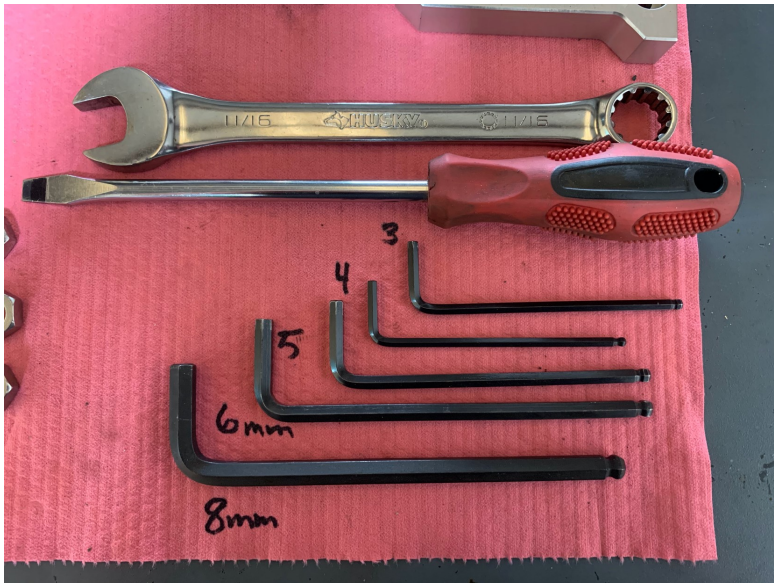
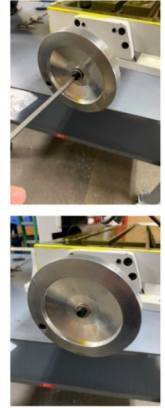




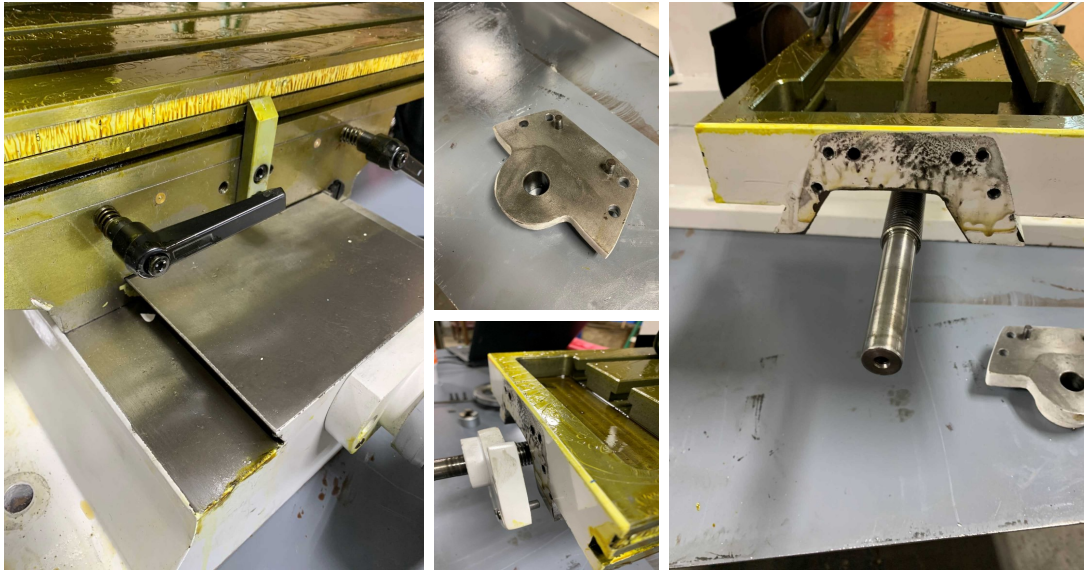
THESE ARE THE TOOLS YOU WILL NEED



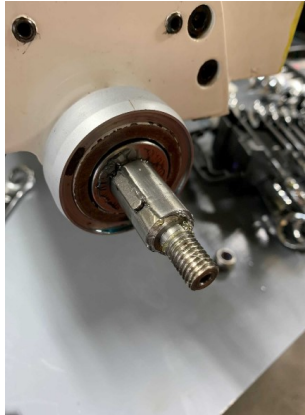
START WITH X. YOU NEED TO REMOVE THE TABLE.
TAKE THE HANDLES OFF EACH END OF THE TABLE.



