

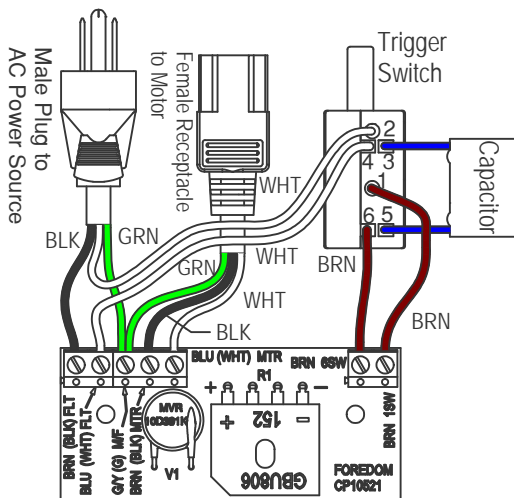
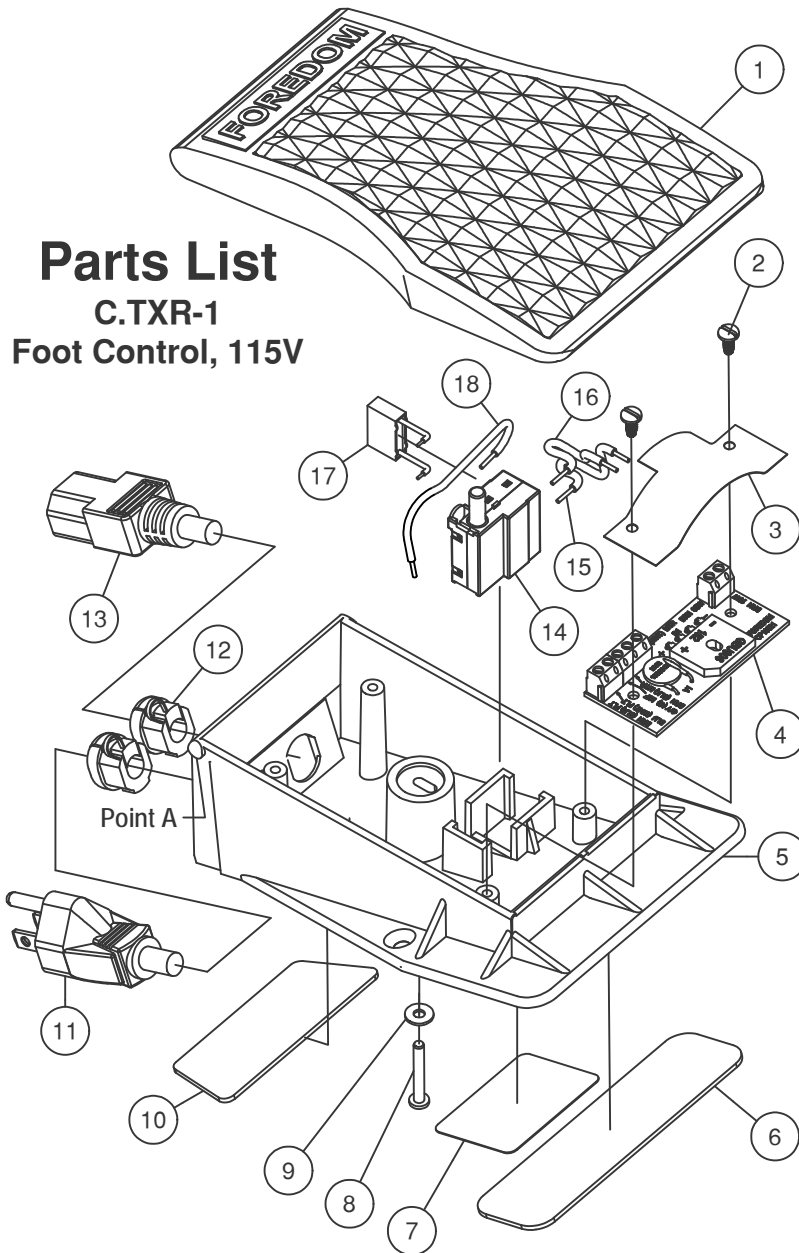
Instructions for Removing and Replacing Trigger Switch

Disconnect Foot Control from Motor and Wall Outlet.

