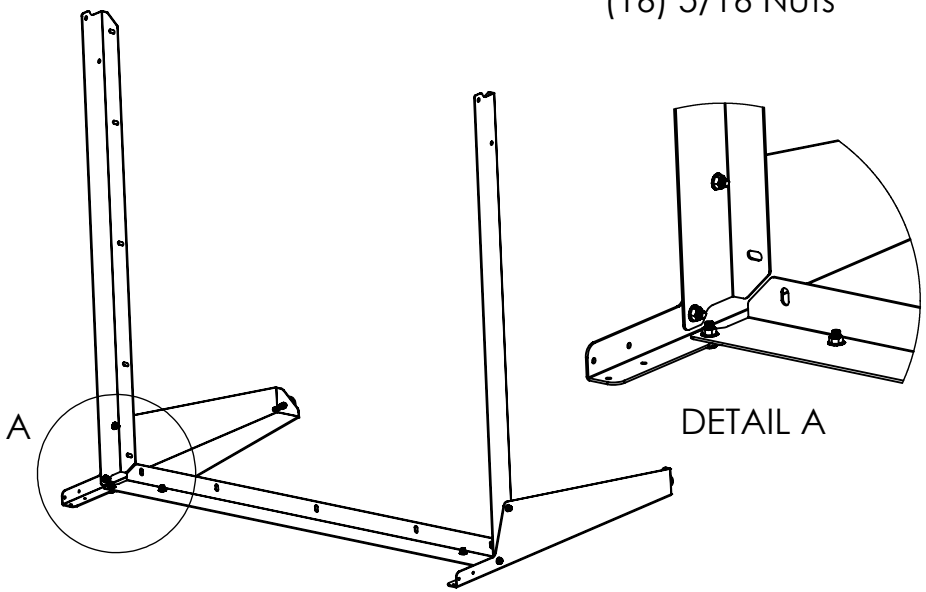
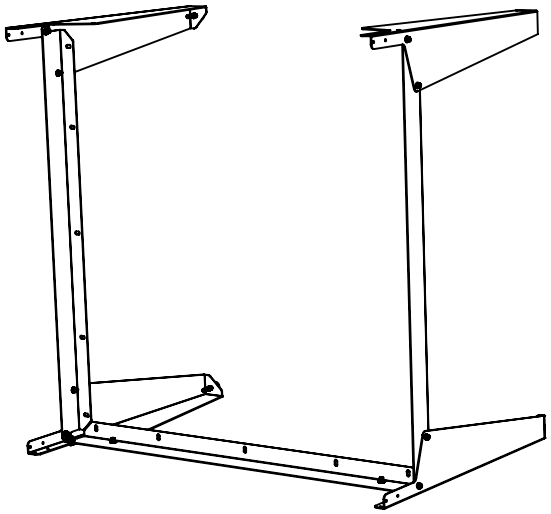
STEP 1

