

Remove the handles from X and Y



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Remove the two cap screws attaching the Y
lead screw



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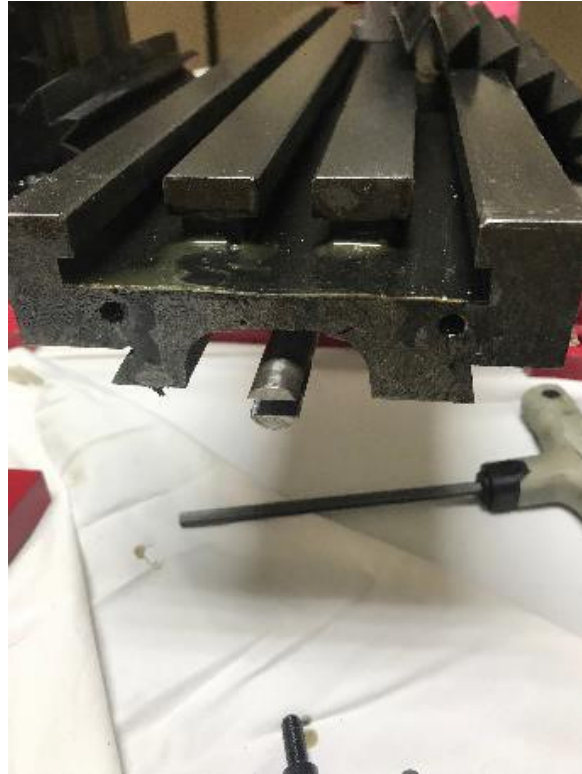


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Remove the two cap screws for the end piece of the table



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Remove the two cap screws at the handle
end of the table



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Now you can slide the table off to expose this



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There are two set screws to remove the lead nut of the X axis



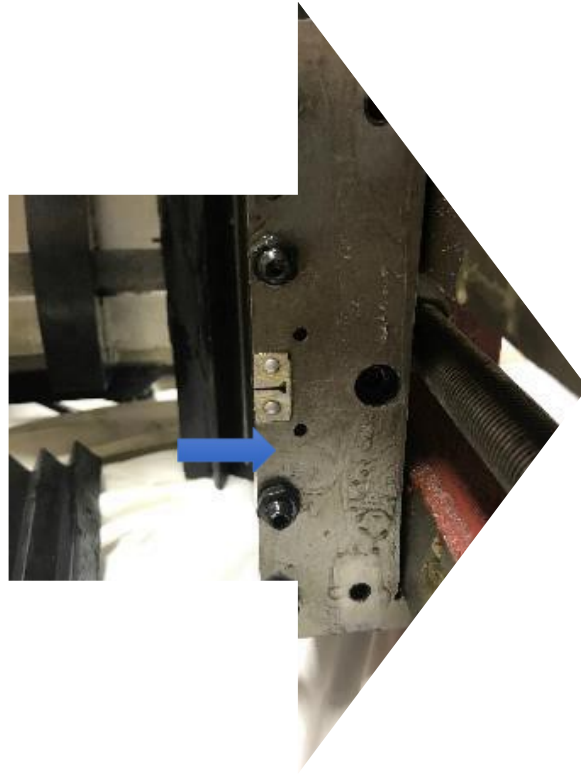
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You will want to remove the way cover



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There is a set screw to remove the Y axis lead nut



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Lay the machine over on its side and you can get the Y lead screw out



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While the machine is on its side, install the new ball screw and nut



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It will install the same way the old one was installed



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- You will find that when you start to install things, they will bind up on you.
- This is where the tweaking process comes in.
- You will need to loosen and tighten things more than once to get the alignment correct.