- A. Unscrew Cover Adjustment Screw (8).
- B. Using flat blade of screwdriver inserted at **Point A** between Cover (1) and Base (5), carefully pry Cover off.
- C. Remove Trigger Switch (14) from Base mounting bracket. Remove AC Male Plug white wire from circuit board screw terminal.
- D. On older Switches, all the terminals will be push-in, spring clamp type. On newer Switches, some terminals have screw fasteners. To remove wires from the push-in terminals, insert 1.3mm [.05in] approximate diameter pin or the blade of a jeweler's screwdriver all the way into the terminal socket, to release the spring clamp. Grasp the tool and wire and pull them together out of the socket. If you have difficulty removing the wires from the push-in terminals and you have wire-cutting, stripping, and soldering tools, you can cut the wires off where they exit from the terminals. To prepare the cut wires for installation into the replacement Switch, strip them back exactly 8.25 mm [5/16 in]. For the wires to be inserted into push-on terminals only, apply solder to the stripped ends to fuse the strands together. **DO NOT** solder wire ends to be inserted into screw terminals.
- E. **Connect Wires to New Trigger Switch and Circuit Board Terminal Block as shown in the Wiring Diagram.** Push wires all the way in, so that no bare wire is exposed. For Screw Terminals 1 and 2, push the wire leads all the way into the socket, then tighten the screw firmly. For Push-on terminals 4 and 6, push the wire leads all the way in. Simultaneously push the Capacitor Leads all the way into terminals 3 and 5. Pull on all the wires, making sure they are secure. Place Switch back into the Base mounting bracket.
- F. Position wires around adjustment screw post so wires will not interfere with cover travel.
- G. Snap cover (1) onto hinge posts on top of rear corners of base (5).
- H. Insert adjustment screw (8) through washer (9) and into post slot and threaded insert in cover (1). Tighten with screwdriver until cover is just touching the trigger switch pushrod. **Do not tighten the screw further** to avoid pressing the Switch Pushrod into a permanently "on" position.

Parts List

C.TXR-1
Foot Control, 115V

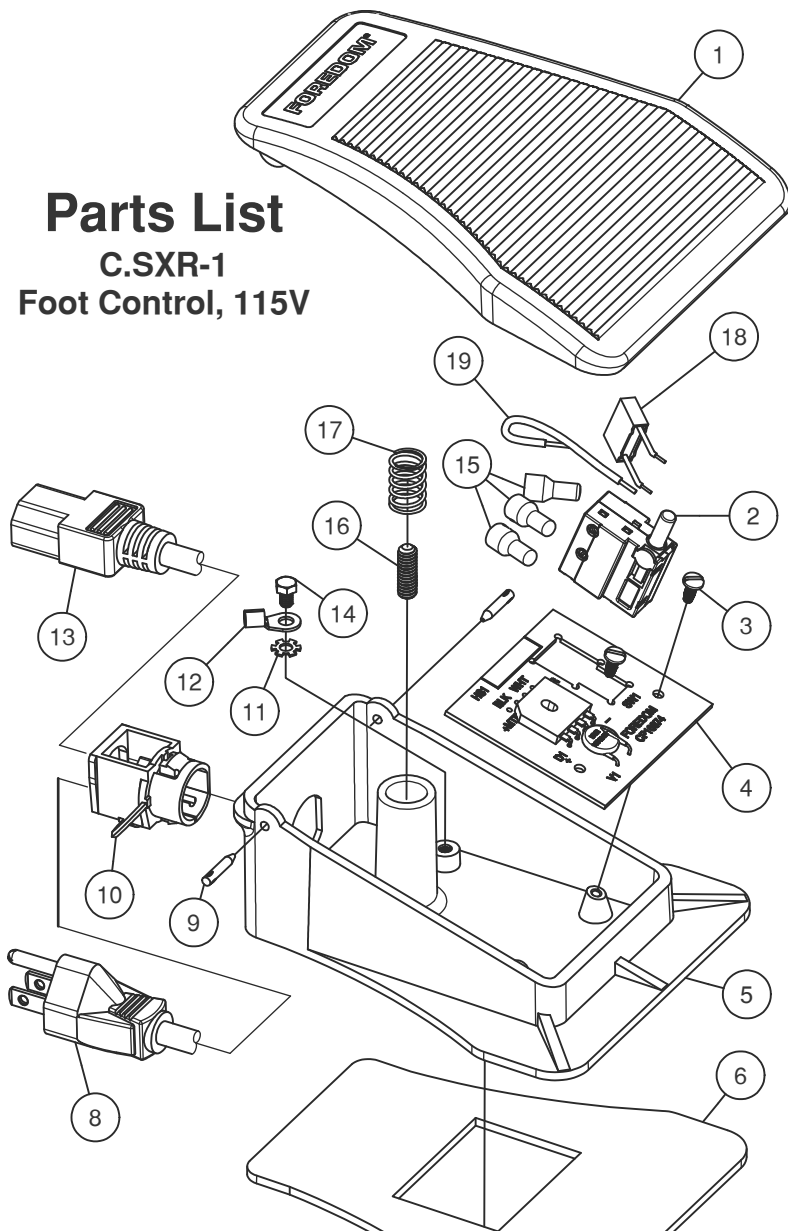


Item	Part No.	Description	Qty
1	CP10852A	Cover	1
2	CP10571	Screw, 6-32 x 5/16"	2
3	CP10525	Fish Paper	1
4	CP10521	Circuit Board	1
5	CP10851	Base, FC	1
6	CP10859	Front Pad	1
7	TxR-1.LAB	Label	1
8	CP10856	Adjustment Screw	1
9	CP10862	No. 6 Washer	1
10	CP10860	Rear Pad	1
11	CP10541	Male Cordset	1
12	CP10003-3	Strain Relief	2
13	CP10830	Female Cordset	1
14	CP11251	Trigger Switch	1
15	CP11163	Wire, Brown, Tinned	1
16	CP11162	Wire, Brown	1
17	CP11248	Capacitor	1
18	CP11036	Wire, White	1

