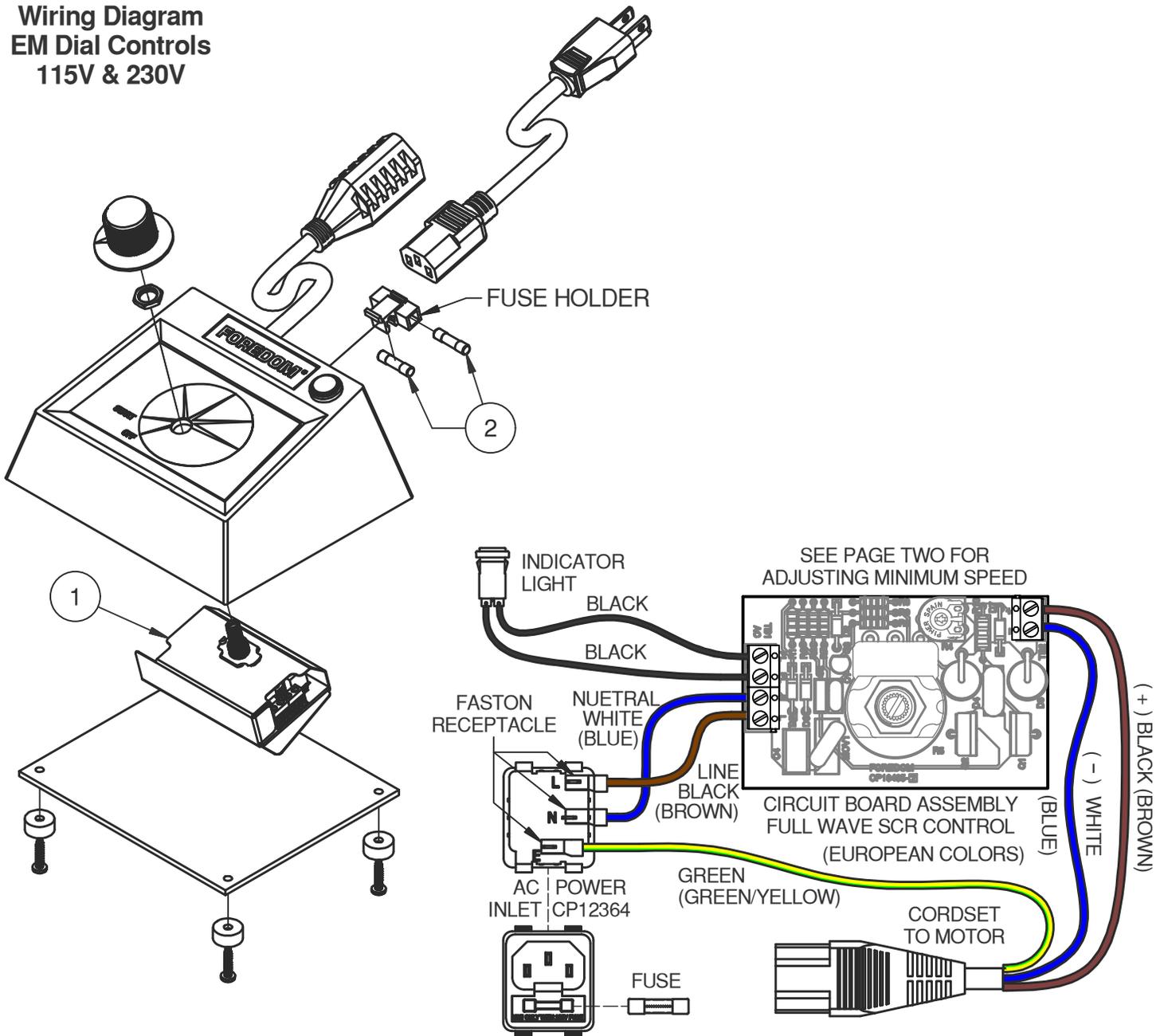


**Wiring Diagram
EM Dial Controls
115V & 230V**



MODEL PART NO. (VOLTAGE)	ITEM (1) CIRCUIT BOARD PART NO.	ITEM (2) FUSE RATING (AMP) PART NO.	TURN-ON SPEED (RPM)	USED WITH MOTOR MODEL NO.
C.EM-1 (115V)	CP10495	3A CP10513	200-600	SR-115V
C.EMH-2 (230V)	CP10495-2	3A CP10513	200-600	SR-230V
C.EMX-1 (115V)	CP10495	5A CP10515	100-300	LX-115V TX-115V
C.EMX-2 (230V)	CP10495-2	3A CP10513	100-300	LX-230V
C.EMGX-1 (115V)	CP10495-PGX	1.5A CP10511	100-300	PGX-115V
C.EMGX-2 (230V)	CP10495-2PGX	1.5A CP10511	100-300	PGX-230V