Install the X ballnut block the same as the old lead screw and nut



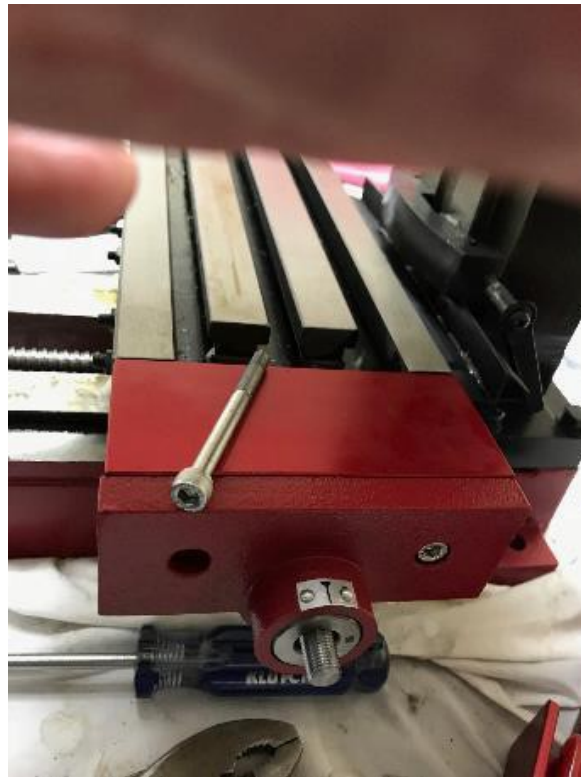
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Now you can slide the table back on



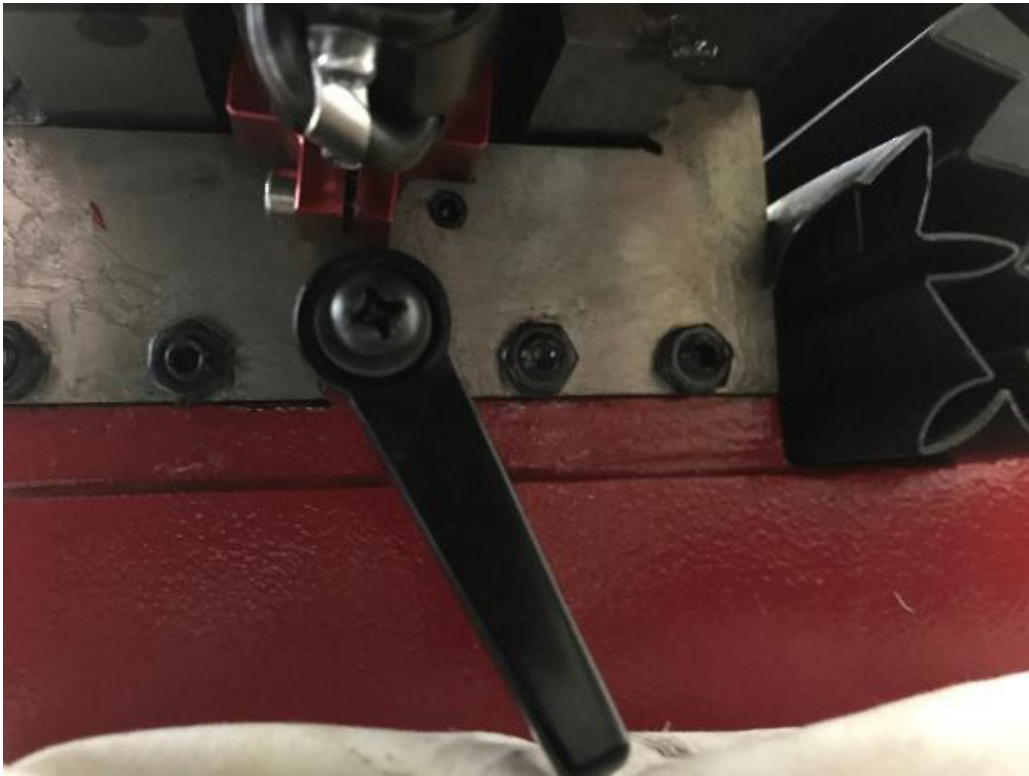
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Use the long 6mm screws that came with the kit.
Put the extension on and also the end cap from the
handle end. Use the existing thrust bearings