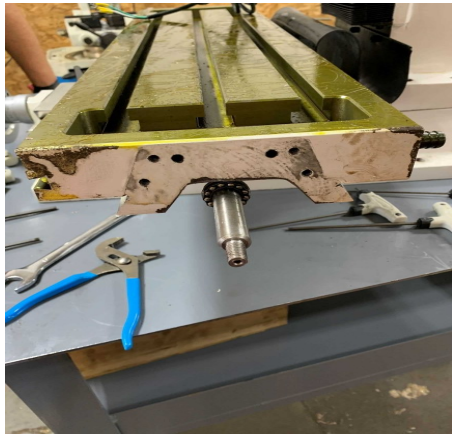
THE EASIEST WAY TO GET THE PLATE OFF IS TO TIGHTEN DOWN THE BLACK HANDLE GIB SCREWS. GRAB THE HANDLE ON THE OTHER SIDE OF THE TABLE AND CRANK IT. IT WILL PUSH THE PLATE OFF THE TABLE. IT HAS PINS THAT ARE PRESSED IN



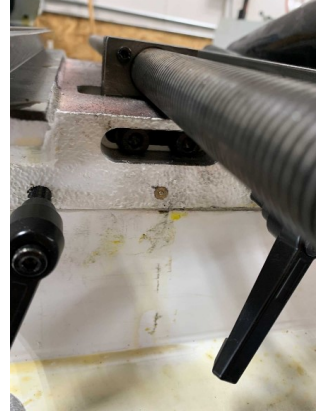
NOW DO THE SAME ON THE OTHER END OF THE
TABLE.



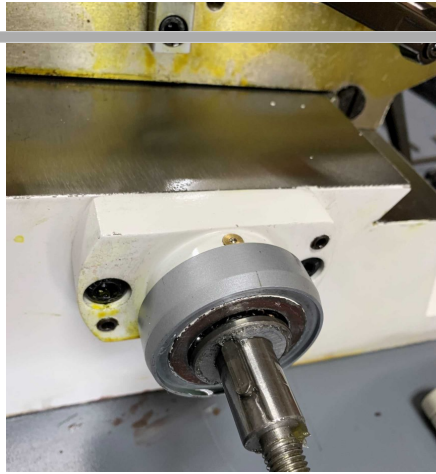
TAKE THE TABLE STOP OFF AND GRAB THE END OF
THE TABLE AND SLIDE IT OFF.



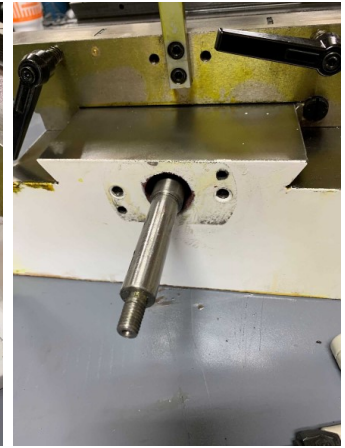
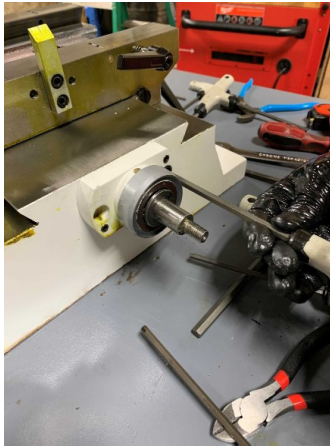
TAKE OFF THE LEAD SCREW AND NUT. THERE ARE TWO
CAP SCREWS BOLTED ON TO THE NUT. REMOVE THEM



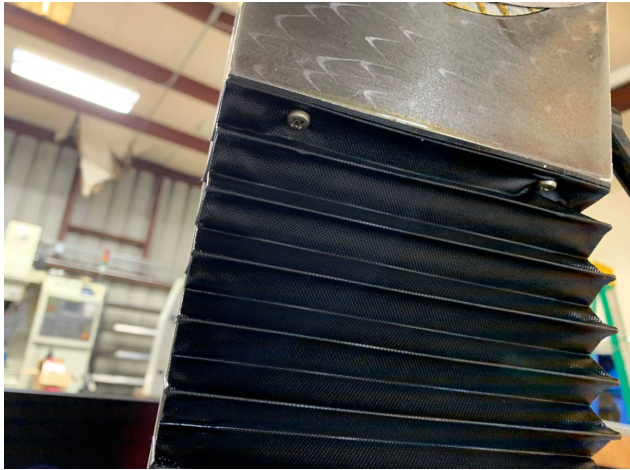
NOW MOVE TO Y. YOU NEED TO REMOVE THE
LEAD SCREW AND NUT. REMOVE THE HANDLE



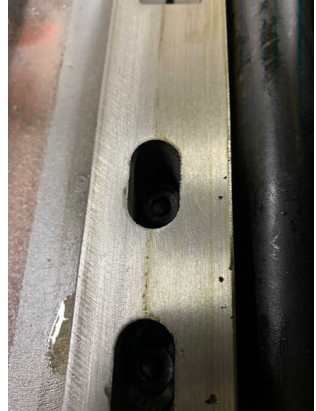
REMOVE THE BOLTS FROM THE PLATE AND DO THE SAME THING YOU DID WITH X. TIGHTEN DOWN THE GIB SCREWS AND TURN THE LEAD SCREW TO PUSH THE PLATE OFF THE BASE



REMOVE THE WAY COVERS.



