



BEND-TECH, LLC.

Quality software & machines developed and manufactured in USA

Grounding With Dielectric Grease.

In lieu of using your machine's grounding brushes for grounding the plasma torch current, we have had great success grounding the current to the rear pillow block bearing for the chuck spindle and using dielectric grease injected into the bearings (located inside of your machine's chuck housing). This guide will assist you in making the necessary changes to allow for this method of grounding.



Purchase 1 tube of Super Lube Silicone Dielectric Grease. Available here:
<https://www.grainger.com/product/SUPER-LUBE-White-Silicone-Di-Electric-44N728>

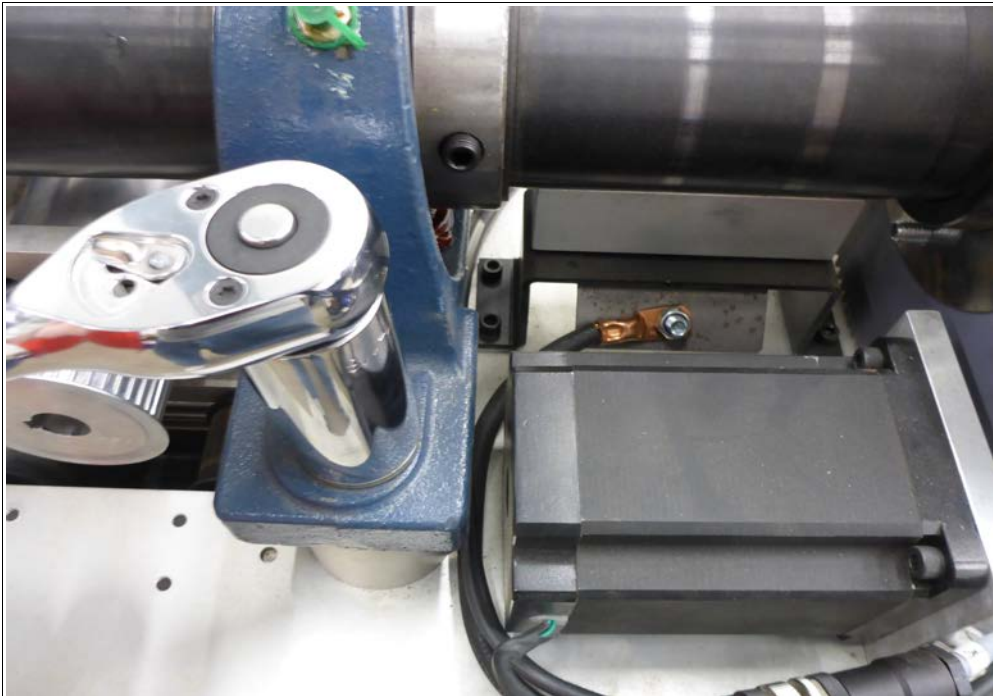
You should also have a grease gun/pump to inject this dielectric grease directly into the machine's rear pillow block according to page 4.

Make sure your Dragon machine is turned OFF at this time.

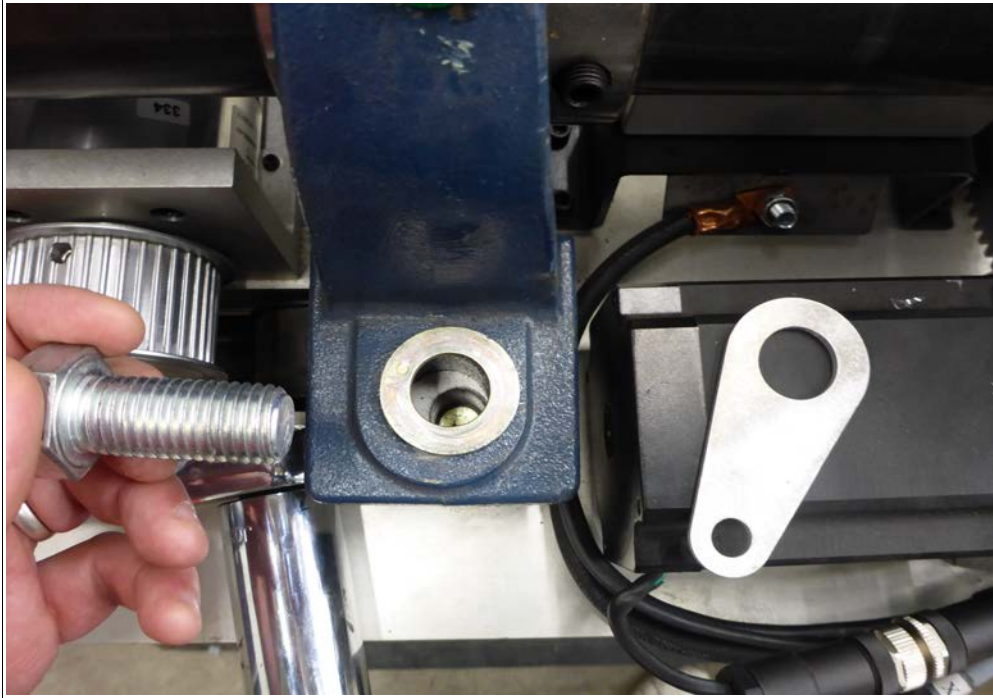
1. Remove the chuck housing from the chuck trolley by first removing the 1/8" bolts from the bottom side (x16) all the way around the housing, then removing either the front or rear panel (x10). Disconnect the DC plug inside leading to the E-stop button, then carefully lift the housing off the trolley.



2. With the chuck spindle revealed, use a ratchet with a 3/4" socket to remove the rear pillow block bolt nearest the rotational motor (Y) as shown.



3. You will need a tab made up, or requested from us that is the same width of the washer underneath the pillow block bolt. This tab will be used instead of the washer.



4. Using a 5/16" socket with an extension, remove the bolt securing the grounding cable to the carbon brush mount. (The nut on the underside requires a 1/2" wrench to assist in removing this).



5. Using a small amount of dielectric grease in between the bolt and nut used to mount the grounding cable, connect the cable to the small side of the tab as shown.



6. Use a grinder to shave off the paint at the pillow block bolt hole so that the tab can make metal to metal contact when mounted.



7. Coat this mounting location with a liberal amount of dielectric grease before securing the tab.



8. Secure the tab to the pillow block with the 3/4" bolt and make sure that the cable and tab are angled forward so that the chuck cover can be mounted back onto the trolley when finished.



9. Using a grease gun/pump, fill the rear pillow block bearing with the dielectric grease to complete the grounding conversion process.



10. Finish up by re-connecting the chuck trolley housing making sure to plug in the DC connector plug for the Emergency Stop button at the top of the housing.



Thank you for reading this helpful guide.

**If you have questions or concerns please contact a Bend-Tech representative using
the information provided below.**



Bend-Tech Dragon Support Team
Bend-Tech LLC.
1-651-257-8715
support@bendtechdragon.com
support@bend-tech.com
<http://www.bendtechdragon.com>

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