Hardware Required: (16) 5/16x.75 Bolts
(16) 5/16 Nuts



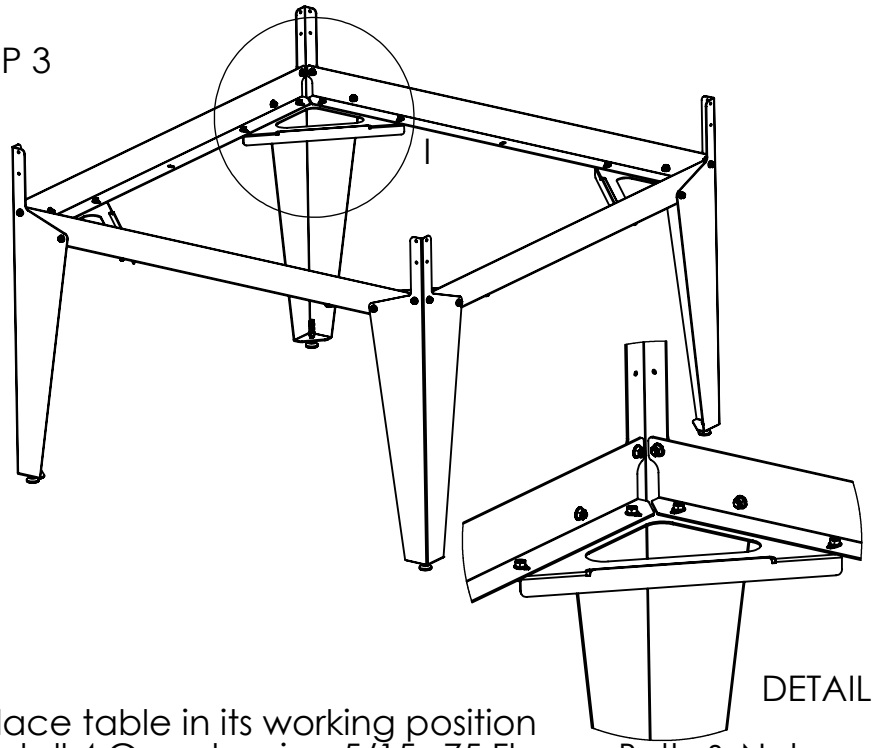
Place legs on floor and bolt frame as shown, leave hardware loose for the next 4 STEPS

STEP 2



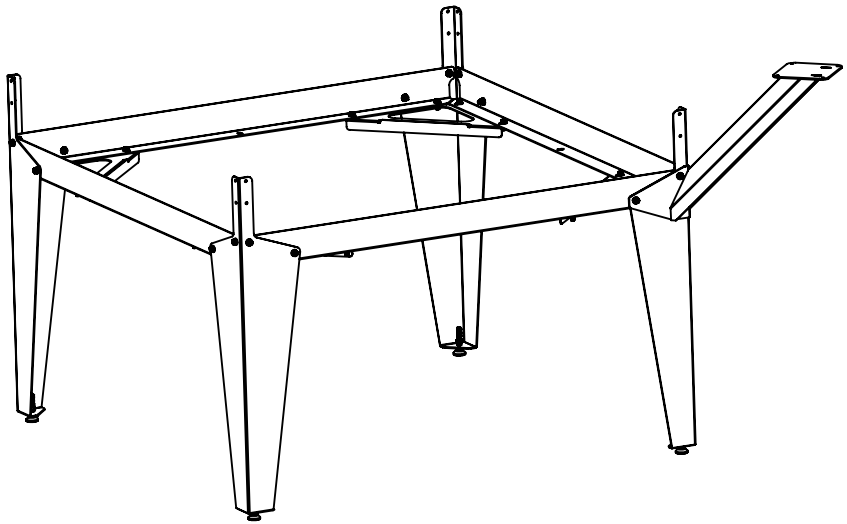
Continue to assemble the 2 remaining legs in this position on the floor

STEP 3



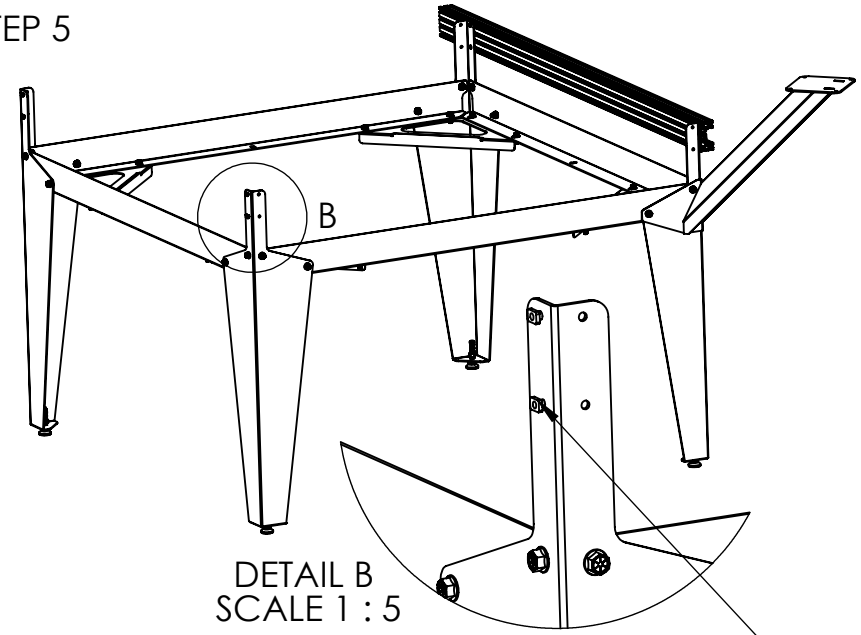
Place table in its working position
Install 4 Gussets using 5/15x.75 Flange Bolts & Nuts

