



Mount parts catcher as shown. Note that mounting plate is under splash-guard hinge. Spacers are provided for upper mounting bolt

Modify splash-guard as indicated above (*drill clearance hole for mounting bolt*) and at left (*cut away corner to clear splash-guard chip-shield*).

Route air-lines to new air-solenoid (*see next page for air-solenoid installation instructions*).

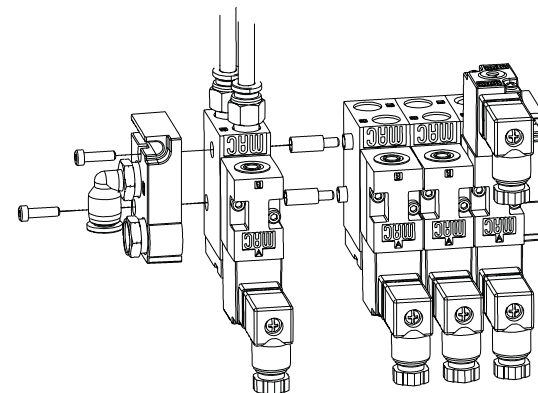
Parts catcher extends with M25 and retracts with M26.

Use the key labeled "*Parts Catcher*" or "*M25/M26*" to extend and retract the parts catcher in Jog mode. If there are no labels use the PgDn key. If you have "G4" CNC (with two cycle-start buttons on front-panel) you must press and hold Ctrl key, then press "*Parts Catcher*" or "*M25/M26*" key.

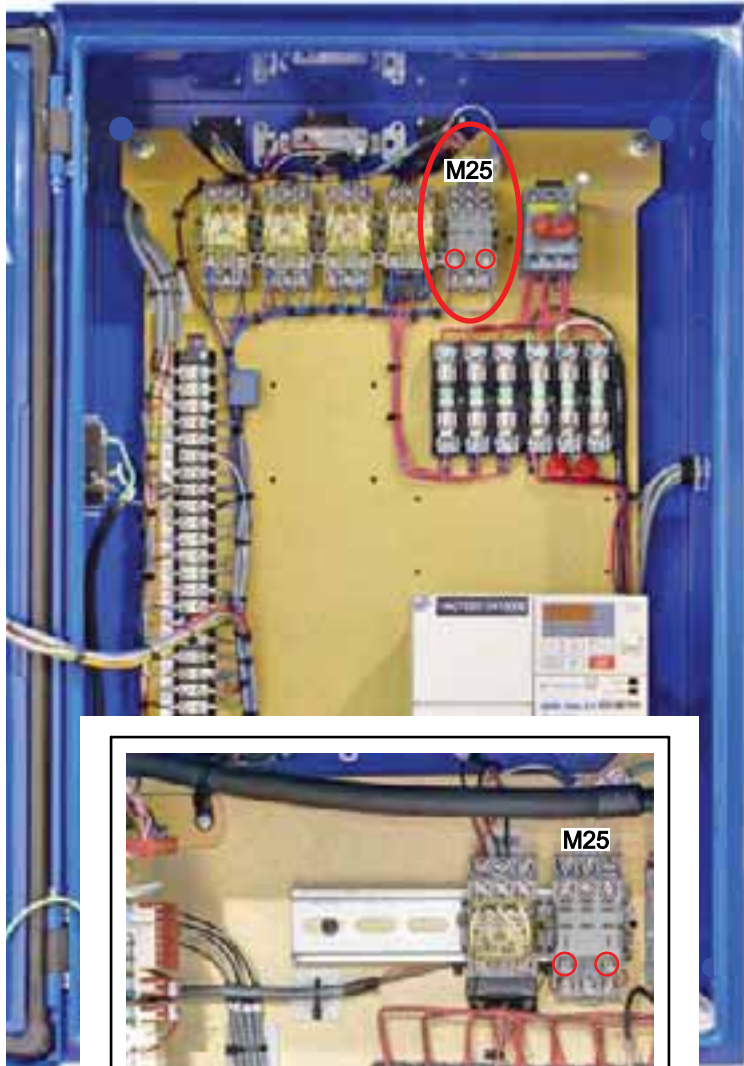


TO ADD AIR-VALVE TO AIR-PACK:

1. Remove two socket-head capscrews and endcap.
2. Add tie-rods (supplied with air-valve).
3. Install new air-valve and gaskets: observe gasket polarity and reassemble. Don't pinch gaskets.



