

**Teknatool International Limited**

4499 126<sup>th</sup> Ave N  
Clearwater, FL 33762  
727-954-3433

Email: [service@teknatool.com](mailto:service@teknatool.com)

Website: [www.teknatool.com](http://www.teknatool.com)



## Frequently Asked Questions

Date Raised: 23-Aug-22

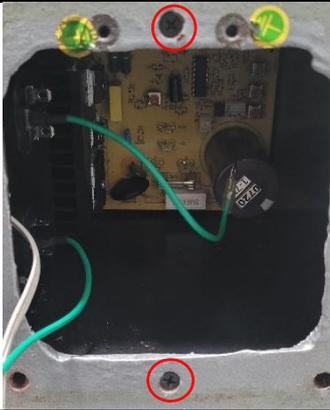
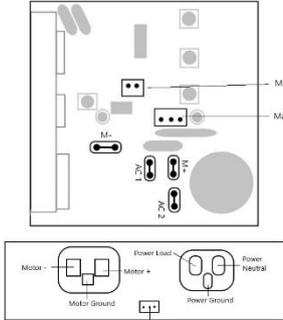
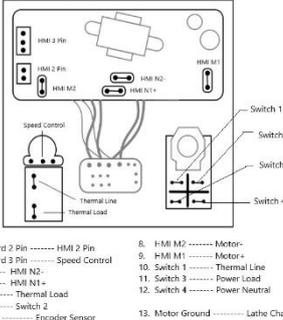
Safe practices should always be employed to ensure the Health and Safety of yourself, employees and customers (if applicable) Refer to product manuals, exploded drawings and our website if further assistance is required, or contact us on [service@teknatool.com](mailto:service@teknatool.com)

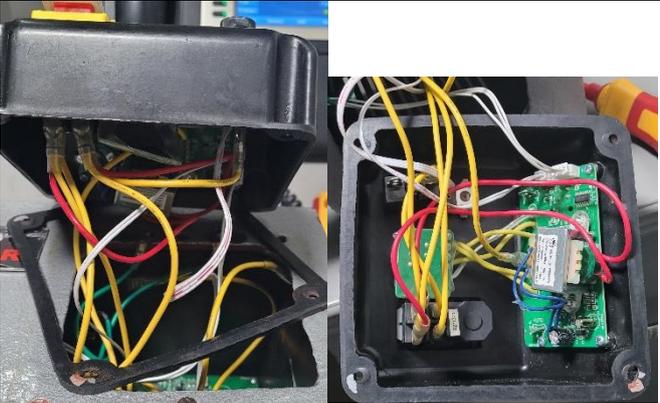
Date Amended

Tools Needed: Phillips Screwdriver, Needle Nose Pliers (Optional)

**Procedure:**

Step No.	Description	Image
1.	Remove power from the controller	
2.	Remove HMI portion of controller by removing the 4 screws holding it on	
3.	Remove 2 ground wires	
4.	Separate the HMI from the controller by removing the wires from the control board	

<p><b>5.</b></p>	<p>Remove the 2 screws holding in the control board assembly</p>	
<p><b>6.</b></p>	<p>Remove the controller from the bed of the lathe and remove the motor power from the housing.</p>	
<p><b>7.</b></p>	<p>Plug the motor into the new controller and re-attach the controller to the lathe bed with the 2 screws that you removed in step 5.</p>	
<p><b>8.</b></p>	<p>Re-attach the 2 ground wires to where they were in Step 3</p>	
<p><b>9.</b></p>	<p>Using the wiring diagram at the end of this FAQ, reconnect the wires to the proper locations. It may be easier to remove the wires from the HMI to plug them into the control board and then re-attach to the HMI. Needle nose pliers may also be useful.</p>	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p><b>Main Board</b></p>  </div> <div style="text-align: center;"> <p><b>HMI / Control</b></p>  </div> </div> <ol style="list-style-type: none"> <li>1. Main Board 2 Pin ----- HMI 2 Pin</li> <li>2. Main Board 3 Pin ----- Speed Control</li> <li>3. M- ----- HMI N2-</li> <li>4. M+ ----- HMI N1+</li> <li>5. AC 1 ----- Thermal Load</li> <li>6. AC 2 ----- Switch 2</li> <li>7. HMI 3 Pin ----- Encoder Sensor</li> <li>8. HMI M2 ----- Motor-</li> <li>9. HMI M1 ----- Motor+</li> <li>10. Switch 1 ----- Thermal Line</li> <li>11. Switch 3 ----- Power Load</li> <li>12. Switch 4 ----- Power Neutral</li> <li>13. Motor Ground ----- Lathe Chassis</li> <li>14. Power Ground ----- Chassis</li> </ol>

<p><b>10.</b></p>	<p>Slide the gasket over the HMI</p>	
<p><b>11.</b></p>	<p>Re-attach the HMI to the bed and back part of the controller with the screws removed in step 2</p>	
<p><b>12.</b></p>	<p>Plug power back into the controller that was removed in Step 1</p>	