STEP 4



Remove the bolts at any corner while supporting the frame, install Computer Stand using the same bolts removed

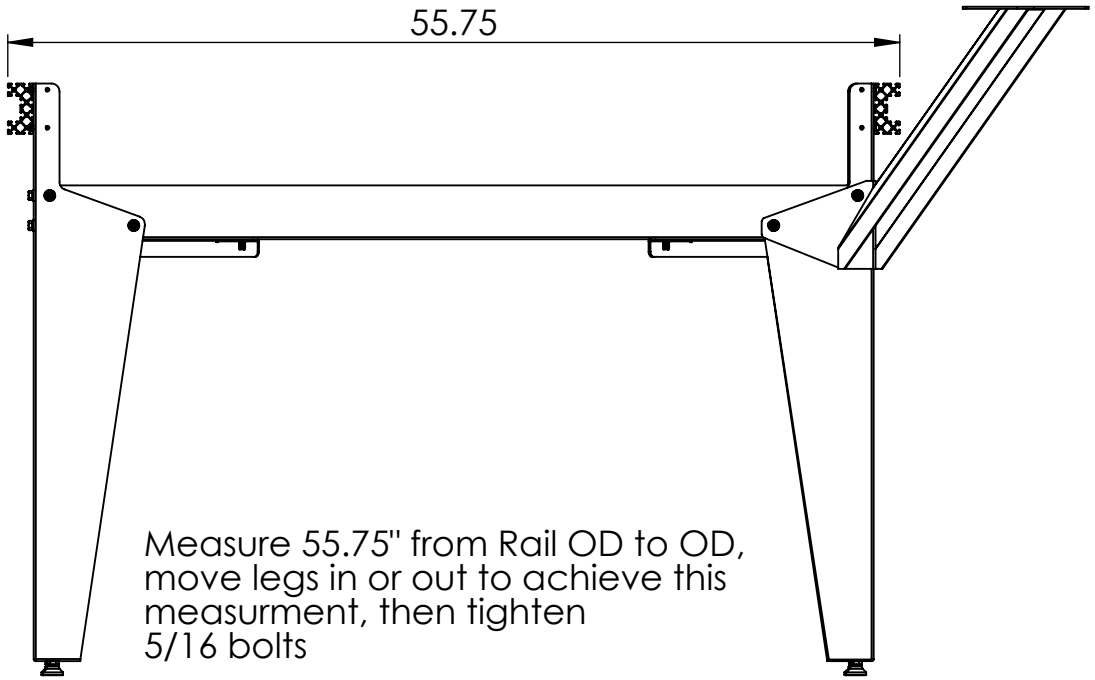
STEP 5



DETAIL B
SCALE 1 : 5

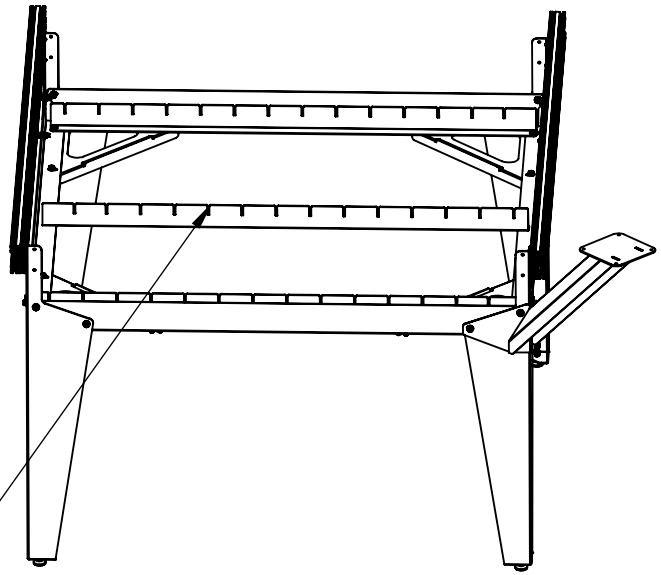
Install 10-32x1/4 Capscrews & Tee Nuts
Slide C-Bean Aluminum Extrusion on the Tee Nuts & flush with legs on 1 end, & Tighten

STEP 6



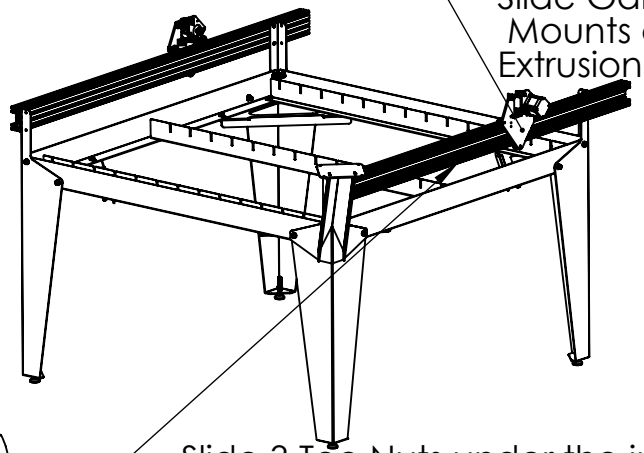
Measure 55.75" from Rail OD to OD, move legs in or out to achieve this measurment, then tighten 5/16 bolts

