

ALL PURPOSE CNC/HEAVY DUTY

Rotary Phase Converters
240 VOLT SERIES



AD and ADX SERIES

Operation & Installation Manual

DANGER: HIGH VOLTAGE
Electric shock could result in death or injury. Please consult qualified personnel for installation.

DANGER: Risk of Electric Shock
Please wait 30 minutes before servicing

This manual is to serve the purpose of providing recommendations for proper performance, but is not to supersede or replace local or national electric codes. Installation should be done by a licensed electrician who is familiar with phase converter installations.

WARNING! READ BEFORE STARTING CONVERTER!

If this phase converter does not start in less than 2 seconds, **TURN IT OFF!**

1. Make sure the wire size meets our minimum recommended size.
2. All loads INCLUDING TRANSFORMERS must be DISCONNECTED before starting the phase converter each time. This includes small control transformers that run controls inside your equipment. If you need an economical 3-phase disconnect switch, please visit www.AmericanRotary.com or call 1-888-743-6832 for assistance.

If your converter still takes more than 2 seconds to start, call our Toll-Free Technical support line 1-888-743-6832. You will be asked to verify conditions 1 and 2 above are met. Failing to meet these two condition account for 99% of starting problems and can result in damage to the starting capacitors.

This converter is quiet. If it does not sound quiet and smooth, **TURN IT OFF!**

3. Make sure the idler motor is mounted on rubber. **DO NOT BOLT THE IDLER MOTOR DOWN!** This can cause bearing failure.
4. Make sure the idler motor is wired properly.

For the American Rotary/Baldor soft-start idler motor
240 Volts Input (1,7,A), (2,8,B), (3,9,C), (4,5,6 bolted together and insulated)

5. This phase converter does NOT disconnect the single phase power as it passes through the unit, so the single phase legs remain energized even when the rotary phase converter is off. In addition to installing a single phase breaker in front of the phase converter, you need to be aware that the single phase power DOES flow through the phase converter whether the unit is on or off.

For a stock three-phase motor that uses our Stock Motor Panel, wire the motor according to the diagram for that motor, **NOT** according to our wiring diagram.

- * Make sure the Phase Converter Panel, the Idler Motor, and your equipment is grounded!
- * If this phase converter does not start in less than 2 seconds, **TURN IT OFF!**

OVERVIEW

Congratulations on your purchase of a state of the art American Rotary rotary phase converter. American Rotary along with Baldor Electric have created the ultimate Idler / Generator to provide balanced voltage and a voltage boost for extra starting torque. Our super quiet idler reduces its in-rush starting current by about 75%. The American Rotary / Baldor Idler is the ultimate in flexibility and smooth true sine-wave power.

All American Rotary rotary phase converters provide the voltage balance and true sinusoidal 3-phase AC output that many of today's modern machines require. Our control panel has been engineered to exceed UL, CSA, & NEMA standards. We offer the easiest installation in the industry with straight line runs, terminal block connections, built-in starter, power guard restart protection, and no stress capacitor mountings. Rotary phase converters can be operated from almost any single phase 240 VAC power source that has adequate current carrying capacity. They can operate any type of equipment that requires 3-phase 240 VAC.

KEY FEATURES AND CONSIDERATIONS

- Current limiting soft starting idler / generator made exclusively by Baldor
- Built-in starter (on models purchased with starters) with power guard restart protection
- Pushbutton start with raised safety OFF button
- Virtually zero harmonic content
- Industrial Control Circuit - the single phase power remains on even when the rotary phase converter is in the off position, allowing you to activate any single phase control circuits, DRO's or other single phase features on your three phase equipment
- Balanced voltages for voltage sensitive equipment
- Convenient terminal blocks for easy connections
- Separate control panel and Idler / generator for optimum space saving installation
- Built in power factor correction
- Loads can be located a large distance from the converter.
- American Rotary rotary phase converters should be wired by an experienced and qualified electrician into a 208V – 250V AC single phase circuit with proper breaker protection.
- American Rotary rotary phase converters can run any type of load, resistive, inductive, multiple motor, and in any combination and or number.
- Best warranty in the industry 5yr/lifetime.

