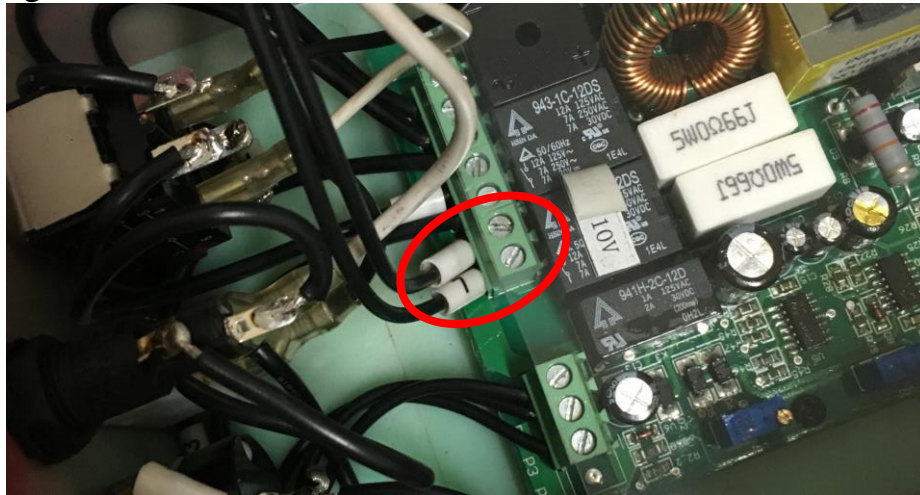
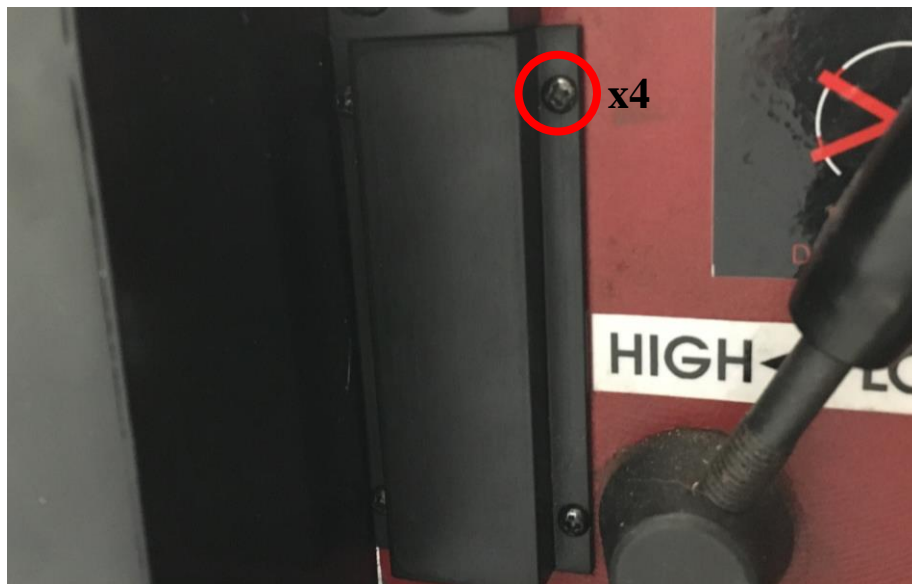


## Chuck Safety Switch Upgrade Installation Steps

1. Safety first! Unplug the lathe. You will need to get into the control box, and you don't want to be messing around in there while it's still plugged in.
2. Remove the 4 screws holding the control box to the housing. Pull the box towards you to remove it from the grommet.
3. Use a slotted screwdriver to loosen the connectors securing the wires at pins 6 and 7. Pull the wires free from the control board. If installed, cut the zip tie bundling the wires together.



4. Remove the 4 screws securing the wire cover on the back of the lathe. Pull the wires through the housing, ensuring the tube in the housing does not come out with the wires.