STEP 7

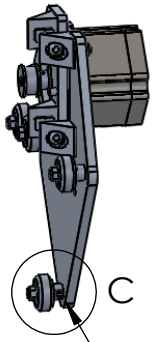


Install 3 Slat Holders with the center postioned to curve the slat

STEP 8

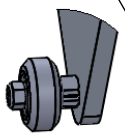


Slide Gantry Plate Mounts on EA. Extrusion



Slide 3 Tee Nuts under the inside track of the Extrusion closest to the computer stand

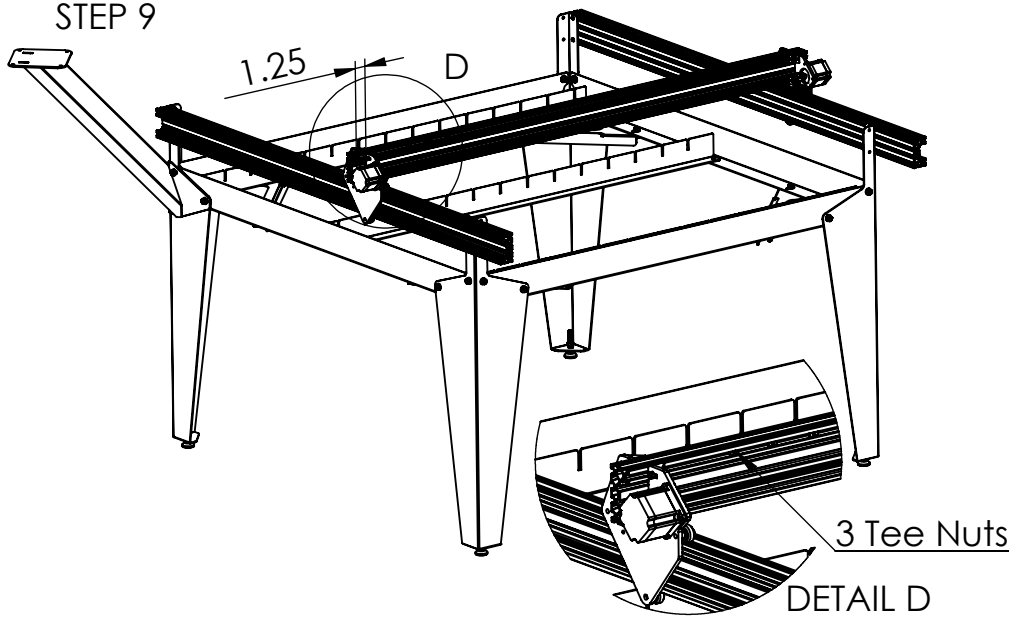
Ecentric Nut, V Cutout indicates lowest tension-rotate to adjust to ensure wheels are snug to track



