

## REMOVE CHIP PAN

The chip pan is usually shipped in the cutting area of the GT-75. It holds the coolant pump, leveling feet, and any special tooling or accessories.

## REMOVE 4x4's

Replace the 4x4's with the leveling feet (or optional bolt-down feet). Absolute leveling is not necessary; adjust the feet so that the machine is stable on your floor.

## INSTALL COOLANT SYSTEM

Remove white cardboard box behind the lower front doors (CNC control & user's manual).

The coolant tank is shipped bolted to the right side of the frame with two bolts; the other two bolts are threaded into mounting holes in cross member. Remove these bolts and unbolt the coolant tank. Set coolant tank on cross members with pump chamber on left side; bolt securely to cross members. CNC mounting wedge is shipped in coolant tank; set this aside for now.

The coolant pump flange holds coolant pump to tank w/o hardware. Set pump atop pump chamber. Connect coolant hose to pump; tighten clamp securely.

Plug coolant pump power cord into outlet on spindle drive cabinet (blue cabinet at left).

## INSTALL CNC CONTROL

Remove CNC control and OmniTurn User's Manual from white cardboard box. *USB stick, door-interlock bypass key, and any technical documents specific to your machine, are added to the front of the User's Manual.* Place CNC on table upside-down. Remove four 1/4-20 SHCS from bottom of Control. Mount wedge to control. Attach wedge and control to GT75 using 3/8-16 SHCS. Control can be rotated if desired, by using only one bolt. Cut zip-ties holding cables and connect cables to control: **insure that labels on cable plugs agree with labels on control sockets.** Plug CNC power cord and work lamp plug box into outlets in box at top right-rear of GT75. Locate USB stick inside front-cover of OmniTurn Manual, and install in socket behind door. This is the parts program backup and emergency hard drive restore.

## CONNECT AIR

*The GT75 has a pneumatic brake on the X axis slide: **do not move slide without air!***

Connect dry air to 1/4NPT port on regulator input. The regulator is set for 90 psi. When servos are on there is positive air pressure on spindle bearings to prevent coolant migration.

## CONNECT POWER

Route 220VAC line to junction-box at rear of spindle cabinet on GT-Jr. Connect three-phase power to the black, white and red wires. Phasing is not necessary. For single-phase operation (not available for C-Axis) connect hot wires to the black and white wires. Cap or tape the end of the red wire. Connect ground wire to green ground screw in box. Power for CNC is supplied by transformer in spindle cabinet.

## TURN-ON

Insure that E-Stop switches on CNC Control and Dual Palm-Box are disengaged. Set Spindle Drive Cabinet disconnect switch to ON. Press Control On pushbutton on Control panel. Switch will light and computer will begin boot-up sequence. When boot-up is complete, computer will prompt "Please backup your program files (Y/N)". Always Press "Y" to backup any files which were edited. You may see some test files copied this time, or no files at all. Press any key to continue. The next screen will prompt "Servos off or Ext. Halt detected-". Press the blue Servos On button.

## DOOR INTERLOCK and BYPASS KEY

To insure operator safety, the sliding front door is interlocked to the CNC. The sliding door must be closed for Cycle Start to function. If the door is opened while program is running, spindle will stop and Feed Hold will be active. To continue, close door and press Cycle Start switches.

## PHASING

Phasing is not necessary unless equipped with **CONVEYOR** or **3-PHASE LIVE-TOOL** options. Adjust phasing for these options at line input; multiple options have been phase-matched at factory before shipping.

## BYPASS KEY

The interlock bypass key-switch is located on the Spindle Drive Cabinet door at left side of machine. A pair of keys are inside front-cover of User's Manual. These keys should be in the possession of supervisory personnel specially trained and cognizant of the potential hazards involved with working on machinery that is powered up and/or in cycle. **Your GT-75 is now initialized and ready to Jog.** Refer to your Manual for detailed instructions to jog and establish Home.