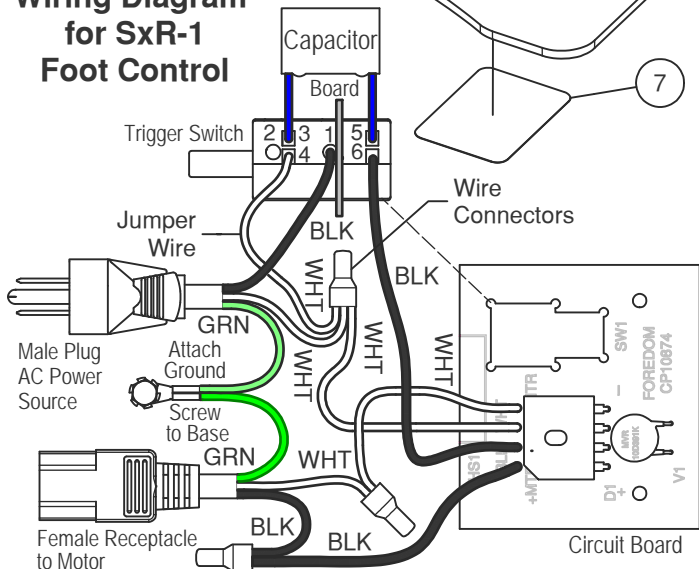
FOREDOM® The Freedom Electric Company
16 Stony Hill Rd., Bethel, CT 06801 • 203-792-8622
Fax: 203-796-7861 • www.freedom.net

Parts List

C.SXR-1 Foot Control, 115V



Wiring Diagram for SxR-1 Foot Control



Instructions for Removing and Replacing Trigger Switch

Disconnect Foot Control from Motor and Wall Outlet.

- With a punch and hammer, drive two Pins (9) in until Cover (1) lifts from Base (5). Remove Pins from Cover by driving them outward.
- Remove two Screws (3) from Board (4). After the wires have been removed from the switch, as instructed in paragraph C, remove the switch from the board, insert the new switch in its place, and follow the instructions in paragraphs E and F.
- On older Switches, all the terminals will be push-in, spring clamp type. For newer Switches, Terminal 1 has a screw for fastening the wire lead. To remove wires from the push-in terminals, insert 1.3mm [.05in] approximate diameter pin or the blade of a jeweler's screwdriver all the way into the terminal socket to release the spring clamp. Grasp the tool and wire and pull them together out of the socket. If you have difficulty removing the wires from the push-in terminals and you have wire-cutting, stripping, and soldering tools, you can cut the wires off where they exit from the terminals. To prepare the cut wires for installation into the replacement Switch, strip them back exactly 8.25 mm [5/16 in]. For the wires to be inserted into push-on terminals only, apply solder to the stripped ends to fuse the strands together. **DO NOT** solder wire ends to be inserted into screw terminals.
- Insert new Trigger Switch into Board.
- Connect Wires to New Trigger Switch and Circuit Board as shown in the Wiring Diagram.** Push wires all the way in, so that no bare wire is exposed. For Screw Terminal 1, push wire lead all the way into the socket then tighten the screw firmly. Push the other wire lead all the way into terminal 6. Simultaneously push the Capacitor leads all the way into terminals 3 and 5. Pull on all the wire leads, making sure they are secure.
- Locate the White Wire from the Male AC Power Cord then follow it to the Wire Connector. Cut both white wires nearest the connector then strip both wire ends 8.25mm [5/16in]. Insert three white wires into newly supplied connector and crimp.
- Install Board and Switch into Base using two Screws (3).
- Position wires around post of Base so wires will not interfere with Cover travel.
- Install Cover over Spring (17) and align holes to Base. Insert Pins (9) and seat them with hammer.

Item	Part No.	Description	Qty
1	CP10691	Cover	1
2	CP11251	Trigger Switch	1
3	CP10571	Screw, 6-32 X 5/16"	2
4	CP10874	Circuit Board, SxR	1
5	CP10690	Base	1
6	CP10753	Pad	1
7	SxR-1.LAB	Specification Label	1
8	CP10541	Male Cordset	1
9	CP10584C	Hinge Pin	2
10	CP10578	Grommet	1
11	CP10564	Lock Washer, #8	1
12	CP10580	Ring Terminal	1
13	CP10830	Female Cordset	1
14	CP10563	Screw, 8-32 x 1/4"	1
15	CP11029	2 Wire Connector	3
16	CP10562	Set Screw	1
17	CP10588	Spring	1
18	CP11248	Capacitor	1
19	CP11036	Wire, White	1