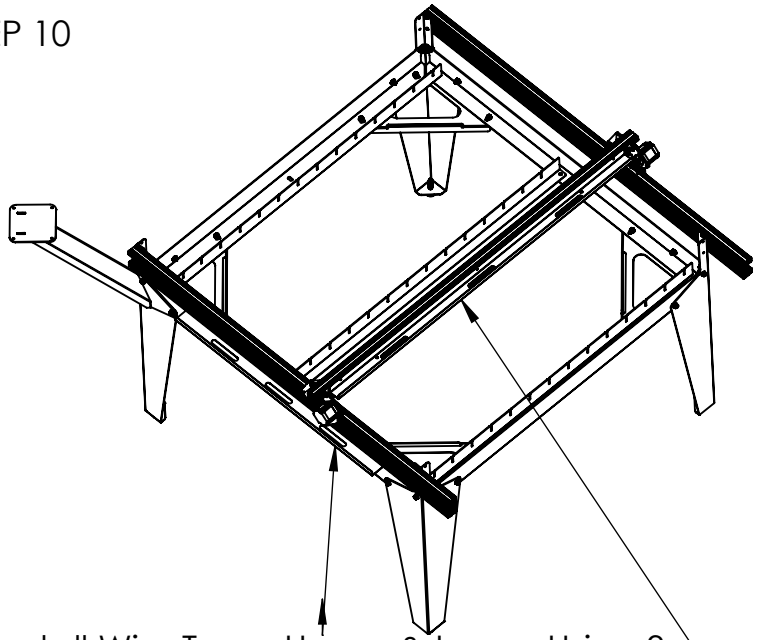
DETAIL C

After Installing, use 5/16 wrench to adjust Ecentric Nut to tighten wheels untill they are snug on the Extrusion V-Slot