Spindle Drive Panel with TB1
(See inset for panel with PWB)

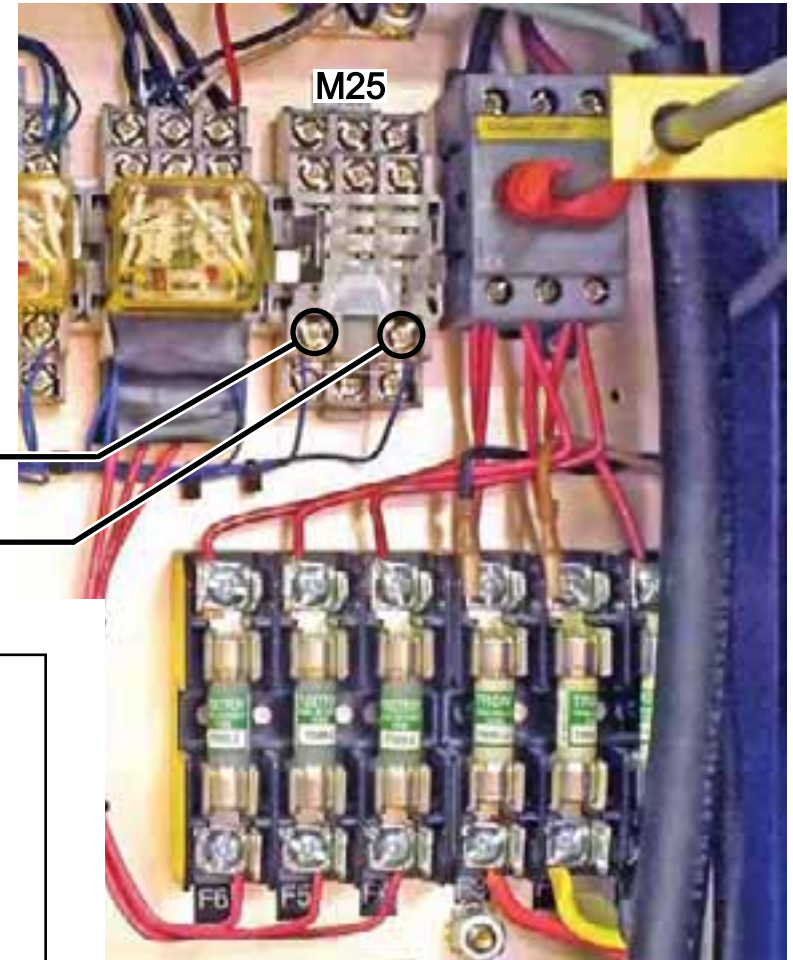


M25

Remove the relay from M25 socket to reduce load on driver.

Route cable from new air-valve to M25-14 (clear) and M25-13 (black)

From Parts Catcher Air-valve



M25

SCHEMATIC

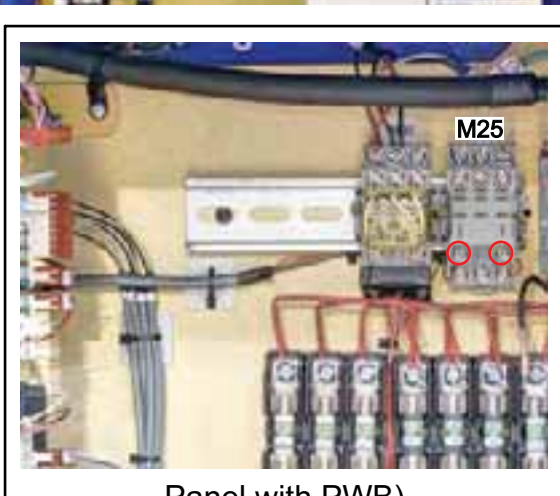


M25
(remove relay)