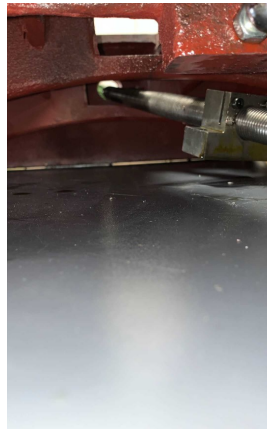
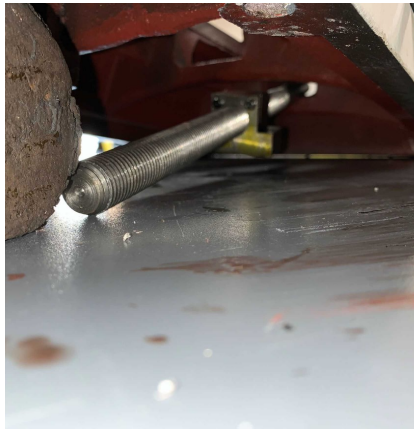
THERE ARE TWO CAP SCREWS HOLDING THE Y LEAD
NUT IN PLACE. REMOVE THEM



SLIDE THE SADDLE OFF THE BASE



TILT THE MACHINE UP AND REMOVE THE Y LEAD
SCREW AND NUT.



BE SURE TO TIGHTEN DOWN
THE GIBS WITH THE LOCKING
LEVERS TO KEEP THE HEAD
FROM DROPPING WHEN
REMOVING THE LEAD SCREW



MOVING TO Z AXIS. TILT THE HEAD 90 DEGREES TO EXPOSE THE
CAP SCREWS ATTACHING THE LEAD SCREW TO THE HEAD. GO
AHEAD AND REMOVE THEM.



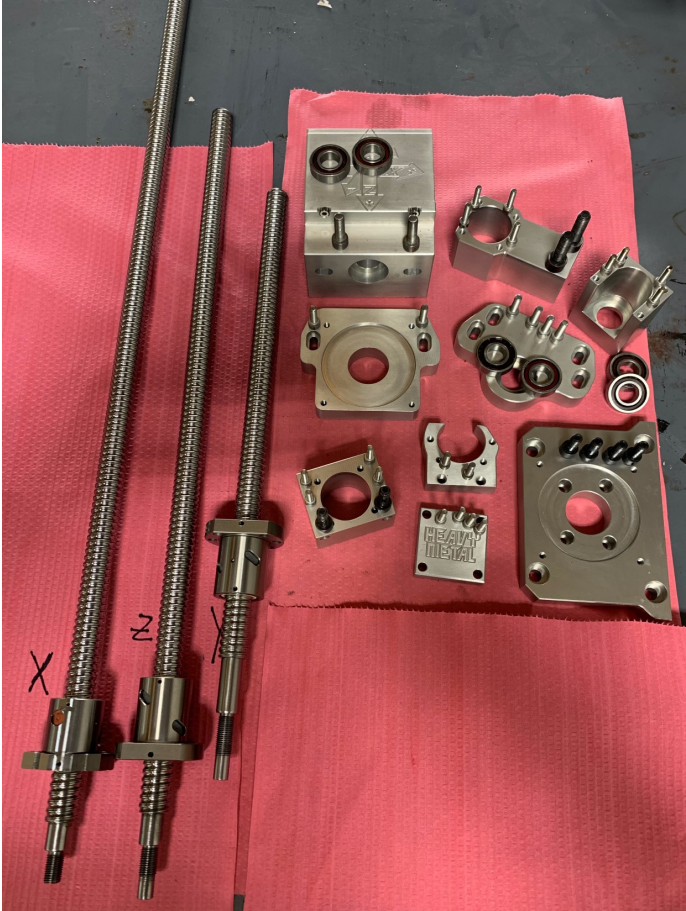
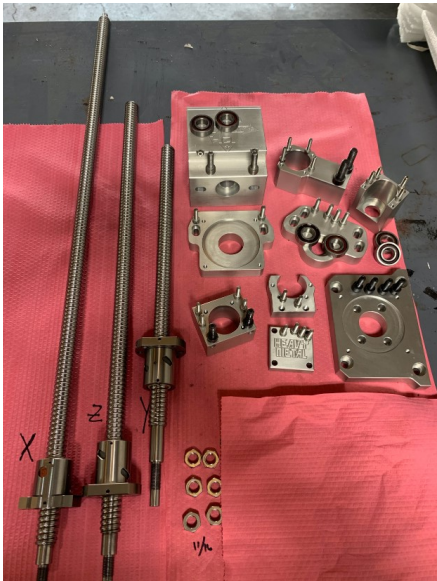
REMOVE THE Z HANDLE. REMOVE THE 4 CAP SCREWS
AND PRY OFF THE PLATE WITH A SCREWDRIVER