STEP 9

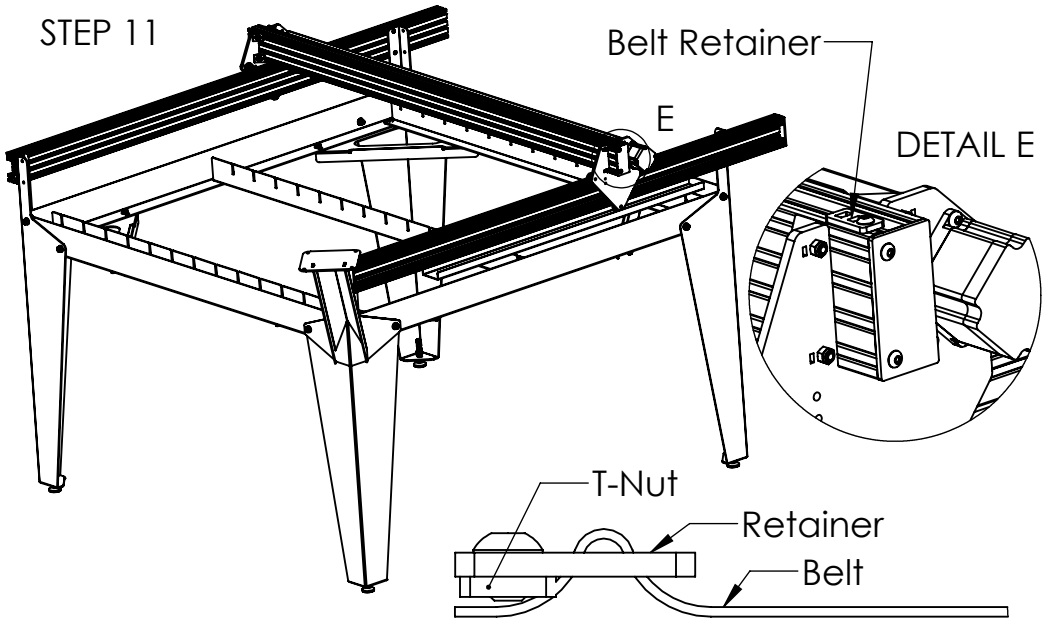


STEP 10



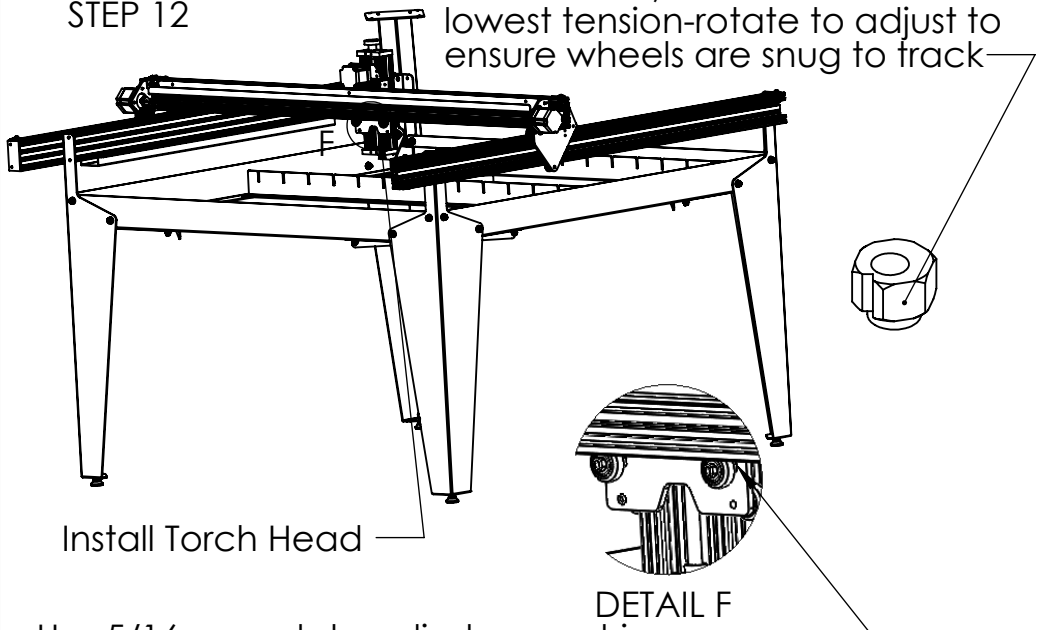
Install Wire Trays, Upper & Lower Using 3 10-32x1/4 Capscrews into the Tee Nuts