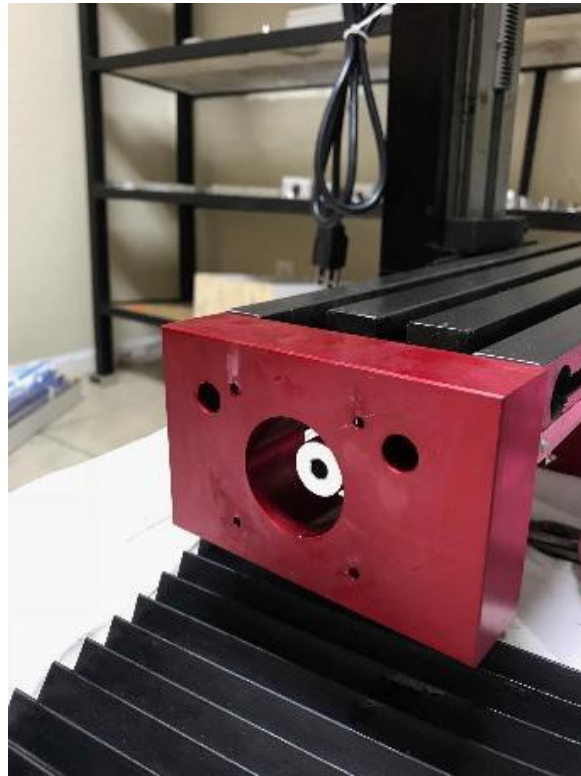
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You can still get to the set screws for the X ballnut, to make adjustments



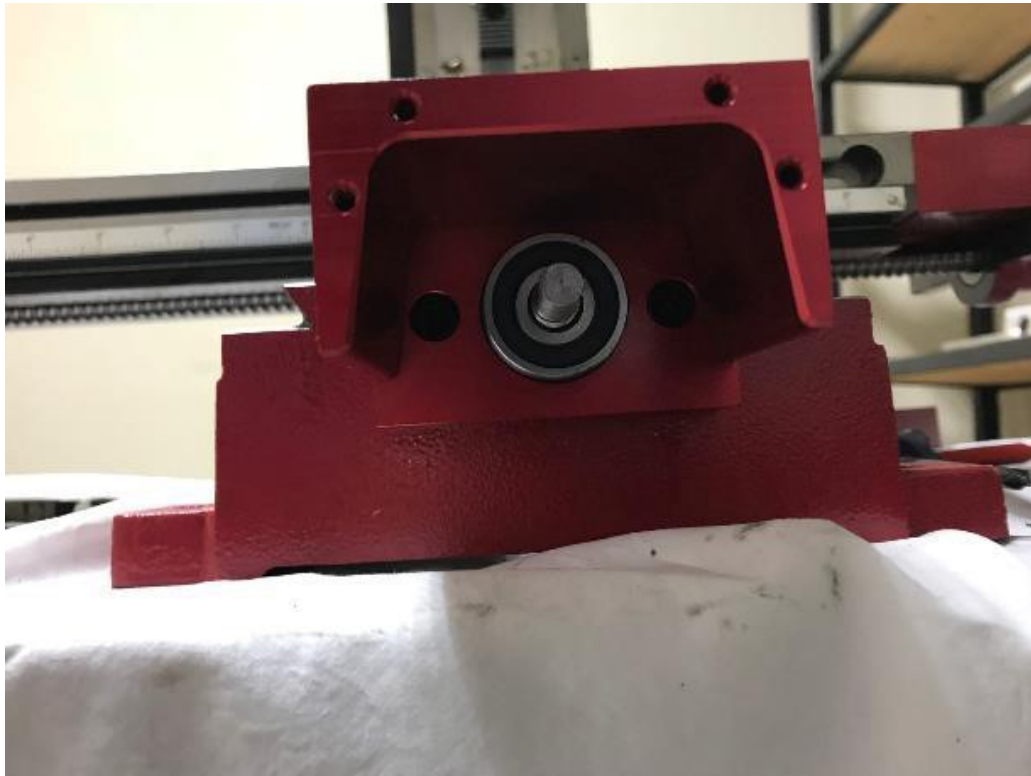
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Bolt the X motor mount to the other end of the table



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Remove the ¼" plate from the Y assembly to bolt it to the machine



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Screw on the two nuts, and put the coupling back on