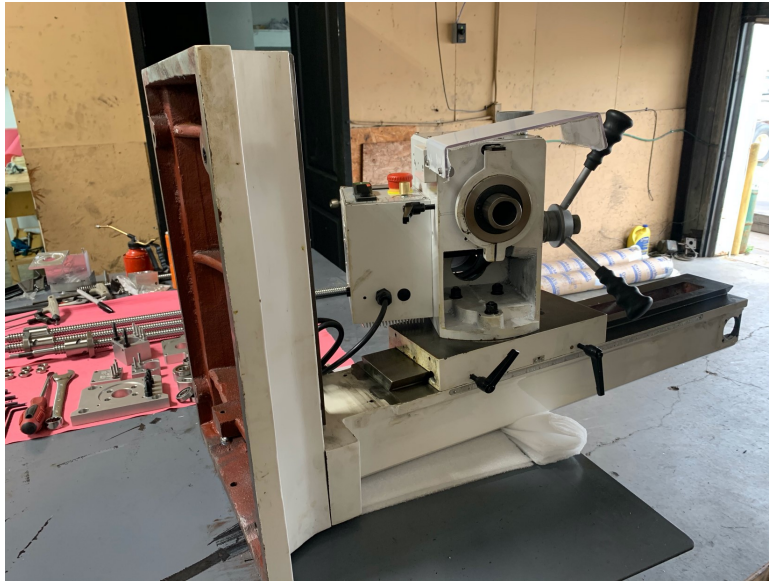
REMOVE THE CAP ON TOP OF THE COLUMN. THE LEAD SCREW NUT IS TWO PIECES. TAKE IT APART AND REMOVE THE RECTANGULAR BLOCK BEFORE TRYING TO PULL IT UP AND OUT OF THE COLUMN



THE KIT

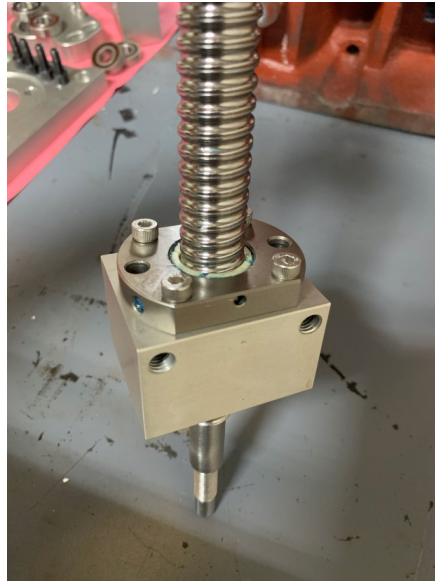


START WITH Y AXIS. LAY THE MACHINE BACK
ON THE COLUMN





THE Y BALL NUT BLOCK ASSEMBLED





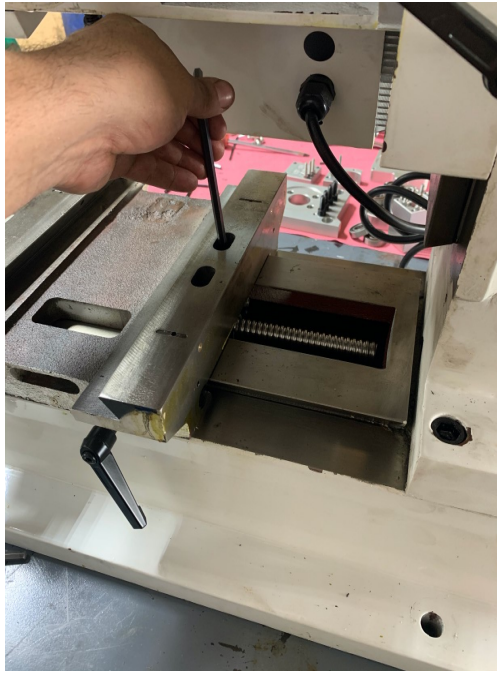
THE BALL NUT ASSEMBLY HAS TO BE TOWARDS THE END OF THE BALL SCREW. SLIDE THE BALL SCREW UP AND THROUGH THE ORIGINAL HOLE THE LEAD SCREW CAME OUT OF.



NOW YOU CAN MOVE
IT ABOVE THE CROSS
BRACE AND SLIDE IT
DOWN AND IN.