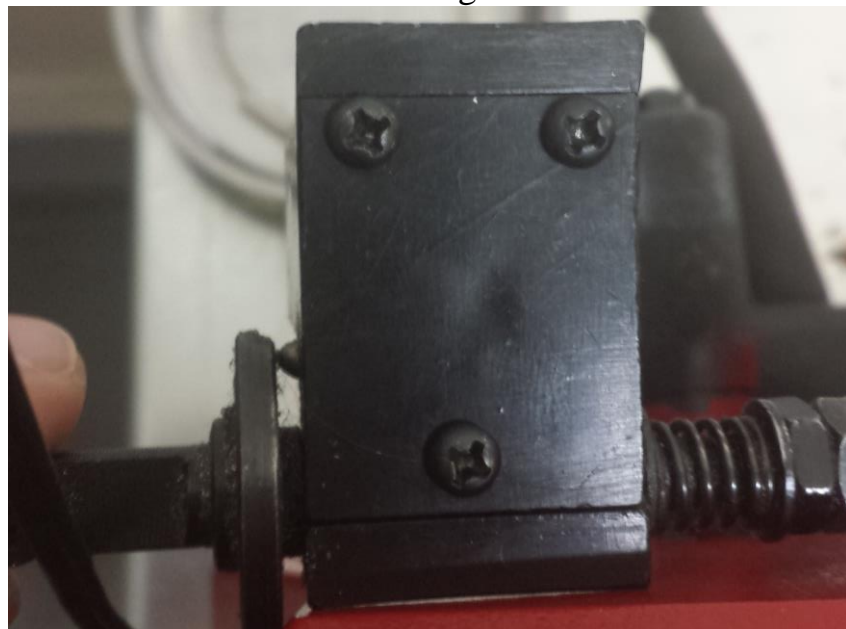


5. Remove the two screws securing the chuck shield switch to the housing and pull

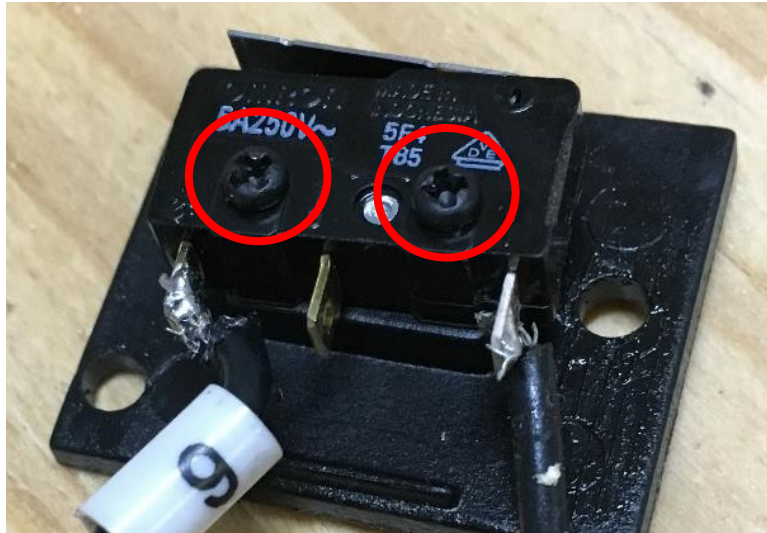
the switch housing away from the lathe.



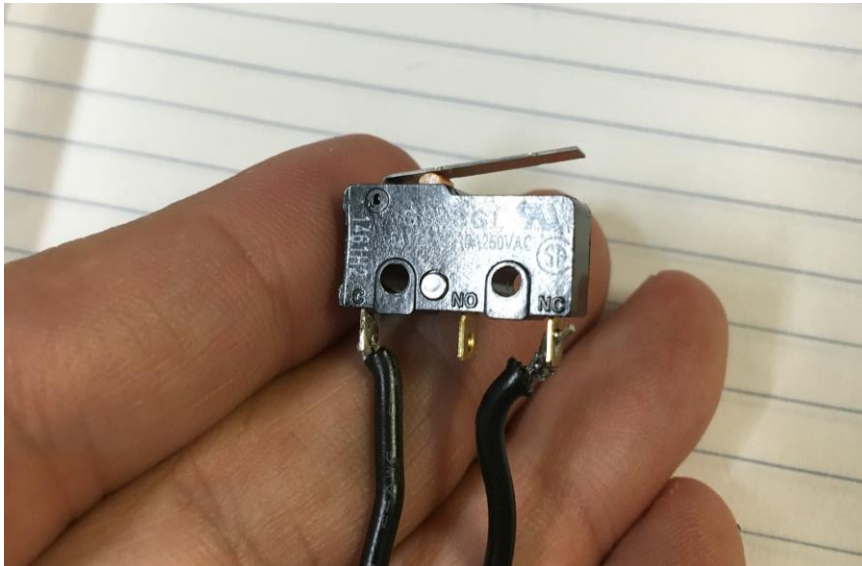
6. Use a Philips head screwdriver to remove the three screws holding on the switch cover and pull the switch free of the housing.

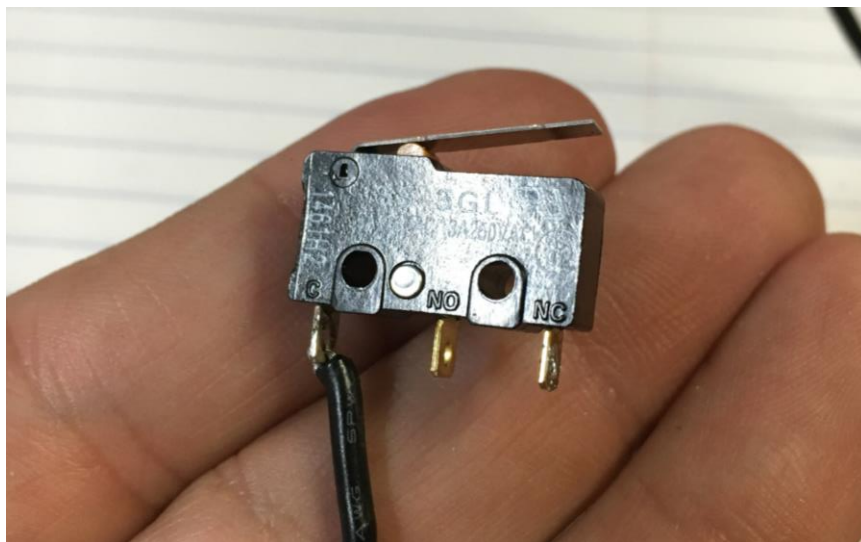


7. Remove the two screws securing the switch to the cover and pull the switch and the wires free from the housing.



8. As is, the wires will be connected to the switch in two places: “C” and “NC” (Common and Normally Closed). You have two choices here: 1) Cut the wire at the “NC” terminal and just leave the soldered on part of the wire alone, or, 2) Desolder the wire from the “NC” terminal. Either way, you need to remove the wire connected to the “NC” terminal. I chose to desolder the wire.