STEP 11



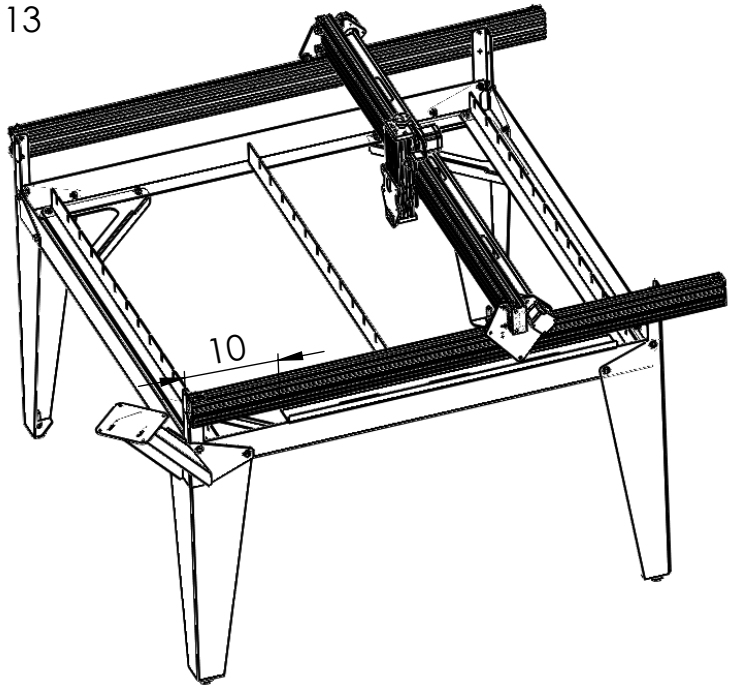
Install Belt Retainer with 10-32x1/4 Capscrew & Tee Nut & End Cap Plate with 10-32x5/8 Capscrew. Belt Threaded through retainer as shown. After install, pull belt retainer to insure a good amount of tension on belt

STEP 12



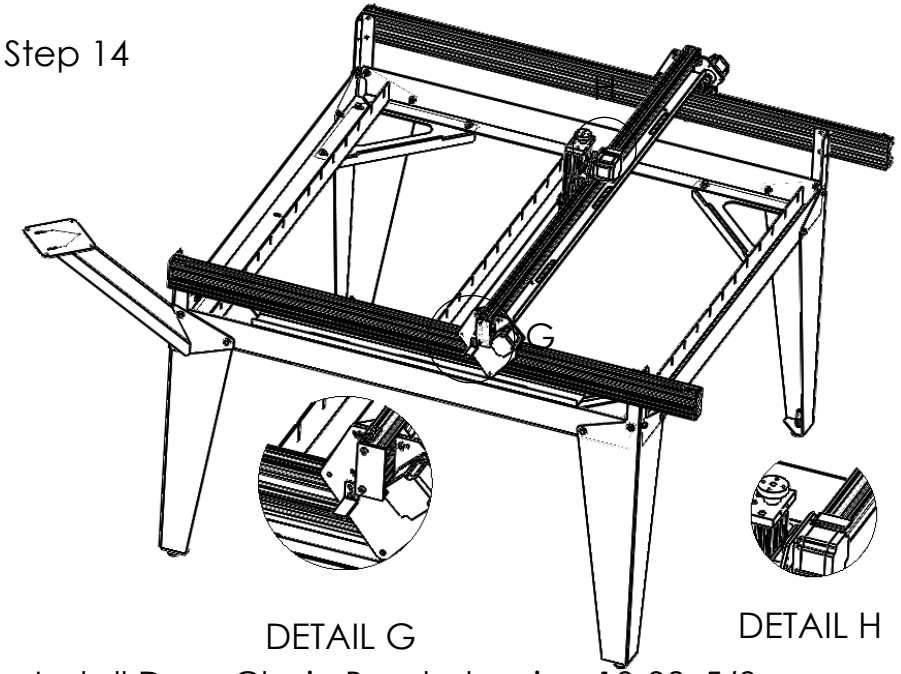
Use 5/16 wrench to adjust eccentric nuts until wheels are snug on V-Slot, remove lower wheels to access, then reassemble and adjust the eccentric nuts on those lower wheels

