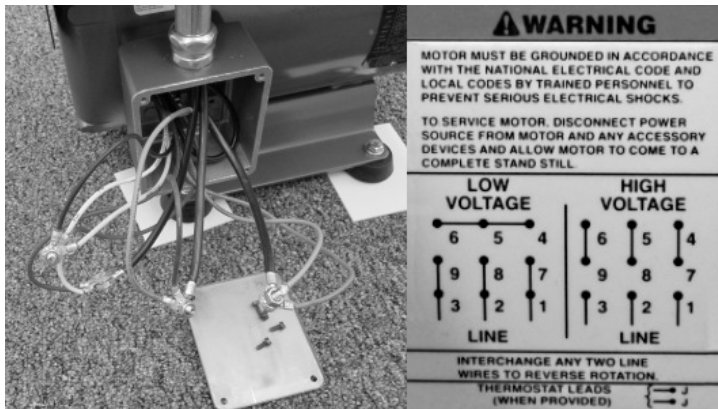
2. Attach conduit fitting/SO cable and/or conduit to idler junction box using supplied fittings/clamps.



3. Attach jumper/SO wires to T1, T2, and T3. Feed through conduit into junction box.



4. Attach ground wire to chassis and idler ground lug as shown.



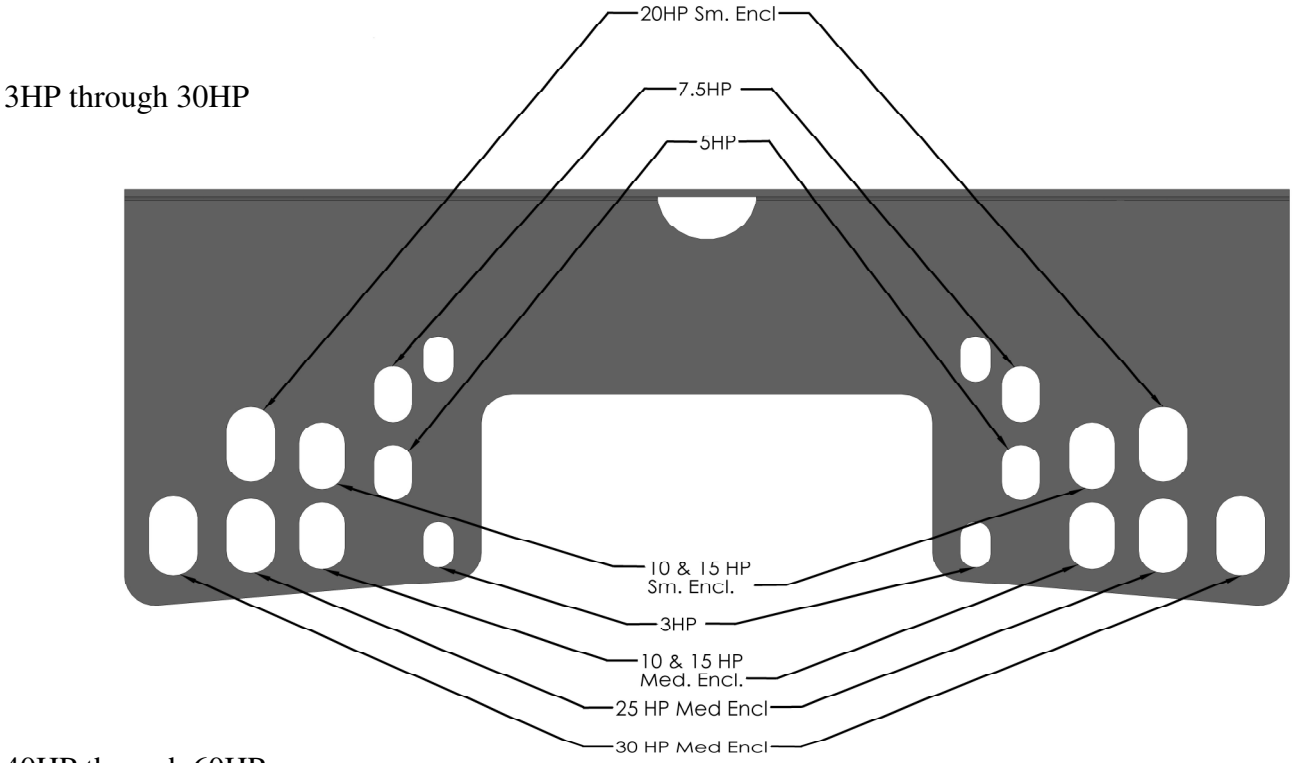
- 5a. Refer to installation manual when connecting idler wired to jumpers T1, T2 and T3.
- 5b. Using the 1/4-20 x 1/2" hex bolts and k-lock nuts (star washer attached to nut), secure the connections from the idler to the jumpers provided wiring for low (240) or high (480) voltage setting.
- 5c. Use heat shrink or electrical tape to insulate each connection.



6. Reattach idler junction box cover.

			Tightening Torque		
HP	KW	Thread Size	IN LBS	FT LBS	Exposed Thread (In Inches)
3	2.2	#10 - 32	27 - 33	2.3 - 2.8	.33 or equal
5	3.7	1/4 - 20	63 - 77	5.0 - 6.6	.475 or equal
7.5	5.5	1/4 - 20	63 - 77	5.0 - 6.6	.43 or equal
10	7.5	5/16 - 18	130 - 158	10.1 - 13.2	.425 or equal
15	11.2	5/16 - 18	130 - 158	10.1 - 13.2	.47 or equal
20	15	3/8 - 16	230 - 280	19.1 - 23.3	equal (remove lift rings)
25	18.5	3/8 - 16	230 - 280	19.1 - 23.3	equal (remove lift rings)
30	22	3/8 - 16	230 - 280	19.1 - 23.3	equal (remove lift rings)
40	30	3/8 - 16	230 - 280	19.1 - 23.3	equal
50	37	3/8 - 16	230 - 280	19.1 - 23.3	equal
60	45	1/2 - 13	582 - 704	48.5 - 58.7	equal
75	55	1/2 - 13	582 - 704	48.5 - 58.7	equal

Table 1



40HP through 60HP

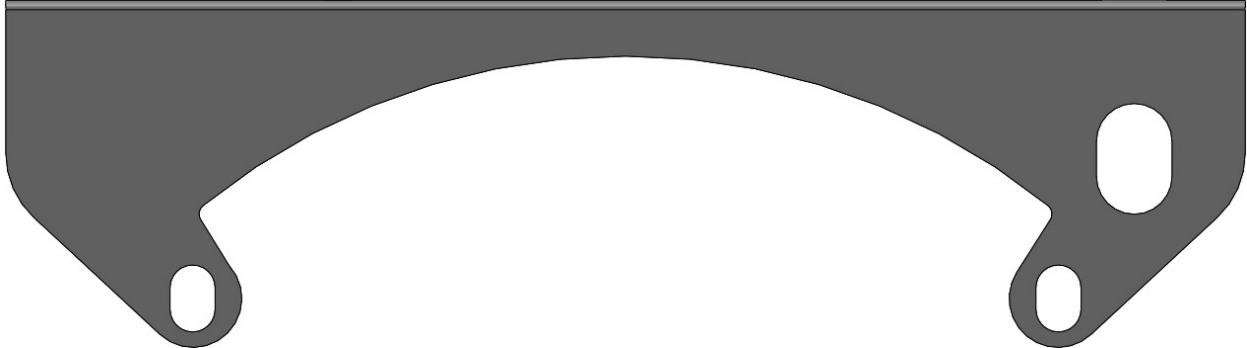


Figure 1