

Service Bulletin 1007 Coolant Level Indicator - PCNC 1100

Date

Issued 1-June 2012

Product

Tormach PCNC 1100 (LMS PN 4263) with Deluxe Stand (LMS PN 3835)

Issue

The coolant tank is inside of a compartment on the Deluxe Stand. It is hard to see the coolant level.

Solution

Install a coolant level indicator as described below. You'll need a few parts, as detailed on the attached drawing.

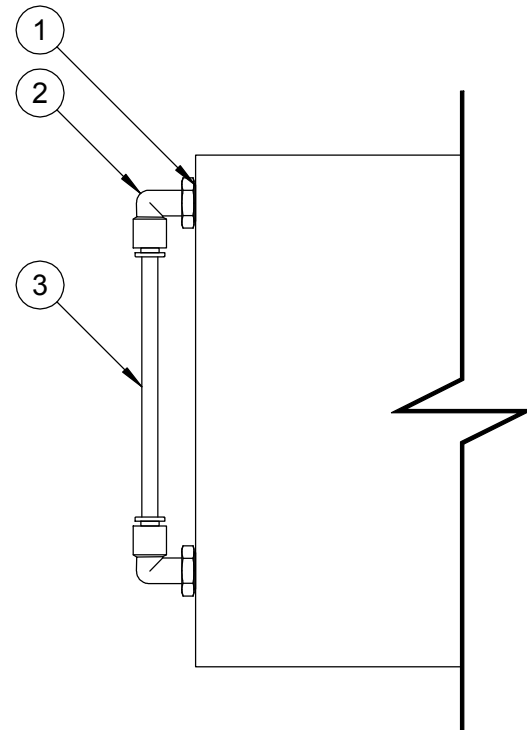
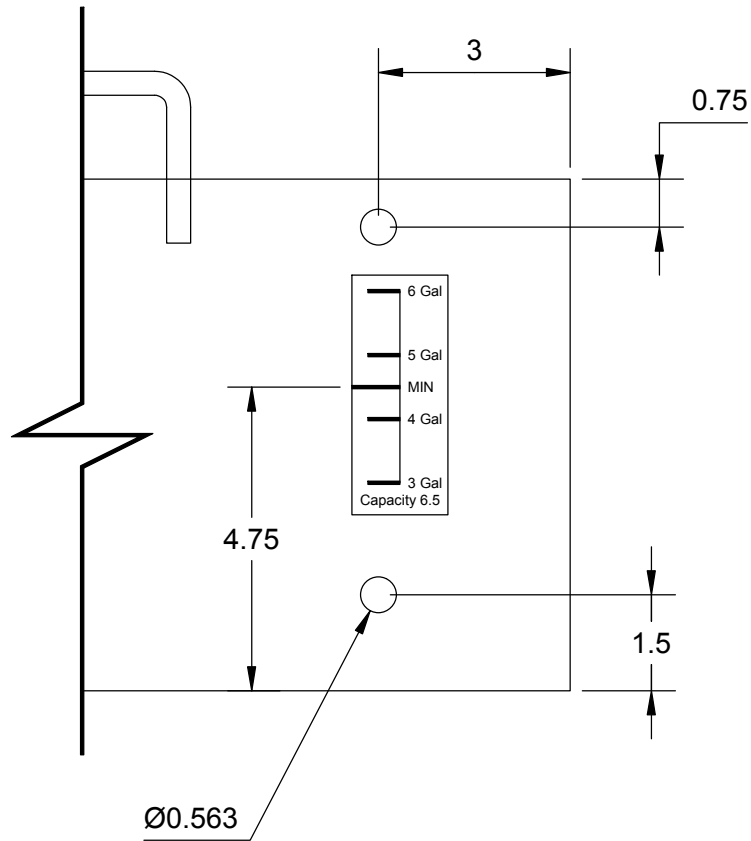


Installation

1. Use the Coolant Manual switch to pump as much coolant as possible from the coolant tank into a storage container (or discard).
2. Unplug the coolant pump power cord.

3. Remove the catch drawer.
4. Remove the coolant tank and pump.
5. Remove the top from the coolant tank.
6. Pour the balance of the coolant into a storage container (or discard).
7. Mark and drill two 9/16" holes as shown on the attached drawing.
To produce round holes through sheet metal:
 - a. Starting with a 1/8" drill, drill progressively bigger holes in 1/8" steps, until you reach 1/2".
 - b. Cut or tear two 1" squares of medium to fine abrasive cloth (emery cloth).
 - c. Place the abrasive cloth face down over a hole in the tank and drill through it with a 9/16" drill.
 - d. Repeat (with a new piece of abrasive cloth) for the other hole.
8. Install the bulkhead male elbow fittings with O-rings. Don't tighten so much that the O-ring is mashed.
9. Measure the minimum distance between the two fittings.
10. Cut the tubing to 1/4" longer than the measurement.
11. Press the ends of the tube firmly into the fittings to seat it.
12. Print the Level Gage in the attached drawing. Be sure that your print options are set to Actual Size. Confirm the 3.75" dimension.
13. Cut out the Level Gage using the printed rectangle as a guide.
14. Get a piece of 2" clear carton sealing tape and place it on a flat surface with the adhesive side up.
15. Place the Level Gage face down centered on the tape. Now it is much easier to handle the tape.
16. Trim the tape approximately 1/4" above and below the Level Gage. You should have a 1/4" margin of tape all around the Level Gage.
17. Mark a point on the front of the tank that is 4.75" above the bottom of the tank and directly behind the level indicator tubing.
18. Adhere the Level Gage to the front of the tank so the left end of the MIN line is on the mark.
19. Replace the coolant tank into the stand, guiding the power cord out the back.
20. Route and plug in the power cord.
21. Replace the coolant catch drawer.
22. Replace the coolant by pouring it into the stand's catch trays.

Item	Qty	Description
1	2	O-ring, 1/6" wide, 1/2" ID
2	2	Bulkhead male elbow, SMC KQ2LE07-00
3	6"	Tubing, 1/4" OD nylon, soft nylon or polyurethane



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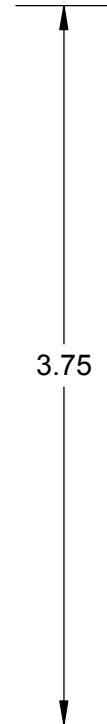
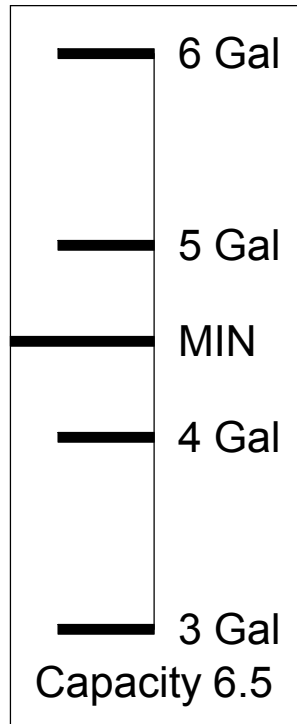
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