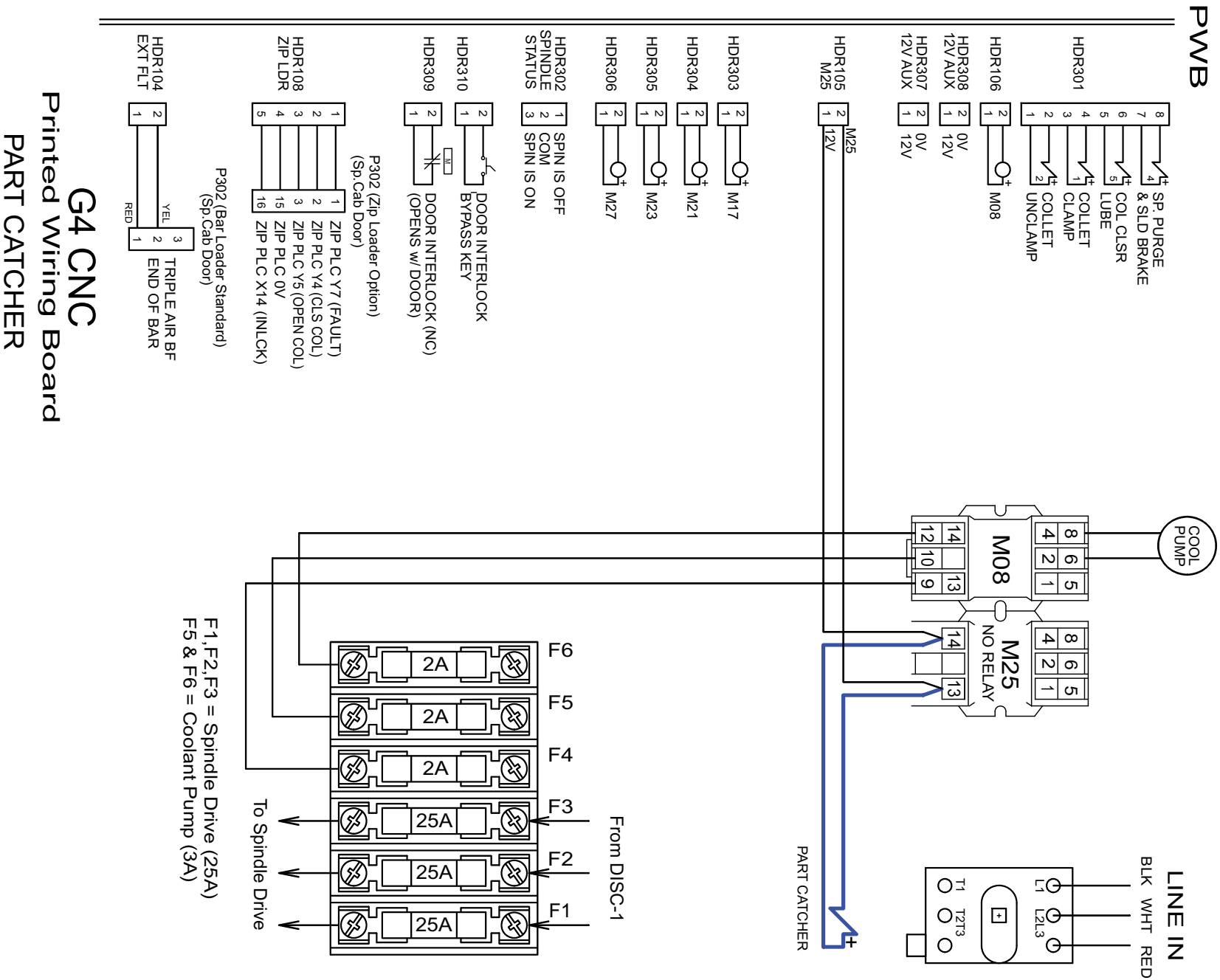
From parts catcher air-valve.

Route cable from parts catcher air-valve through liquid-tight on side of spindle cabinet where other solenoid cables go through.

NOTE: If you find any wires on M25 relay except at 13 & 14, **DO NOT continue installation!** Call (541) 332-7004 for assistance.

