

KURT MANUFACTURING CO.
INDUSTRIAL PRODUCTS DIVISION
"POWERLOCK" INSTALLATION AND OPERATING INSTRUCTIONS

INSTALLATION:

Prior to installation make sure that:

- Air pressure is between 70 - 80 PSI, and free of water.
- The optional Filter/Regulator/Lubricator, is filled with air-tool oil and adjust for minimum oil flow. Set the regulator between 70 - 80 PSI.
- Quill is all of the way up, and locked in position.
- Machine power source is turned off at the disconnect box.

Remove the existing drawbar rod from your mill. Most machines have a hardened washer on the drawbar rod. This washer is to be used on the new splined drawbar rod unless a new hardened washer is supplied in the hardware package. Apply molybdenum disulfide grease, found in the hardware package (white tube) to the hardened washer and the areas of the drawbar rod specified in the exploded view. Install the new spline design drawbar, with the washer, back into the machine.

VARIABLE SPEED MILLS

The drawbar head (splined diameter) should stick up above the bearing retainer plate $1.000 + .000/-0.050$. If this dimension is not correct, the washer may need to be modified to meet this dimension. Place the Pneumatic Motor Assembly on top of the bearing plate of the mill, so that the IN/OUT lever is facing the front of the machine. Align the mounting slots or holes, depending on model, in the base of the assembly, with the existing jack screw holes in the bearing plate. Install the screws, leaving them 1-2 turns from tight. On some models it may be necessary to remove the Trip Lever Assembly (Item # 3) to install screws. Remove shoulder screws (Item #13) and guide rollers (Item # 5). Push the impact wrench down by applying slight pressure. The socket will engage with the splined head of the drawbar. Tighten the mounting screws and re-install Item #3 if it has been removed.

STEP PULLEY MILLS

Place the (3) extension legs on the bottom of the base using the (6) #10-24 x 1/2 flat head screws. Place the Pneumatic Motor Assembly on top of the sliding gear plate of the mill, so that the IN/OUT lever is facing the front of the machine. Make sure that the extension legs DO NOT interfere with the brake lever or sliding gear handle movement. Remove shoulder screws (Item #13) and guide rollers (Item #5). Push the impact wrench down by applying slight pressure. The socket will engage with the splined head of the drawbar. This will properly center the motor assembly with the drawbar. Transfer drill and tap (3) 1/4-20 UNC holes for mounting the pneumatic motor assembly. Insert spacers under leg extensions and secure with the (3) 1/4-20 x 2-1/4 socket head cap screws and lock washers, holding socket down on the drawbar during final tightening. There should be a .050/.100 gap between the top of the shoulder on the drawbar head and the bottom of the base. If this dimension is not correct, the washer may need to be modified to meet this dimension.

BOTH STYLE MILLS

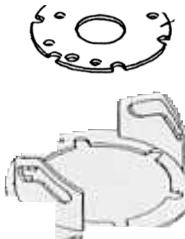
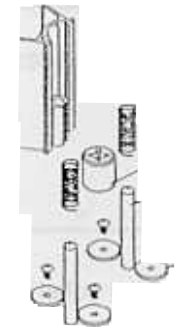
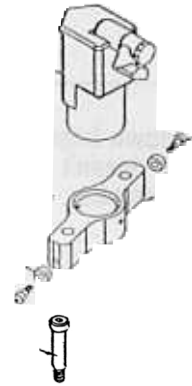
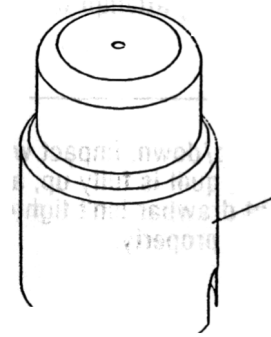
Re-install guide roller (Item #5) and shoulder screws (Item #13). Check the air flow control on the impact wrench and make sure that the setting is at #7. If you have purchased the optional Filter/Regulator/Lubricator, mount it in an easily accessible location of your choice. Connect air supply to impact wrench. Reconnect the electrical service to the machine. Following safety instructions on cover, test unit to see if it is operating properly. If unit functions properly, install cover. If unit DOES NOT function properly, and the above steps have been followed correctly, please refer to the troubleshooting guide portion of this booklet.

MAINTENANCE

Make sure collets or toolholders are free of chips. Periodically lubricate collet or toolholder threads to avoid damage to threads. Make sure that the air lubricator is filled with air-tool oil. If a lubricator is not used, it is recommended by the manufacturer to oil the air motor once daily. Make sure the assembly is covered at all times.

