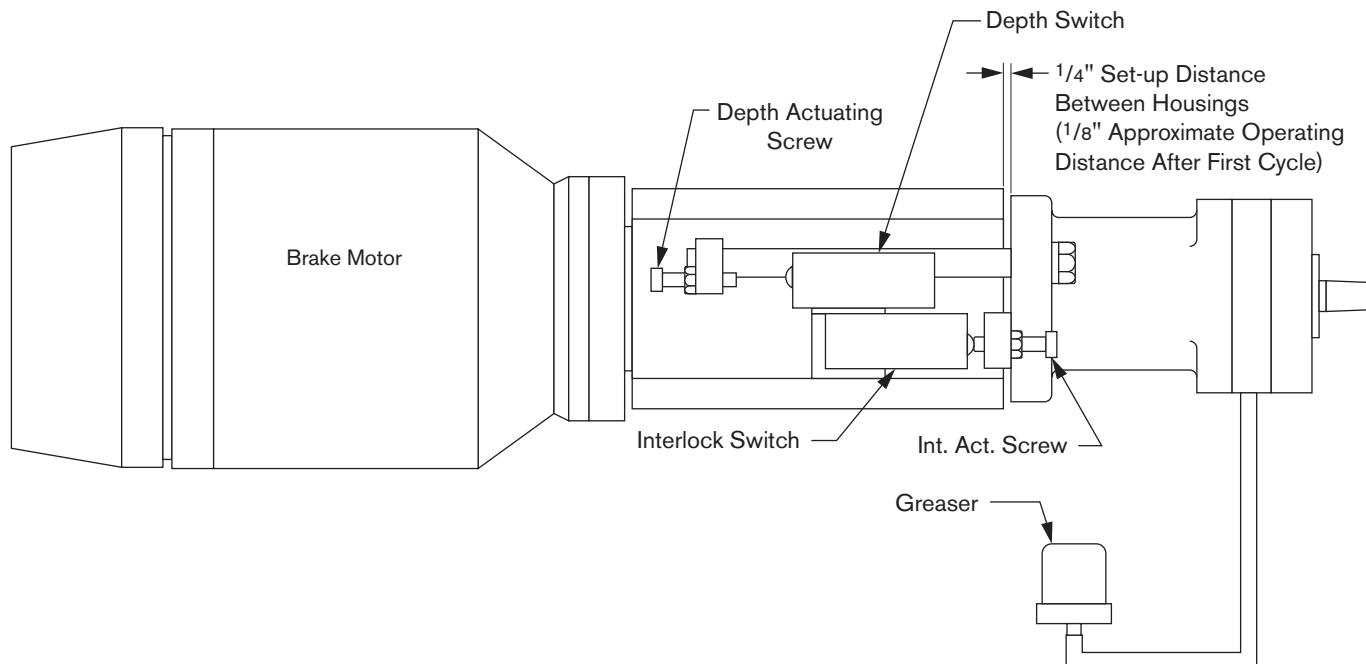


# HYPNEUMAT INC.

AUTOMATIC DRILLING & TAPPING UNITS

## MLS-175E SET-UP INSTRUCTIONS WITH BRAKE MOTOR



1. Wire the unit, motor and other components completely.
2. Make sure the Motor off/on selector is in the OFF position.
3. Release Brake Motor with Manual Brake Release Tools
4. Rotate the Unit Spindle to  $\frac{1}{4}$ " set-up distance between the housings. After the first cycle, motor should brake to within approximately  $\frac{1}{8}$ " operating distance between housings. (see Sketch).
5. Remove Manual Brake Release Tools.
6. Advance Interlock Activating Screw to activate the Interlock Switch.
7. Turn the power ON.
8. Push the Feed Buttons.
9. Use the Motor off/on selector as a Jog Motor Rotation Check:
  - a. Turn off/on selector to ON position then quickly to OFF position.  
NOTE: This must be done rapidly so as not to bind unit up if unit is running in the incorrect direction.
  - b. If unit Feeds Forward Set-up is complete.
  - c. If the unit closed the distance between the housings, change (2) two Leads, either at the Motor Starter or Motor Connections.
10. Set Depth Switch (not to exceed  $1-\frac{3}{4}$ ").

Visit us on the World Wide Web at <http://www.hypneumat.com>

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