SLIDE THE
SADDLE
ON.USE
THE CAP
SCREWS
THAT
CAME
WITH THE
MACHINE
TO ATTACH
IT. LEAVE
IT LOOSE
FOR NOW





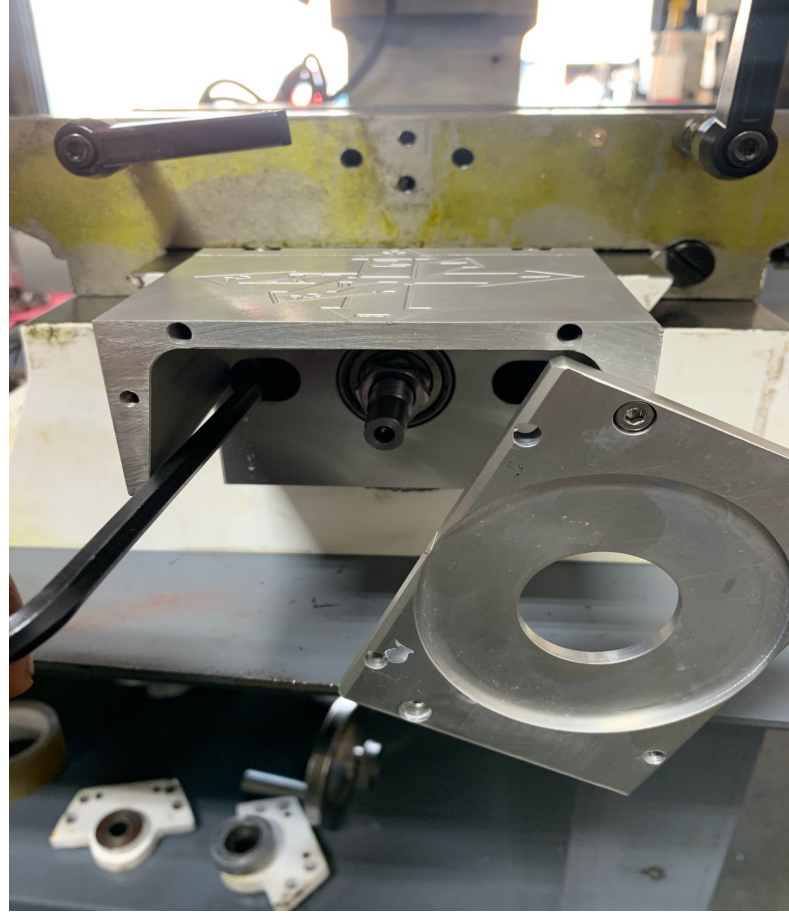
SLIDE
THE GIB
BACK IN
AND
TIGHTEN
IT UP

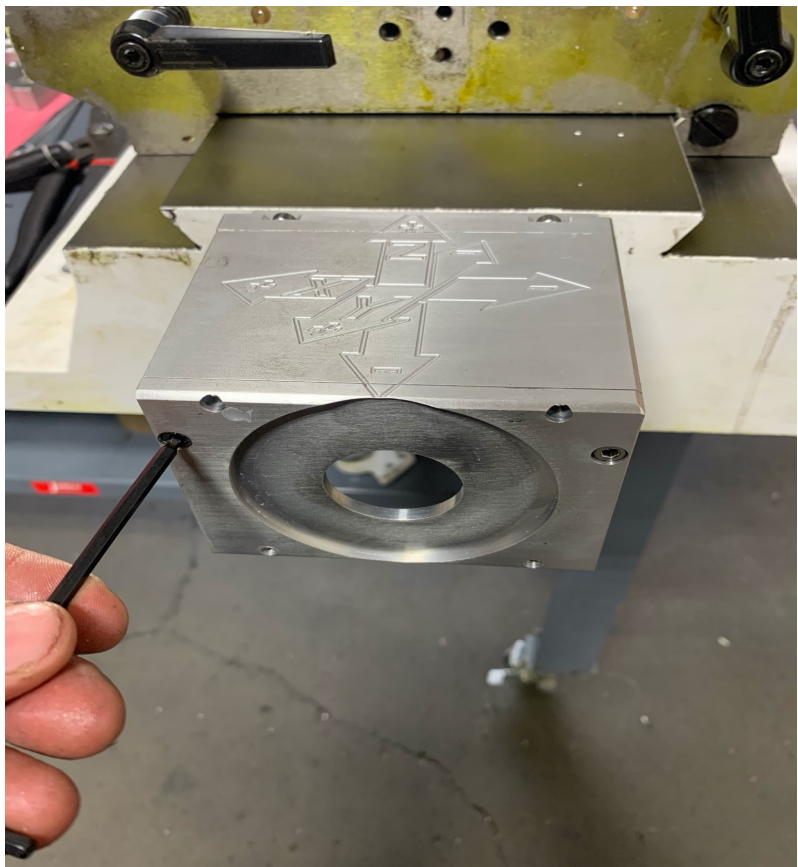


REMOVE THE 1/4" PLATE FROM THE Y ASSEMBLY. THEN PUT ON THE JAM NUTS. THEY NEED TO BE TIGHT AGAINST THE BEARING. JUST TIGHT ENOUGH TO GET RID OF ANY BACKLASH. USING THE DOUBLE NUT METHOD WILL KEEP THEM FROM COMING UNDONE



NOW BOLT IT ON TO THE BASE. LEAVE THIS LOOSE AS WELL. NOW I SUGGEST YOU ATTACH A MOTOR TO THE BALL SCREW SO YOU CAN RUN IT BACK AND FORTH AS YOU TIGHTEN IT UP. THE BALL NUT BLOCK AND MOTOR MOUNT HAVE SIDE TO SIDE ADJUSTMENT TO MAKE SURE THERE IS NO BINDING





