



SPECIAL SERVICE INSTRUCTIONS

Instructions to correct wiring error on 2075

If the grinding head switch is lit when the unit is plugged in, and the grinding head switch is in the off position, the wiring in the chuck head has been assembled incorrectly. The Black and White set and the Red and Orange set of power wires in the 5-conductor cord have been connected incorrectly.

NOTE: DO NOT RUN THE MACHINE UNTIL THE SHIPPING BLOCK UNDER THE GRINDING HEAD IS REMOVED, OR THE DRIVE BELT MAY SLIP OFF ONE OF THE PULLEYS! If this happens the motor cover must be removed to align the pulleys and belt.

To correct this wiring error, follow the instructions below. You will need a Phillips screwdriver and a needle-nose pliers.

1. UNPLUG THE MACHINE ! Never work on the machine while it is connected to line voltage. Remove the wooden shipping block from under the grinding head motor. It can be located by following the cord that is attached to the three blocks used on the 2075.
2. Loosen the cord clamp nut on the back of the chuck cover of the cord going to the limit switch. Slide the rubber grommet up the cord until there is about 3" of slack between the grommet and the chuck cover. Hold the cord between the grommet and clamp when moving the grommet. This is necessary to prevent unplugging the limit switch wire when the switch panel is removed in the next step.
3. Remove the screws from switch plate .
4. Carefully tilt the plate down while feeding in the limit switch cord, until you have access to the back of the rocker switches. See the other side of this sheet for a wiring diagram.
5. Remove the RED and ORANGE wires from the grinding head switch by pulling on the terminals with a needle-nose pliers. This is the top switch, and the terminals closest to the speed control module. Do not pull on the wires themselves or they may come loose from the terminals.
6. Carefully remove the BLACK and WHITE wires from the chuck motor switch. This is the lower switch. These wires are the closest to the speed control, and connected to jumpers of like colors. Do not remove the jumpers, but carefully remove the wires from the jumper using a needle-nose pliers to pull on the terminal.
7. Connect the BLACK wire to the top terminal on the grinding head switch. Connect the WHITE wire to the bottom terminal on the grinding head switch.
8. Connect the RED wire to the BLACK jumper wire on the top terminal of the chuck motor switch. Connect the ORANGE wire to the WHITE jumper wire on the bottom terminal of the chuck motor switch.
9. Make sure all the wires are snugly connected. Then carefully replace the switch panel and gently tighten its retaining screws. Be careful not to strip out the screws.
10. Push the grommet on the limit switch cord back to its original position, and tighten the nut.
11. Plug the machine in and check to see that the grinding head switch is no longer lit, when the unit is turned off.

IF THE GRINDING HEAD IS RUN WITH THE SHIPPING BLOCK IN PLACE THE DRIVE BELT MAY SLIP OFF ONE OF THE PULLEYS. If this happens the motor cover must be removed to align the pulleys and belt.

**SIOUX
TOOLS INC.**

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65317

— ORANGE

- WHITE

- GREEN

28188

18226
LIMIT SWITCH

1826
LIMIT SWITCH

— C
— No

CHUCK HEAD
SWITCH

28864

WHITE

BLACK

SPEED CONTROL

RED 28157

BLACK 28158

The diagram shows a circular control panel. On the right side, there are three buttons arranged vertically: "SPEED CONTROL" at the top, "BLUE" in the middle, and "RED" at the bottom. On the left side, the word "BLACK" is written vertically. The panel is divided into three horizontal sections by the button lines.

TOP EDGE OF PANEL

REAR VIEW OF CONTROL PANEL

AS SEEN FROM FRONT OF MACHINE AFTER REMOVAL
(RUSSENBERGER SWITCHES ONLY)