American Rotary Advantage



AD & ADX Panels Only

All American Rotary AD & ADX rotary phase converter control panels are warranted against defects in material and workmanship for a lifetime. The American Rotary Baldor Idler / Generator is covered by Baldor's 2 year warranty. The rotor is warranted for lifetime against defects in material and workmanship to the original owner. Warranty is from the date of purchase by the original owner. American Rotary will repair or replace (at our option), at no charge, any part(s) found to be faulty during the warranty period specified. The control panel warranty repairs must be performed by/at American Rotary's facility. Baldor Idler repairs or replacements must be performed by/at American Rotary's facility, or at a Baldor Authorized Service Center. Baldor Idler repairs or replacements must also be pre-authorized in writing by American Rotary.

Obligations of the Original Owner

1. Product Registration Required within 30 days of original purchase
2. The original Bill of Sale must be present in order to obtain "in-warranty" service
3. Transportation of control panels to American Rotary is the responsibility of the original purchaser. Return transportation is provided by American Rotary when the control panel is "in-warranty"
4. American Rotary will not accept Baldor Idler returns or repairs sent to American Rotary. All Baldor issues are handled by Baldor Authorized Service Centers.

Exclusions of the Warranty

This warranty does not cover any of the following: accident, misuse, fire, flood, and other acts of God, acts of terrorism, nor any contingencies beyond the control of American Rotary, including water damage, incorrect line voltage, improper installation, installation where this unit will not meet local electrical codes, missing or altered serial numbers, and service performed by an unauthorized facility. American Rotary's liability for any damages caused in association with the use of American Rotary's equipment shall be limited to the repair or replacement only of the American Rotary's equipment. No person, agent, distributor, dealer, or company is authorized to modify, alter, or change the design of this merchandise without express written approval of American Rotary.

Liability Limitation: In no event shall American Rotary be liable or responsible for consequential, incidental or special damages resulting from or related in any manner to any American Rotary product, third party installation(s), manufactured or distributed, or parts thereof. A licensed electrician must perform all installations. Not all American Rotary phase converters are UL listed, this is an option the customer must specify and additional charges will apply. American Rotary is not responsible for meeting, complying with or insuring installation inspections. American Rotary does not accept returns on units that have been installed or energized.

INSTALLATIONS MUST COMPLY WITH ALL NATIONAL AND LOCAL ELECTRICAL CODE REQUIREMENTS AND MUST BE INSTALLED BY A QUALIFIED LICENSED ELECTRICIAN. CUSTOMER IS RESPONSIBLE FOR MAKING SURE THIS PHASE CONVERTER CAN PASS INSPECTION WHERE INSTALLED.

PRODUCT RETURN POLICY

This policy covers the return of GENTEC/American Rotary products (excluding Warranty returns, which are covered by a separate policy). Under this policy, original Purchaser may return product to GENTEC LLC with its **PRIOR APPROVAL***, for credit under the following terms and conditions:

Product MUST BE in its original UNOPENED, UNMARKED carton.

Any product whose carton has been opened (seal broken), installed, or has been marked on in any way is not considered suitable for resale, and will not be accepted for credit.

Customers must return the product to the GENTEC/American Rotary warehouse, freight prepaid. The product carton should be packed in the same condition as it was shipped, with adequate protection from damage. Upon receipt, the product will be inspected, tested, and evaluated. If the package is found not to be in “as-new” resalable condition, the customer will be notified, and will be offered the option of having the product returned to them, freight collect.

Valid returns will be credited the original purchase price **minus a restocking charge of 25%, or a minimum of fifty dollars (\$50). In addition, the price of any replacement parts will be subtracted. Modified Stock will be subject to a 50% restocking charge plus the price of any replacement parts. These products are defined as items that have been upgraded from our standard product line such as, but not limited to, Nema 3R, TEFC, UL, 480V. Custom products are not returnable.**

Valid Returns

The unit must have been purchased within forty five (45) days of the date it is received by GENTEC/American Rotary. Only products sold by GENTEC/American Rotary through its North American sales network are eligible for this program.