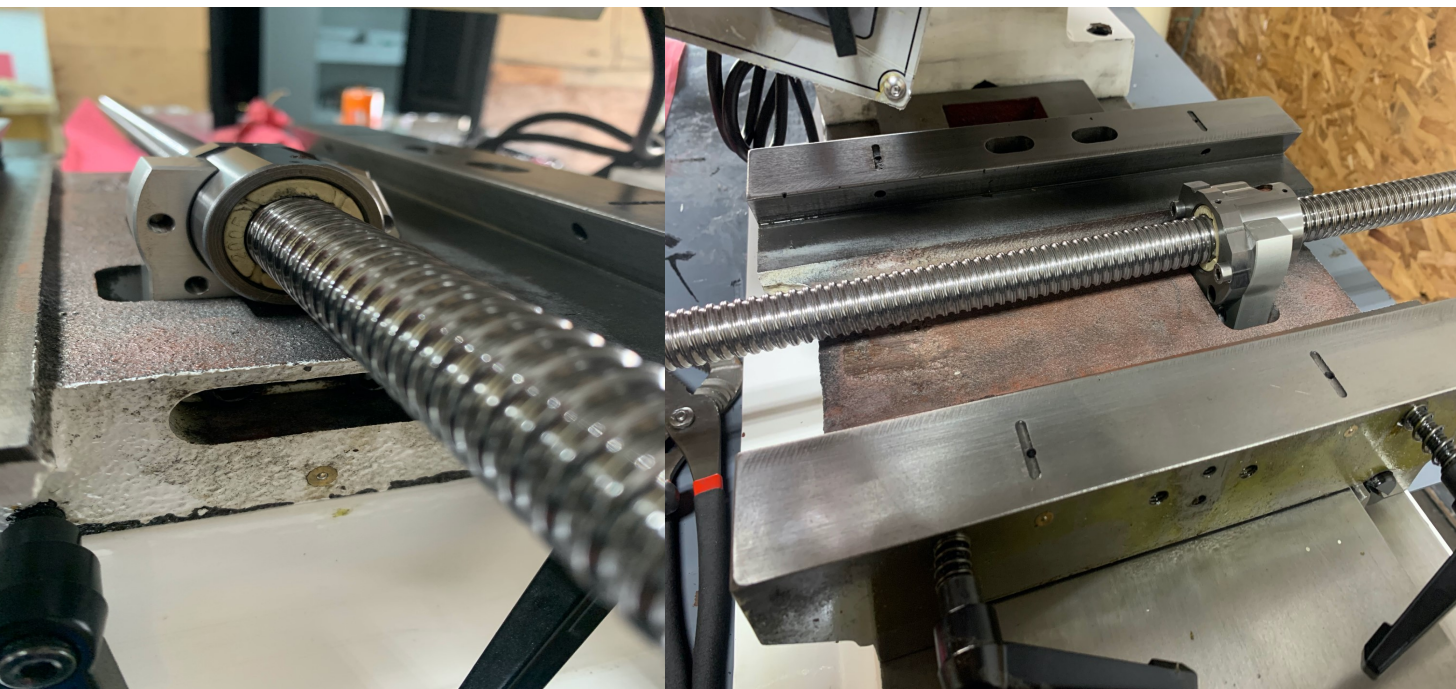
FOR X AXIS.
TO KEEP
FROM
MILLING INTO
THE SADDLE,
WE WERE
ABLE TO JUST
TAKE .100"
OFF THE
BOTTOM OF
THE TABLE.