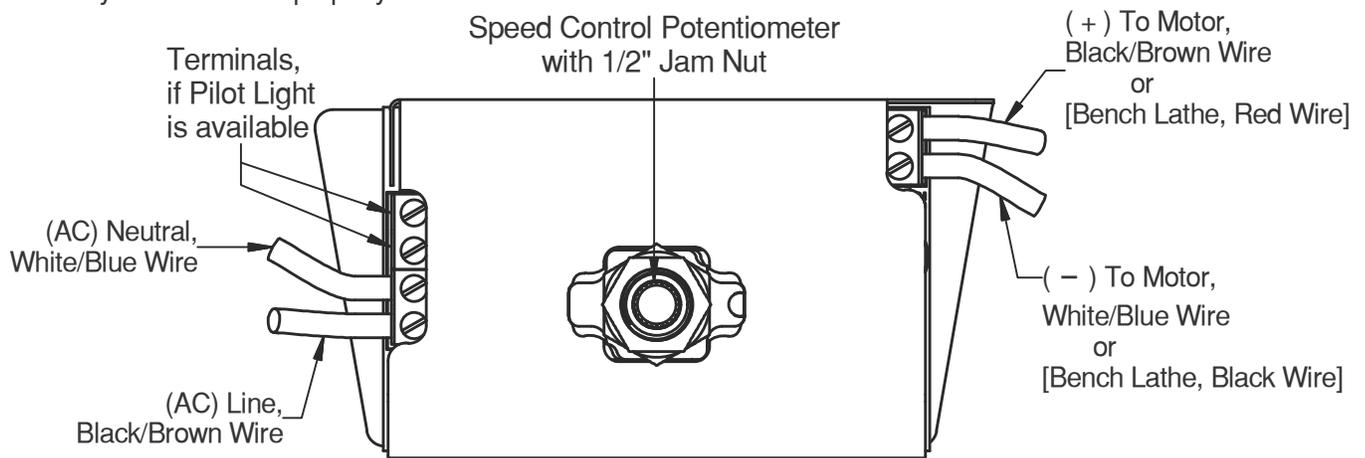
CAUTION ! This procedure should be performed by a qualified technician.
Factory Repair Service is available from Foredom Electric.

Replacing Circuit Board Assembly Part No. CP10495 or CP10495-2 and Adjusting the Start Speed.

Removing old Circuit Board Assembly from Control Base: Unplug unit from power supply. Remove bottom Cover from unit. Loosen the Set Screw, if present, on the side of the Speed Control Knob. Pull off the speed control knob. Loosen and remove 1/2" Jam Nut from Speed Potentiometer Post. Pull Circuit Board Assembly out of unit. Carefully turn Circuit Board over, and loosen the terminal screws and remove wire ends. Leave the Green Ground Wires connected. For older circuit board models, cut and strip 1/4" off the Black/Brown and White/Blue wires.

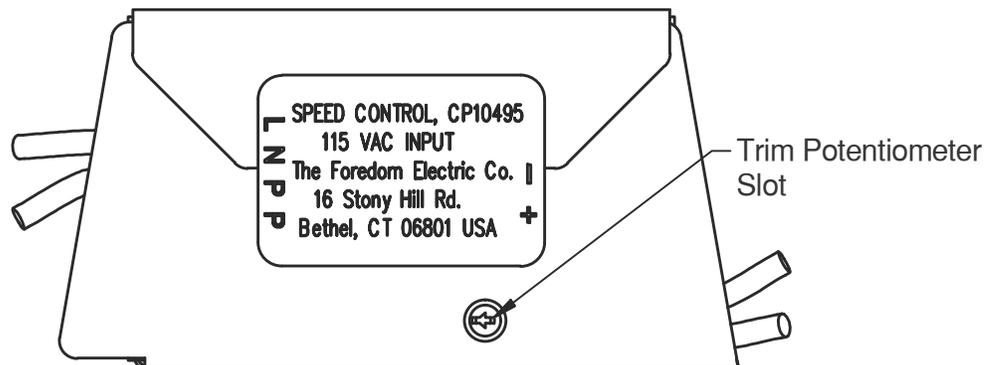
Installing new Circuit Board Assembly into Control Base:

Remove 1/2" Jam Nut, if included, from new Circuit Board Assembly. Temporarily place Circuit Board into unit to determine correct orientation and proper fit. Flip Circuit Board over. Insert each wire end into corresponding terminal and tighten terminal screw to secure wires as shown in Figure 1. Flip Circuit Board back over and insert Speed Potentiometer Post through Control Base Hole. Install 1/2" Jam Nut onto Speed Potentiometer Post and tighten. Turn Speed Potentiometer Knob fully counterclockwise until it clicks to the off position. Insert Knob onto Speed Potentiometer Post while aligning white marking with the "OFF" decal. Tighten set screw, if present, on the side of the Knob. Inspect all wires and insure they are connected properly.



Top View of Circuit Board Assembly
Figure 1.

Adjusting minimum speed Trim Potentiometer: Turn Speed Potentiometer Knob fully counterclockwise until it clicks to the "off" position. Orient unit with Circuit Board Assembly so that Circuit board is facing up. Connect unit to power supply with proper AC voltage: for CP10495 use 115 VAC, 60 Hz; for CP10495-2 use 230 VAC, 50Hz. Turn Speed Potentiometer just until it clicks to the "on" position. Insert a fine jewelers screwdriver into the Trim Potentiometer slot, shown in Figure 2. Slowly Turn the screwdriver in either direction until the desired start speed is achieved. Turn the Speed Potentiometer to the off position and disconnect unit from AC power supply. Replace the unit's bottom Cover.



Bottom view of Circuit Board Assembly
Figure 2.