*PRIOR APPROVAL: Contact a GENTEC/American Rotary representative with pertinent details to obtain an RMA number and shipping instructions.

This form must be signed, dated, and faxed to our company headquarters before credit is issued. FAX (262) 402-6438

I have read and agree to all of the terms of the above mentioned product return policy:

Signed _____ **Date** _____

Single-Phase Input from Main Utility Supply Panel

(disconnect & overload circuit protection provided by others. Check local & NEC codes)

Three-Phase Output

(Output voltage equals input voltage)

General Installation Notes:

- Single phase service should be sized to a minimum of 6 amps per HP of load.
- Do not bolt Idler/Generator to floor or any rigid structure.
- Disconnect all three output lines if complete electrical isolation is needed.
- T3 to ground may measure between 190 and 230 volts.

A(D,R,B) Series Rotary Phase Converter
(factory installed starter)

Wiring Notes:

1. This diagram does not replace or supersede any requirements of local, state or national electric codes.
2. National Electric Code (NEC) requires single phase branch circuit to be sized to 250% of the 3-phase load current.
3. All equipment controls should be hooked up to L1/T1 & L2/T2.
4. Ground the idler/generator, control panel, and load.
5. Size the wire from the converter to the 3-ph. load a minimum of load to 1.5 x the largest motor's full load current.
6. To approximate the 3-ph. current at 240 volts, multiply the HP of the 3-ph. load by 2.5
7. Converter output 3-phase is three-wire delta.
8. Terminals A and B are for Idler only.

Converter Selection & Load Chart (208-240 volts)

Model No.	Largest Motor Start HP				Max. Total HP (amps)	Max. Total CNC HP (amps) (series D&R)	Min. recommended wire ^{1,2}		Panel to idler wire gauge
	Easy	Medium	Hard	Locked Rotor ³			1-phase input	3-phase output	
A-03	2.5	2	1.5	1	3 (10)	1.5 (4)	10	12	12
A-05	4	3	2.5	2	7.5 (22)	2.5 (6)	8	12	12
A-07	5	4	3	2.5	11 (31)	3 (9)	8	10	12
A-10	7.5	6	5	3	15 (42)	5 (15)	8	10	12
A-15	10	10	7.5	5	22 (60)	7.5 (22)	6	8	10
A-20	15	12	10	7.5	30 (80)	10 (28)	4	6	10
A-25	20	15	12.5	8	38 (95)	12.5 (35)	2	6	8
A-30	25	20	15	10	45 (113)	15 (42)	1	4	8
A-40	30	25	20	15	60 (150)	20 (54)	1/0	3	6
A-50	40	35	25	20	75 (182)	25 (68)	3/0	2	4
A-60	50	40	30	25	90 (225)	30 (80)	4/0	1/0	3
A-75	60	50	37.5	30	112 (281)	37.5 (94)	250	2/0	2

¹ conductors listed are min. recommended based on largest hard starting & CNC amps.

² for combined load HP's greater than 50% of Max. Total HP listed in the table above, consult NEC & local codes for conductor sizing.

³ Submersible pumps, Air Compressors, Flywheel loads, Blowers etc. Equipment that have heavy loads at zero or low RPM's.

NOTES:

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American Rotary

Connection Diagram for A(D,R,B) Series Rotary Phase Converter

American Rotary

N59W16600 Greenway Circle, Menomonee Falls, WI 53051

AmericanRotary.com

888.743.6832

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1. INTRODUCTION

American Rotary specializes in converting Single Phase electrical power to Three Phase electrical power. The diagram below provides a very simple view of the layout.



An additional 3-phase breaker panel may be installed on the line between the converter control panel and the 3-phase equipment. This is recommended to protect each piece of equipment and the wire that feeds that equipment.