THIS IS THE X BALL NUT AND BALL SCREW
ASSEMBLY. WE REMOVED SOME OF THE FLANGE
OF THE BALL NUT FOR CLEARANCE



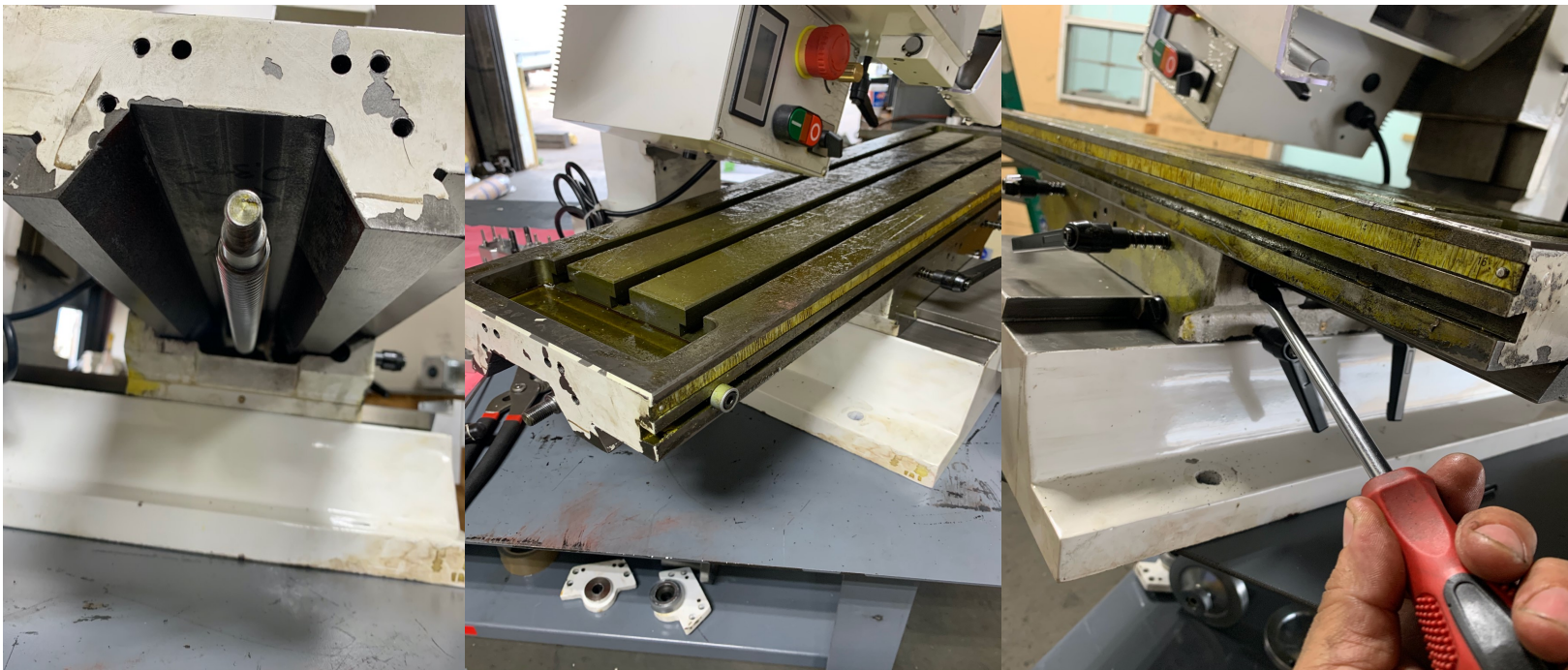
DROP THE ASSEMBLY INTO THE SLOT ON THE
SADDLE



PUT THE CAP SCREWS IN. DON'T TIGHTEN
THEM ALL THE WAY



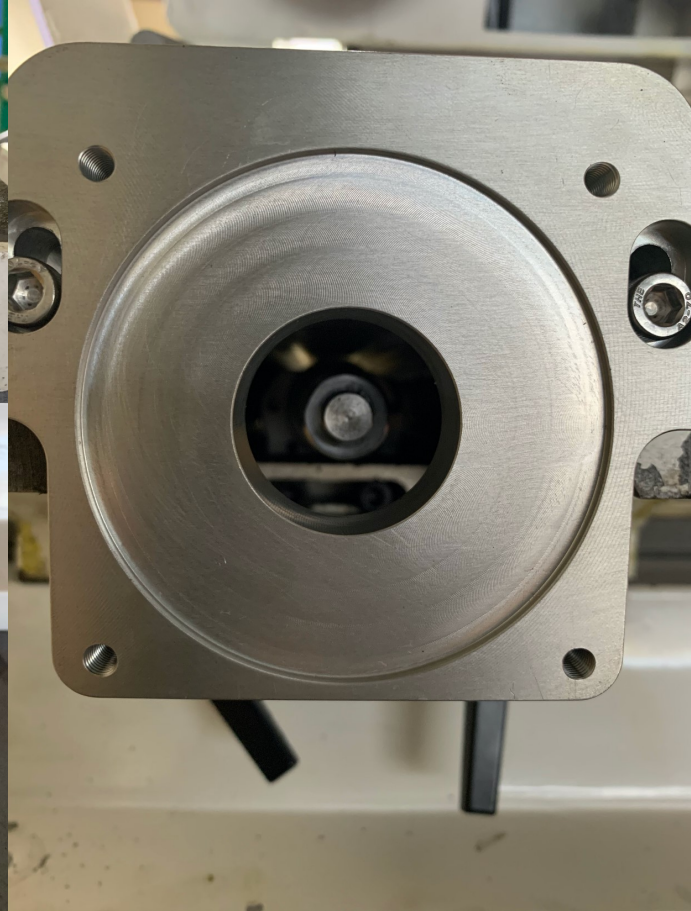
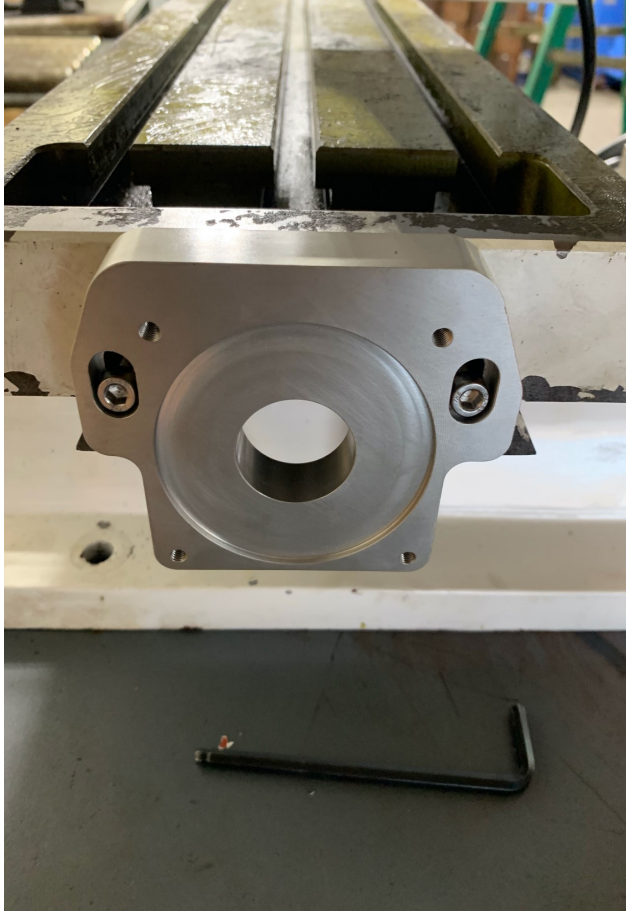
SLIDE THE TABLE BACK ON AND PUT THE GIB IN PLACE