20	04-4242	PIN, ROLL, 3/16 DIA X 3/8	2	
19	700-32	PIVOT PLATE, UNIVERSAL	1	
18	700-08-SA	COVER	1	
17	03-0150	BHCS 3/8-16 X 3/4 LG.	1	
16	* 600-XX	DRAWBAR ROD	1	
15	212-6000	CP-722 IMPACT WRENCH, MECH	1	
14	03-2025	SCREW, SHLDR 3/8 1-1/2	1	
13	03-2000	SCREW, SHLDR 1/4 X 1/4	2	
12	700-15	SPRING COMPRESSION	2	
11	01-0264	SCREW SHSS #10-32 X 1/2 LG.	2	
10	04-0077	PIN, DOWEL 3/8 DIA X 3.0	2	
9	03-125	BHCS #10-24 X 1/2 LG.	4	
8	208-00	SOCKET DRAWBAR	1	
7	700-07	WASHER, HOLDING, BRASS	4	
6	700-06	KNOB, MECHANICAL DRAWBAR	1	
5	700-05	ROLLER, GUIDE	2	
4	700-04-02	SLIDE	1	
3	700-003	TRIP LEVER	1	
2	700-02	PIVOT PLATE ASSEMBLY	1	
1	700-31	BASE ASSEMBLY, UNIVERSAL	1	
	PART NO.	DESCRIPTION	QTY	PRICE

* PART NUMBER VARY DEPENDING ON MODEL NUMBERS.



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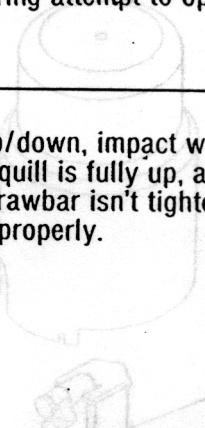
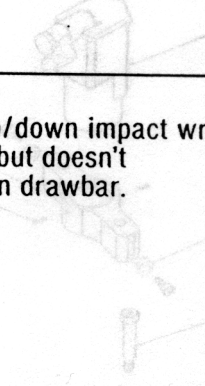
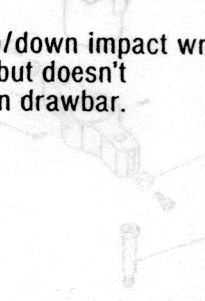
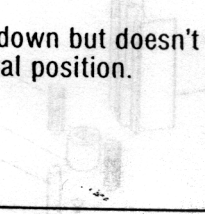
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(3)

(20)

TROUBLE SHOOTING

PROBLEM	SOLUTION	APPLIES TO
<p>Head goes up/down, impact wrench doesn't turn and no air leaking anywhere during attempt to operate.</p> 	<ol style="list-style-type: none"> 1. Air supply disconnected or turned off, verify 70-80 PSI at impact wrench. 2. #700-03 trip lever assembly not functioning properly, the spring tab on the bottom is bent or broken. 	<p>ALL MODELS</p>
<p>Head goes up/down, impact wrench motor turns, quill is fully up, and locked, but drawbar isn't tightening or loosening properly.</p> 	<ol style="list-style-type: none"> 1. Pin in drawbar assembly is sheared. Replace with #604-02 grooved pin. 2. Threads stripped on drawbar. 3. Threads stripped on collet/toolholder. 4. Spline stripped on drawbar and/or #208-00 socket. 5. Flow control on impact wrench not set at "7". 6. Air pressure lower now than when drawbar was tightened. 	<p>ALL MODELS</p>
<p>Head goes up/down impact wrench motor turns, but doesn't tighten/loosen drawbar.</p> 	<ol style="list-style-type: none"> 1. Quill not all of the way up, and locked in position. 2. 1.000 + .000/- .050 spline head height above bearing retainer plate short, socket won't reach drawbar. (Refer to installation instructions.) 3. Legs bent or spacers too long on base with legs. (Refer to installation instructions.) 	<p>ALL MODELS VARIABLE SPEED MACHINES STEP PULLEY MACHINES</p>
<p>Head moves down but doesn't spring back to neutral position.</p> 	<ol style="list-style-type: none"> 1. #700-15 springs are worn or broken. 2. #700-04 slide is binding and needs to be lubricated. 3. #700-02 pivot plate is binding and needs to be removed and greased on the bottom and inside diameter. 	<p>ALL MODELS</p>
<p>Unit doesn't tighten collet/toolholder tight enough.</p>	<ol style="list-style-type: none"> 1. Impact wrench is not being lubricated properly. 2. Air flow control on impact wrench needs to be increased. 3. Operator is not holding the lever in the "IN" position long enough. 	<p>ALL MODELS</p>