The two single phase lines pass through the phase converter and are used to manufacture the 3rd line that completes the three phases. The output voltage will always be close to the input voltage. If a completely different voltage is needed then a transformer installed in front of the phase converter will be necessary.

The three-phase output is delta configured. Phase to phase voltages are similar to the input voltage, but phase to ground voltages are not all equal. When the two pass through lines measured to ground measure 120v, the third manufactured line will measure approximately 208v to ground. This voltage may vary widely depending upon load conditions. Most machinery requires a delta three phase voltage and this third line voltage to ground should not affect operation. If a piece of equipment requires a wye voltage and requires a neutral connection, the output of the phase converter must be run through a delta-wye transformer to create the neutral. The phase converter must be started before the transformer is connected electrically. This is done with a safety disconnect switch. American Rotary supplies these transformers and disconnect switches.

2.0 INSTALLATION

2.1 PHYSICAL INSTALLATION

All American Rotary rotary phase converters come standard in NEMA 1 indoor rated enclosures. NEMA Type 3R rainproof enclosures are available. If the idler/generator is to be located outdoors, you should consider a TEFC idler/generator. The control panels should be mounted securely on a vertical surface. The Idler / Generators should be mounted on a clean flat surface.

2.1.1 PHYSICAL INSTALLATION ENVIRONMENTAL CONSIDERATIONS

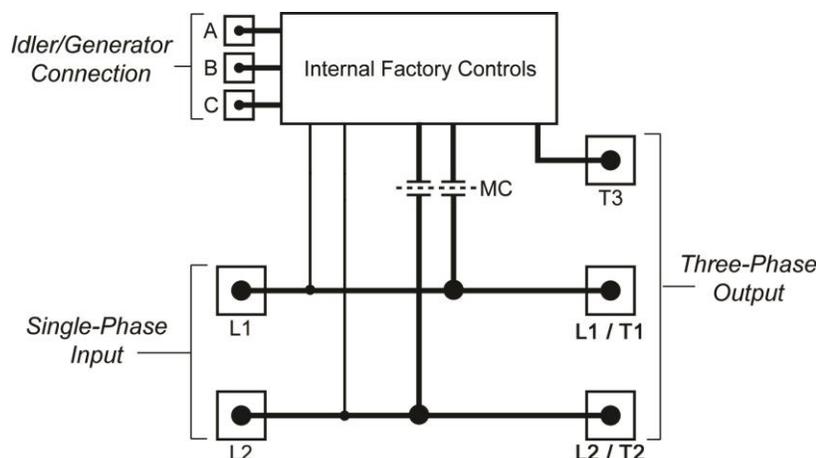
The unit should be installed in a location free from the following:

- Dirt
- Corrosive gases or liquids
- Excessive vibration
- Airborne particles (particularly metal particles)
- Ambient temperatures exceeding 50 degrees C
- High humidity

American Rotary offers both wall mount and floor mount control panel locations. In either case, to minimize heat and vibration in the control panel be sure to use proper isolation mounts on the idler/generator. The Idler can be mounted in an elevated position to help reduce the introduction of dust and foreign contaminants into the windings. TEFC idlers need to be protected from dust buildup on the outside of the motor. This can lead to overheating.