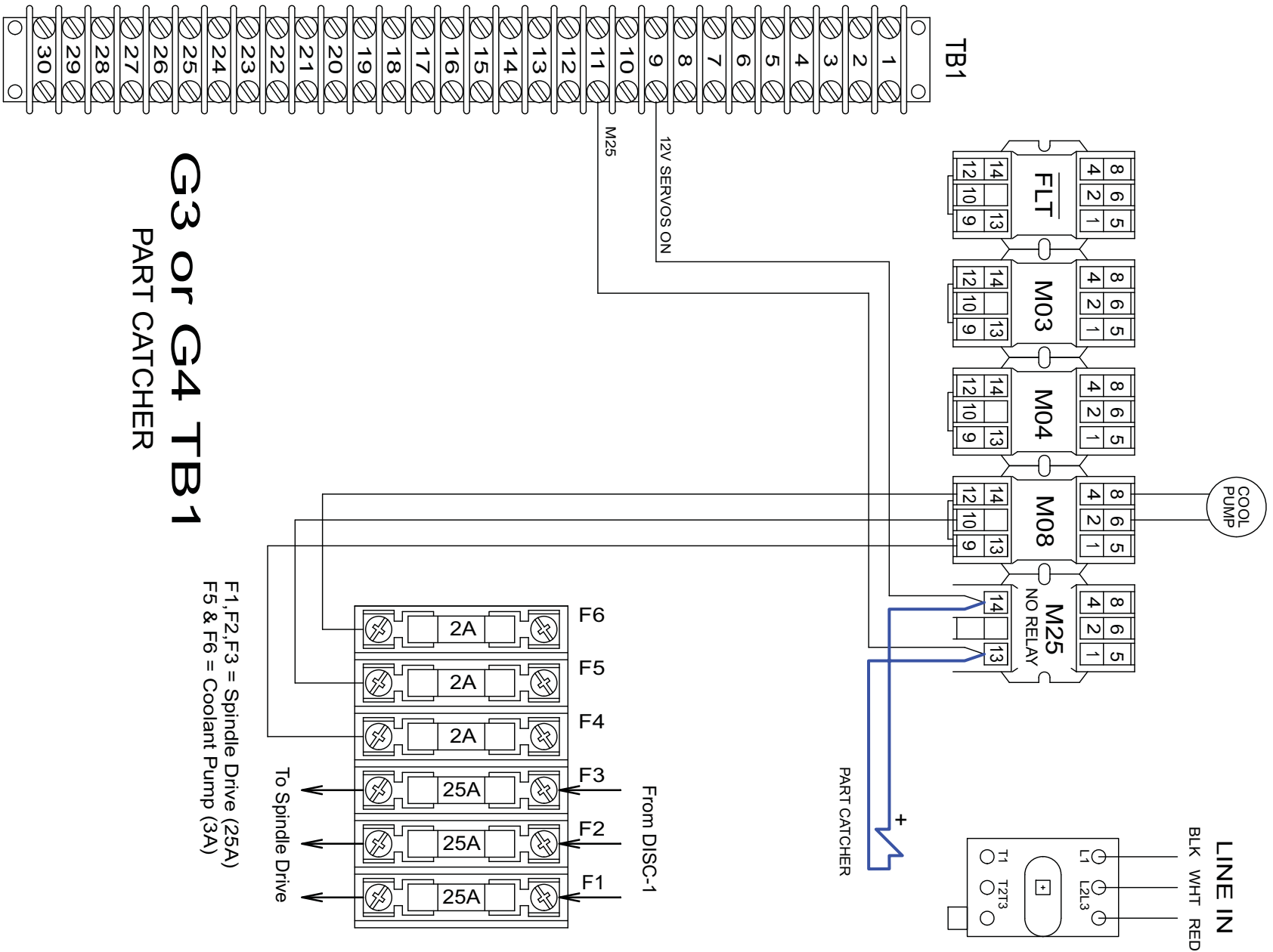


Panel with PWB)



G4 CNC
Printed Wiring Board
PART CATCHER

spindle_cab_pwb_part-catcher.dcd oct 2017



G3 or G4 TB1
PART CATCHER

spindle_cabtb1

part-catcher.dcd oct 2017