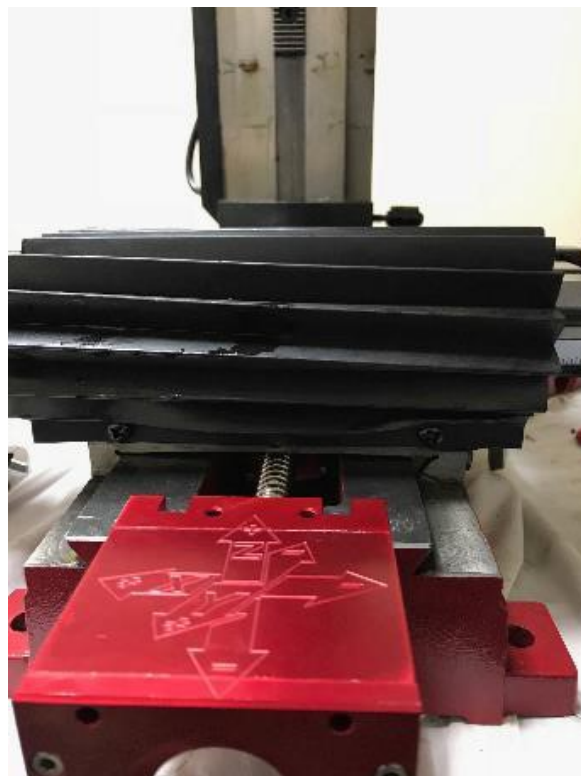
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Bolt it down to the machine



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Re-attach the ¼" plate to the Y assembly



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Now we can move on to the Z axis



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Start by removing the gas spring



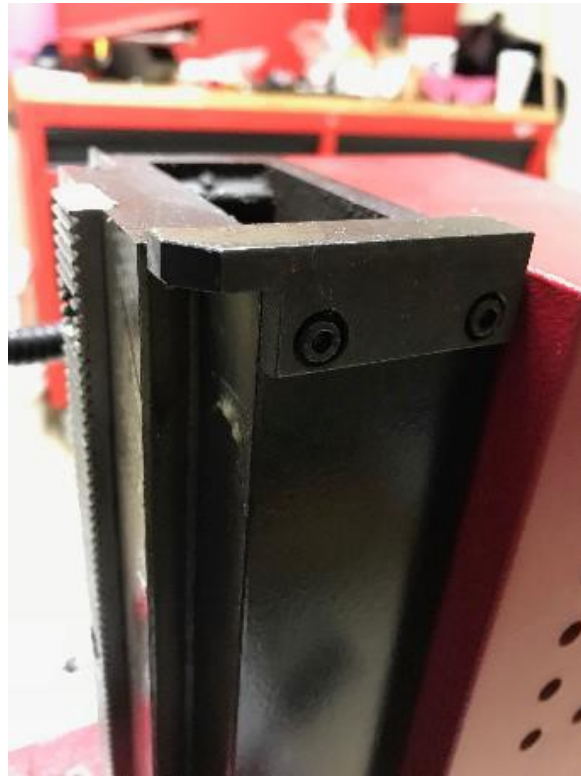
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Detach this cap screw from the back of the machine. It holds the gas spring from inside the column



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This is the stop for the head. Remove it.



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With the head all the way down, remove the screws for the spline rail



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Now move the head all the way to the top,
until it is in this position



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You can now remove the other two screw
from the spline rail, and remove



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Remove the cover for the fine feed.



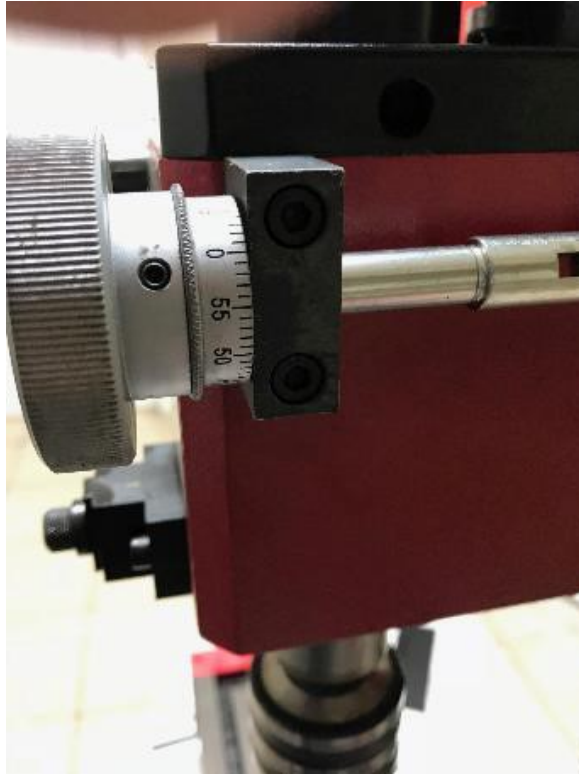
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Remove the handle