2.1.2 INSTALLATION GUIDELINES (CONTROL PANEL & IDLER)

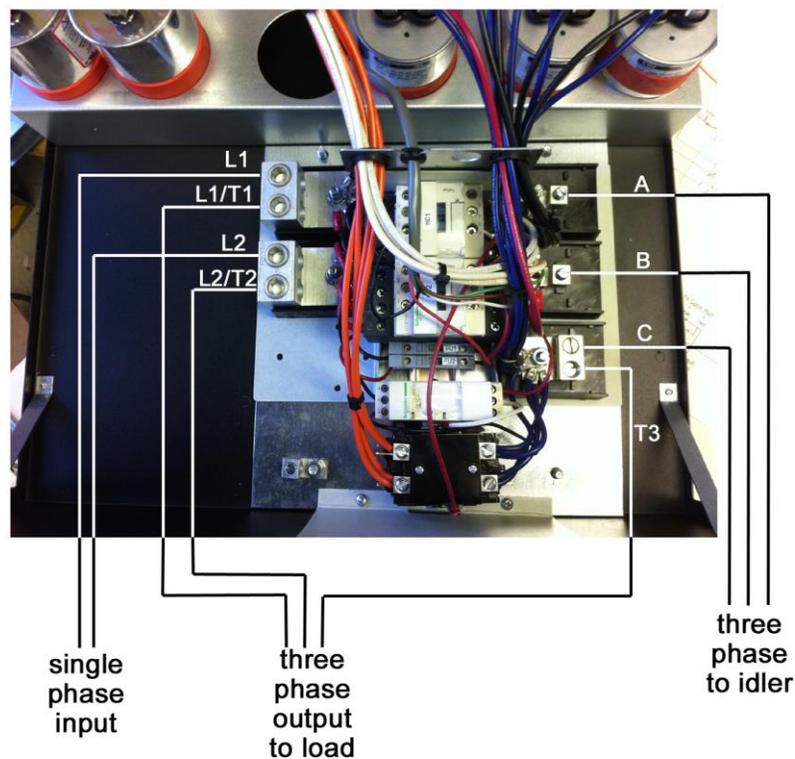
The following diagram shows the electrical schematic for the rotary phase converter.



Note: as you can see in the electrical schematic diagram, the single phase input power flows directly through the unit to the appropriate terminals on the three phase output side (L1 and L2.)

Steps to install the control panel and idler:

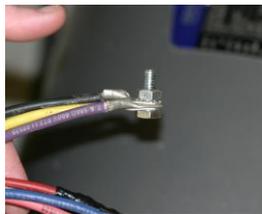
- a. Mount enclosure on a secure wall or on the idler (unitized or floor mount models only.) Attach conduit fittings for single phase input line, 3-phase line to idler and 3-phase line to load.
- b. Pull electrical lines into the enclosure. Be sure to pull enough wire for your load to reach the two terminals on the left side (L1 & L2) plus the terminal on the right side (T3) of the phase converter controls. Run the ground lines with each circuit.
- c. Connect the single phase input lines to the terminals marked L1 and L2.
- d. Connect the lines to the idler/generator to the terminals marked A, B and C.
- e. Connect the three phase output lines to the terminals marked L1/T1, L2/T2, and T3.



Firmly snap in the green, yellow and red switch terminals into the pushbutton switch body. (In the image at right, a clear enclosure cover is used for clarity.)



- f. Wire the idler. Bolt idler leads 4, 5 & 6 together. Insulate this connection with electrical tape or heat shrink tubing. Connect the ground line to the ground screw inside the motor conduit box. Connect terminal A to (1,7), terminal B to (2,8) and terminal C to (3,9). Insulate these connections separately. Hardware for these connections is provided.



2.1.3 GENERAL WIRING CONSIDERATIONS

- Follow all local, state and national electric codes (NEC)
- ***T3 is the manufactured line; DO NOT use T3 for any single phase loads***
- Protect all wire and machinery with proper size breakers
- Always make sure rotary phase converter starts before external load(s)
- A qualified electrician should do all wiring.
- DO NOT assume that a breaker box neutral is a ground! Be sure to ground all equipment including breaker boxes, phase converter control panel & Idler, disconnect switches, transformers, loads etc.
- L1/T1 & L2/T2 measured to ground will produce half the single phase input voltage, but T3 to ground will NOT.
- Run all controls from lines L1/T1 and L2/T2.
- See Wire Sizing Recommendations (section 2.1.4) for wire sizes. This is VERY IMPORTANT, as under sizing the wire may lead to a phase converter that does not start or work properly.

2.1.4 WIRE SIZING RECOMMENDATIONS

It is important to have adequate single-phase electrical service. The actual single phase current that will flow through the converter is approximately 1.73 times the three-phase current. The National Electric Code requires 2.5 times the three-phase load current to allow for starting current and a margin of safety. This is a good conservative calculation to determine your single phase branch circuit wire size and breaker size.