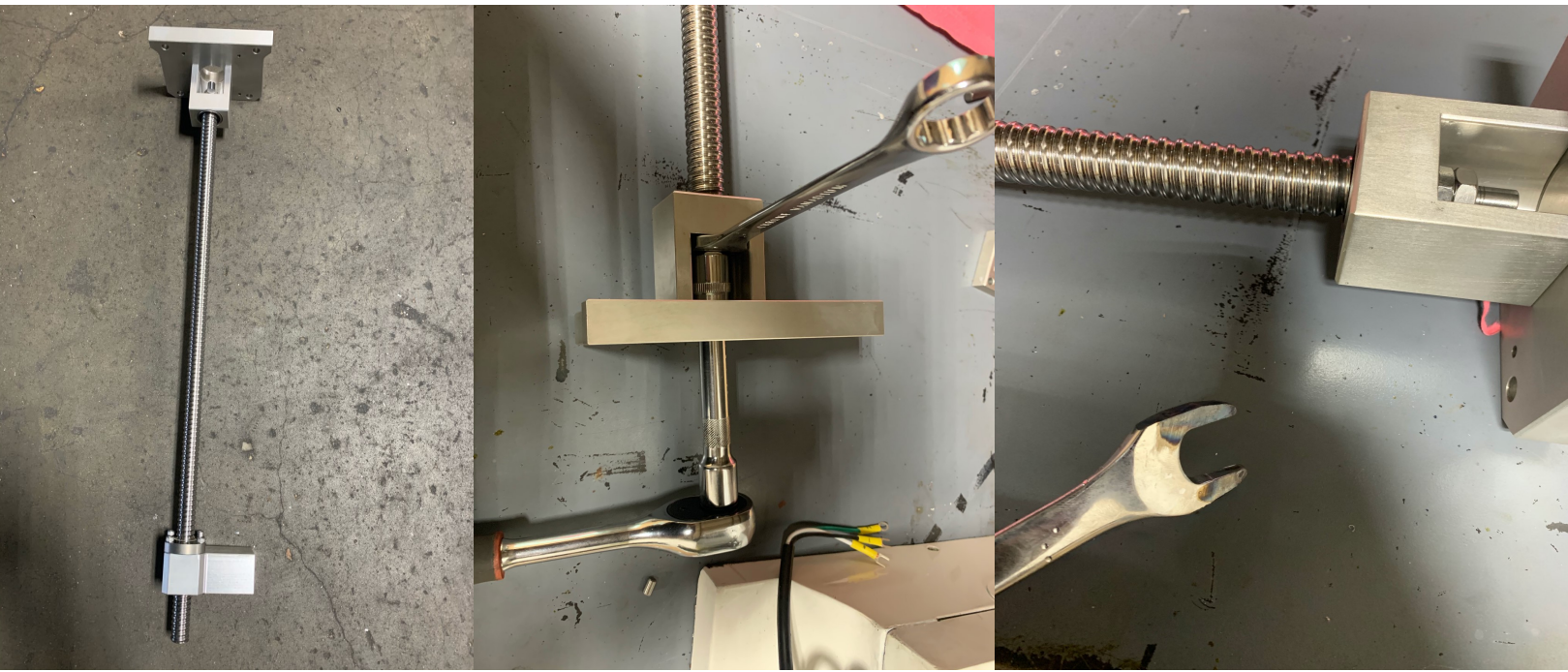
PUT THE
BEARING
BLOCK ON
THE BALL
SCREW ON THE
LEFT END OF
THE TABLE.
LOCK DOWN
THE JAM
NUTS, THEN
ATTACH IT TO
THE TABLE



ATTACH THE
MOTOR
MOUNT TO
THE RIGHT
SIDE OF THE
TABLE. AGAIN
PUT A
MOTOR ON
AND RUN
THE TABLE
BACK AND
FOURTH
WHILE
TIGHTENING
THE BOLTS



MOVING TO Z. TIGHTEN THE JAM NUTS



NOW YOU DROP THE Z ASSEMBLY INTO THE
COLUMN





THE HEAD HAS TO BE TILTED TO EXPOSE THE
SLOT YOU BOLT THE BALL NUT BLOCK ON



BOLT ON THE MOTOR MOUNT TO TOP OF THE
COLUMN. AND THE CAP WHERE THE Z HANDLE
WAS



YOU ARE READY
TO START
HOOKING UP THE
ELECTRONICS