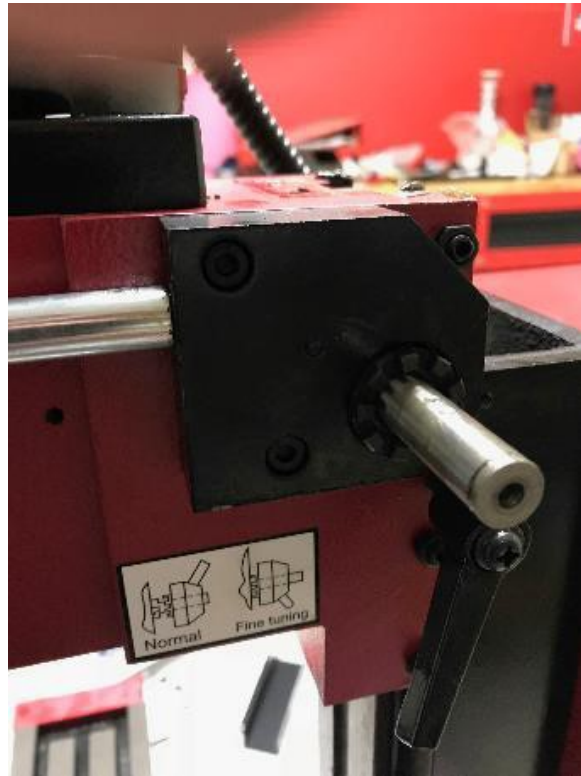
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Remove the two cap screws for the fine feed



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Remove the two cap screws from behind the handle

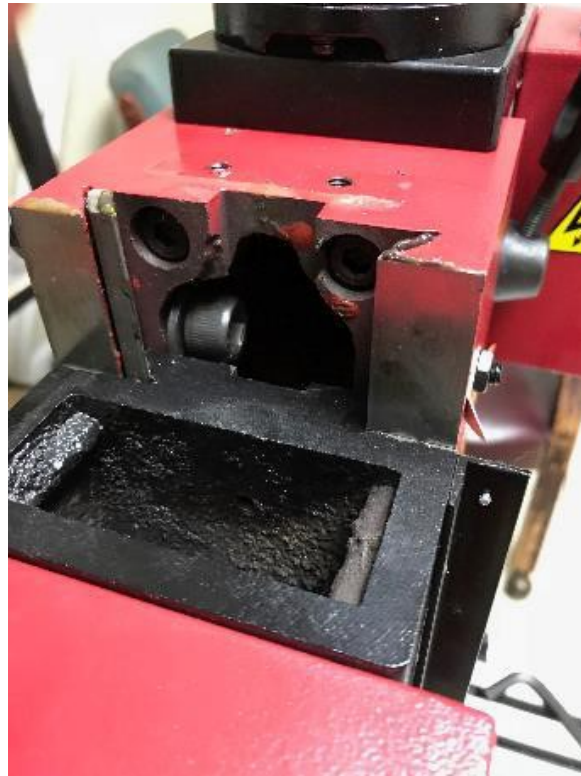


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The 12mm bolt that came with the kit will go in the hole where the spline gear was



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Bolt the block with the 12mm cap screw, and the 2 6mm screws that had the plate bolted to the head



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Slowly move the head down until the Z top mount sets on top of the column



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- We have heard some feed back on issues with the Z axis binding.
- When starting to install the Z axis ball screw, bolt down the side block with the existing holes from the machines first.
- Then you can hold the top plate in place and move the head up and down with a drill attached to the coupling. This will allow you to get smooth movement from top to bottom before deciding on where to drill the mounting holes for the Z top plate.
- We also slotted the Z top plate for some final fine adjustment just in case.
- Mounting of the Z axis should be a slow and steady process to insure alignment is correct. This will avoid any binding issues.

You can drill the holes thru with a ¼" drill, or you can drill and tap them for a 6mm cap screw



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Either way, you can use the 6mm cap screws and nuts that come with the kit



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Now you are ready to tweak everything in,
and start on the electronics



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