In both methods the motor will be disconnected from the power source.

Note: For a (B) connection, connect terminal W to U, V to W and Y to Z.

For a (C) connection, connect terminal W to U, V to Y and Z to T.

Determine the supply voltage and refer to the voltage chart for appropriate connections. Refer to page 3.3 to 3.5 for 3-phase connections.

**WARNING**: Ensure the supply is OFF before connecting to the electrical supply.

<table>
<thead>
<tr>
<th>Supply</th>
<th>Phase</th>
<th>1</th>
<th>2</th>
<th>3</th>
</tr>
</thead>
<tbody>
<tr>
<td>400 V</td>
<td>3 HTC</td>
<td>10</td>
<td>20</td>
<td>30</td>
</tr>
<tr>
<td>400 V</td>
<td>2 HTC</td>
<td>10</td>
<td>20</td>
<td>30</td>
</tr>
<tr>
<td>400 V</td>
<td>1 HTC</td>
<td>10</td>
<td>20</td>
<td>30</td>
</tr>
</tbody>
</table>

**Connect the Supply**

- For all connections: The supply cable (with cable ends attached) must be connected to the motor terminals. For all voltages: The supply cable (with cable ends attached) must be connected to the motor terminals.

**Important**: Do not remove or loosen the bolt and nut on the end of the cable.
NOTE: The setting details a unit with a NCU. The reference to the NCU is not important in the English text provided.

1. It is important that the advance rate of the tool is set to an adequate cutting speed.

2. Insert the tool into the NCU and adjust the tool position.

3. Adjust the tool to the desired position and advance.

4. Connect the tool to the power supply and press Figure 2.

5. Figure 1.

6. The tool must be placed with the workpiece.

7. Next, the workpiece must be moved to the desired position. The gap between the tools must be set to 0.1 mm (0.005 in).

8. Finally, the tool can be moved to the workpiece.
WARNING

The brake sleeve complete is under spring (9) compression whilst resisting the thrust due to the spring (10). ENSURE THE COMPRESSOR WHILST RESISTING THE THRUST ON THE SLIDE, THE BRAKE SLEEVE COMPLETE IS UNDER SPRING (10). ENSURE THE COMPRESSOR WHILST RESISTING THE THRUST ON THE SLIDE, THE BRAKE SLEEVE COMPLETE IS UNDER SPRING (10).