This means that with a 240 volt supply, a 10 hp machine that runs near full load (28 amps) will need approximately 44 amps of single phase current. N.E.C. requires (28 amps x 2.5 = 70 amps) of single phase. Therefore wire should be used that can handle at least 70 amps and the breaker should protect that wire. Multiply this current by the voltage (in this case 240 volts) to get the kW or kilowatts of 16.8 kW. The transformer that supplies your power must be at least this big.

The power required to run the phase converter is very small and is negligible in figuring out the power required. The power required is calculated based on the load only.

Motor loads can be estimated at approximately
2.6 amps per horsepower at 230 volts.
2.5 amps per horsepower at 240 volts
2.9 amps per horsepower at 208 volts

Size the wire going to a load for the Converter's maximum 3-phase current if the converter is sized to run and start that particular load. Example: a 10 hp lathe would normally need a 20 hp converter to start and run it. Size the wire going to the 10 hp lathe to 54 amps (the max current for a 20 hp converter). This will aid in the starting of the converter and insure that a power reducing voltage drop will not occur.

Wire can never be sized too large, but too small of wire can impede performance and even keep the converter from starting properly.

Increase wire size one size for every 50 feet of run and round up.

3.0 OPERATION & MAINTENANCE

3.1 STARTING & STOPPING

Every American Rotary phase converter (purchased with a starter) is started by pushing the momentary start push button. The starting sequence is automatic and the button needs only to be pushed in and released, it does not need to be held in. Stopping the phase converter is done in a similar manner, by pushing the stop push button. As with most electrical equipment, frequent stops and starts are harder on the rotary phase converter than steady operation. The rotary phase converter is extremely low cost to operate at idle (with no three-phase load), and this is preferable to a high level of stopping and starting. If your load situation dictates that the rotary phase converter must be started and stopped frequently, call us about our On Demand with Delay Off kit for optimum product operation.

3.2 CHECKING VOLTAGES

Measuring Voltage is the easiest way to test to see if the phase converter is working properly. When voltages are balanced on the three 3-phase lines, currents are balanced. Measuring current is more difficult as there are different types of current present in the running phase converter.

Voltage Measurements:

Note: voltage balance is calculated by first averaging the three 3-phase voltages. This is done by adding the three voltages and dividing by 3. Then take the lowest of the 3 voltages and divide it by the average voltage and multiply by 100.

Note: voltage measurements from a 3-phase line to ground IS NOT a meaningful measurement. For the following discussion the L1/T1 terminal and L2/T2 terminal will be described simply as T1 and T2, for simplicity. If your equipment is grounded, T1 and T2 to ground will be approximately 120 volts, but T3 to ground can read any voltage.

Example: (T1-T2 = 242) (T1-T3 = 253) (T2-T3 = 251)

The average is $(242+253+251)/3 = 248.6$ volts

The imbalance on T1-T2 is $100 - (242/248.6) \times 100 = 2.7\%$

Note: the single phase line is considered to be imbalanced as well. In other words, don't use the single phase line as the benchmark for balance; use the average as shown above.

The imbalance on T1-T3 is $100 - (253/248.6) \times 100 = 1.7\%$

The imbalance on T2-T3 is $100 - (251/248.6) \times 100 = 1\%$

Measure L1 to L2 (T1 to T2)	This is your single phase voltage as supplied from the utility. The converter does not have to be running to measure this voltage.
Measure L1/T1 to T3	This is the voltage between the manufactured line (T3) and one of the single phase lines. This voltage should be up to 13 volts higher than the T1 to T2 single-phase voltage. 13 volts is about 5%.
Measure L2/T2 to T3	This voltage is the least important. It should also be within 5% or about 13 volts. This voltage will drop when a load is applied.