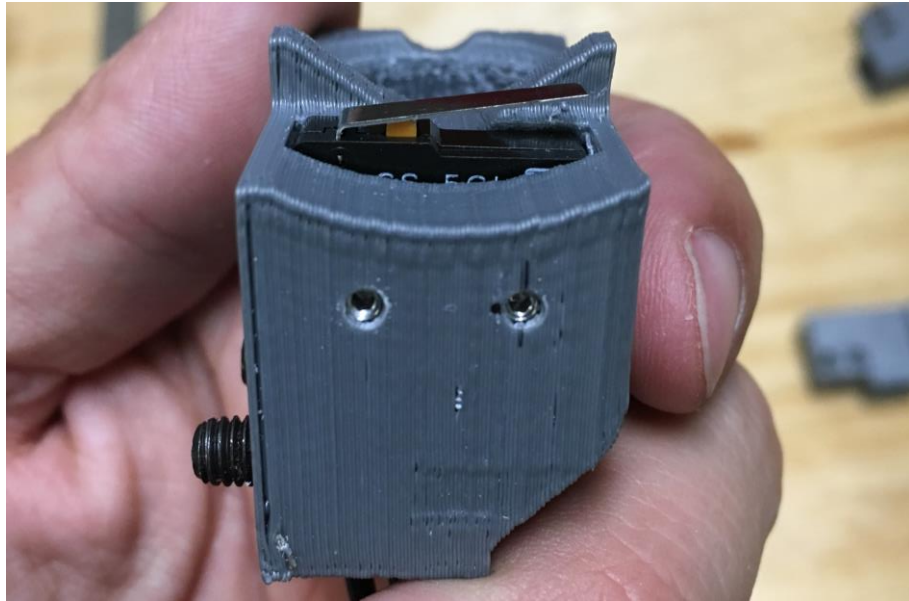


9. Solder the removed wire to the “NO” (Normally Open) terminal. Use a multimeter (if available) to verify that when the switch is pressed, there is continuity through the switch and when the switch is released, the circuit opens.



10. Run the wires through the housing and set the switch in the seat. Install set screws into the housing to secure the switch.

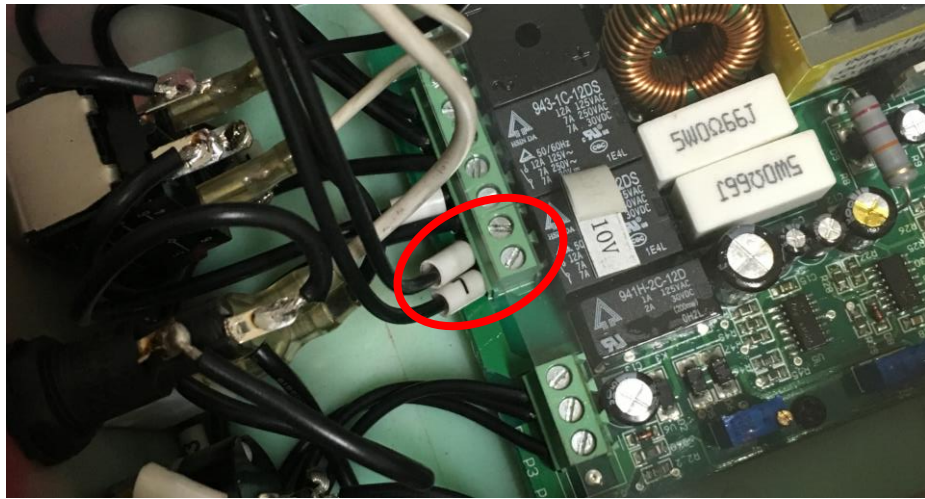




11. Install the two removed screws into the housing to secure to the lathe. Run the wires back through the tube in the lathe housing.



12. Connect the ends of the switch wires to pins 6 and 7 (which wire goes to pin 6 or 7 doesn't matter) and secure.



13. Push the control box back into place and secure with the four screws removed earlier.

14. Plug in the lathe and verify the lathe operates when the key is in the holder and stops when the key is removed.

15. Reinstall the wire cover with the 4 screws removed earlier.



16. Enjoy always knowing where your chuck key is and that you made running your lathe just a little bit safer.



I was able to perform these steps in about 15 minutes (while taking pictures and notes) so you should be able to do the same in about 10 minutes. Feel free to leave a comment, or, contact us if you have any questions or comments.