When the load is applied, this voltage will drop. Ideally it will only drop to 5% below the average of the 3-phase voltages. If needed, adding motor run capacitors across the T1-T3 or T2-T3 lines can increase these voltages.

If your load motor runs backwards, reverse the two single-phase carry through lines T1 and T2 at the motor that needs reversing. If these lines are switched going to the idler, then the direction of all equipment will be reversed.

3.3 GENERAL MAINTENANCE

The rotary phase converter may operate continuously with or without a load. The converter will run cool and quiet in the no load condition because the voltages are well balanced.

1. Never start the converter with a load applied (including transformers)
2. The converter should start within a second or two. Wait to start loads (including transformers) until the converter reaches full speed. A timer circuit can be used to automatically start loads after the converter reaches full speed.

3.3.1 MAINTENANCE

Keep dust and moisture from the control panel and the idler. Keep dust from accumulating in the motor. Dust can be blown out using compressed air. Keep dust from accumulating on the surface of a TEFC model as this prohibits proper cooling.

3.3.2 LUBRICATION

American Rotary rotary phase converter idler/generators are custom made and come with pre-packed lubricant specifically designed for the bearings. Exxon Polyrex EM high temperature bearing grease or equivalent polyurea lubricant is recommended for the Baldor Idlers.

DO NOT use Lithium based lubricants. These may cause premature bearing failure and will void any warranty.

Be careful not to force so much grease into the bearings that the excess finds its way into the windings of the idler. Some idlers have sealed bearings and will never require greasing. If the idler has grease fittings located on the end bells of the idler, use the chart below for a greasing schedule.

Frame	HP Range	Hours running	Grease Type
Up to 210	3-5	12,000	Polyrex EM
210-280	7.5-20	9,500	Polyrex EM
280-360	25-50	7,400	Polyrex EM
>360	60 & 75	3,500	Polyrex EM

4.0 TROUBLE SHOOTING

Questions/Problems	Answer
1. Machine does not seem to have enough power to start	A, B, C, K, M,
2. Converter does not start. It makes a growling sound	B, C, D, E, N, M
3. Converter does not start. Absolutely nothing happens.	C, D
4. Converter does not have a smooth quiet sound	D, F
5. My machine runs backwards	E, H
6. I blew a start capacitor on start-up	O, N
7. The idler has a squealing noise	F, G
8. The idler is very hot	G
9. My machine has contactors that are clicking or lights that are flickering	H
10. My CNC machine kicks out when I start the spindle	H, I
11. My voltage is too high	J
12. My voltage is too low	K
13. My voltage balance is not as good as I want	E, J, K
14. I measure 120 volts from T1 and T2 to ground, but not from T3 to ground	L
15. My Idler generator motor makes a ringing noise	P

- Answer A: Check to make sure your converter is big enough. If not, a second converter of equal size can be installed in parallel to your converter to double its size. Ask us about our Autolink.
- Answer B: Make sure your wire is big enough. Use the minimum wire size on the front of this page. Go up at least one size for every 50 feet of run. Wire may need to be upsized for hard loads.
- Answer C: Check the connections. L1 and L2 are the single phase input and should measure 240 volts from line to line. These lines measure 120 volts line to ground.
- Answer D: Check to make sure the idler is hooked up for low voltage (208-240 volts). Make sure lines 4, 5 & 6 are electronically tied together and then insulated.
- Answer E: By switching any two of the three output lines to the idler, the direction can be reversed. Trying different combinations of A, B and C will result in a slightly varying voltage balance.
- Answer F: Although small, the vibrations caused by the idler can resonate depending on how it is mounted. Never bolt the motor to a rigid structure. Visit www.AmericanRotary.com
- Answer G: The GENTEC/BALDOR idlers are rated up to 150° C. It may be normal for them to run hot. High current on one or more lines may also cause them to run hot. A good voltage balance means a good current balance.
- Answer H: All controls should be run from T1 and T2 (the single phase lines). These lines do not fluctuate voltage as much as T1 to T3 or T2 to T3. If your machine does not have these clearly marked, try different combinations of T1, T2 and T3
- Answer I: You are probably getting a low voltage error. Slow the acceleration down on the spindle in order to reduce the inrush current.

- Answer J: First check your single phase input voltage. The phase converter output voltage is based on the single phase input voltage. To lower your voltage, remove run capacitors from across T1 to T3 and or T2 to T3. Call American Rotary for assistance.
- Answer K: First check your single phase input voltage. The phase converter output voltage is based on the single phase input voltage. To raise your voltage, extra capacitors can be added across T1 to T3 and or T2 to T3. Call American Rotary for assistance.
- Answer L: T3, the manufactured line references a floating ground. Voltage from T3 to ground usually is between 190 and 220 volts. This is correct. The output of a phase converter is a Delta three phase voltage. If a neutral or 120 volts to ground is needed from all three lines, a Delta-Wye transformer is needed. American Rotary stocks the correct transformers for this.
- Answer M: You may need bigger service. Everything may be big enough on your end, but sometimes the power company's transformer is not big enough. Call your power company for service.
- Answer N: Adding start capacitors can help get a motor started. Please contact American Rotary for help.
- Answer O: Blowing a start capacitor is a result of too frequent starts, or having a load on when starting. Make sure all loads are disconnected when starting including transformers.
- Answer P: Check and tighten the bolts on the conduit box and all 4 through bolts on both end bells.



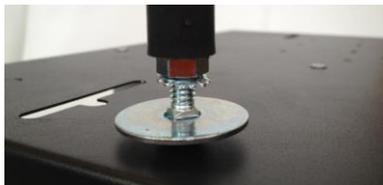
1. This is what the idler will look like once the brackets are installed, using the nylock nuts provided. Adjust brackets so that the top surfaces of the brackets are parallel to each other and level with the ground. Remove all lift rings. **You may need to adjust idler thru bolts before mounting bracket.**



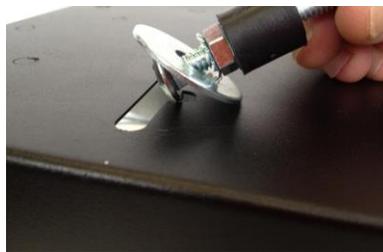
2. When installing brackets on Rotary Phase Converters 3HP – 15HP, four extra nuts are provided. These bolts need to be installed as shown here to protect the idler from the brackets.



3. Locate the 4 slotted knockouts on the bottom of the control panel enclosure. Be sure to completely remove the remnant strip. If remnant strip drops into enclosure, maneuver enclosure until



4. Assemble carriage bolt, washer and rubber isolation mount as shown in picture. Thread rubber isolation mount onto carriage bolt with **ONLY ONE** rotation.



5. Tilt carriage bolt on an angle to slide into notched part of knockout.



6. Slide each mounting bolt to approximate position in each slot. Loosely tighten lock nut and rubber isolation mount so adjustments can be made.



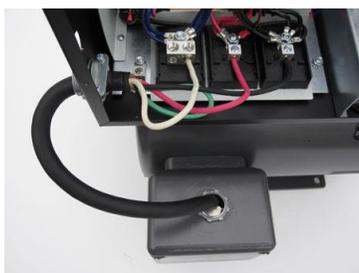
7. This is how the unit will look once the panel has been mounted.



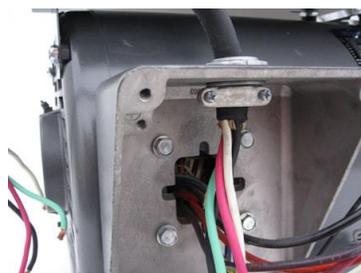
8. Tighten top nut to prevent sliding. Thread the rubber isolator all the way to the lock nut.



9. Insert 1/4" washer and lock nut onto the isolator stud and tighten.



10. The supplied idler cable has ring lugs at one end, which go to the idler. The other end goes to the panel. Refer to main installation manual when making these connections.



11. Showing the connections at the idler.



12. Showing the connections at the panel.