Step 13



Install Wire Trays using 10-32x1/4 Capsrews into Tee Nuts

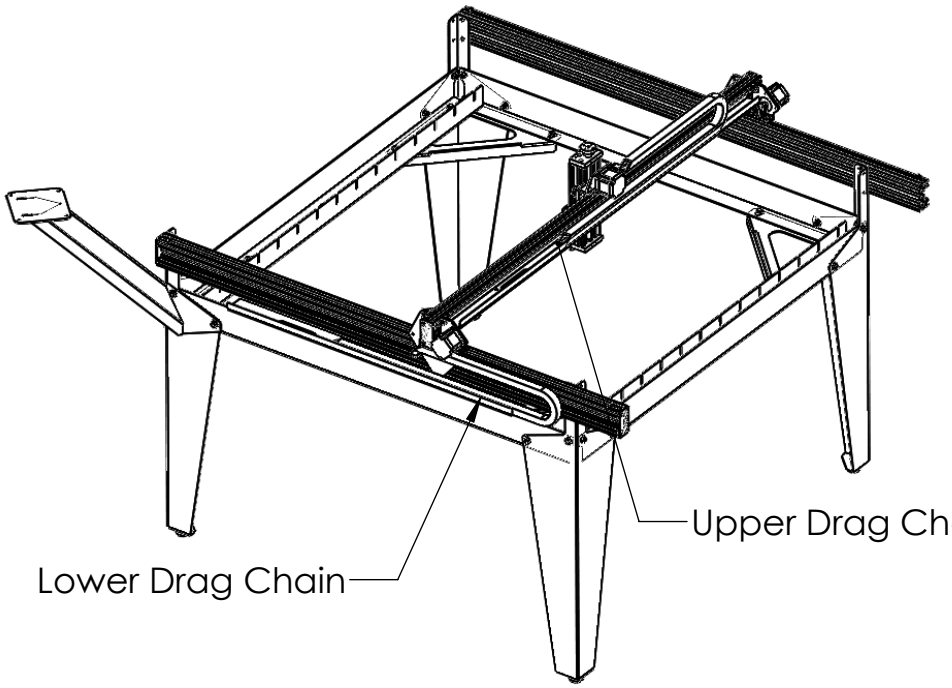
Step 14



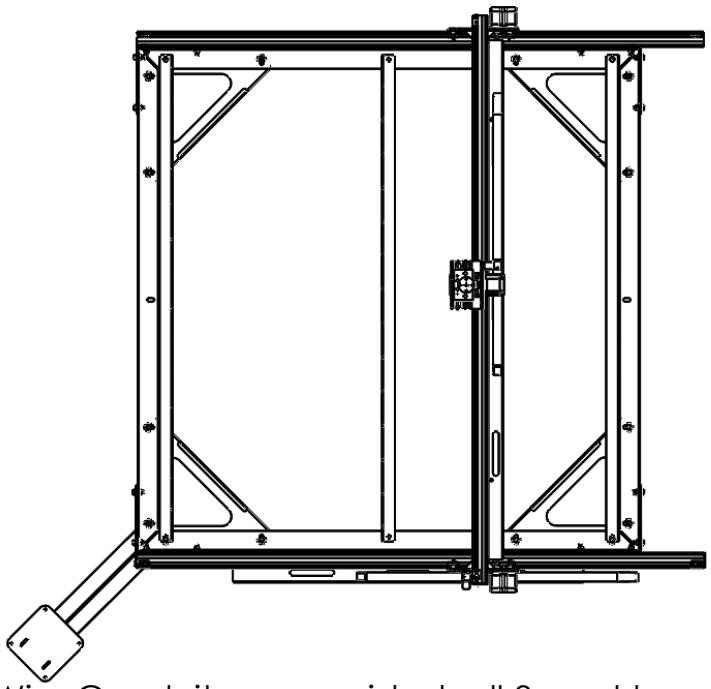
DETAIL G

DETAIL H

Install Drag Chain Brackets using 10-32x5/8 Capscrews or Rivets

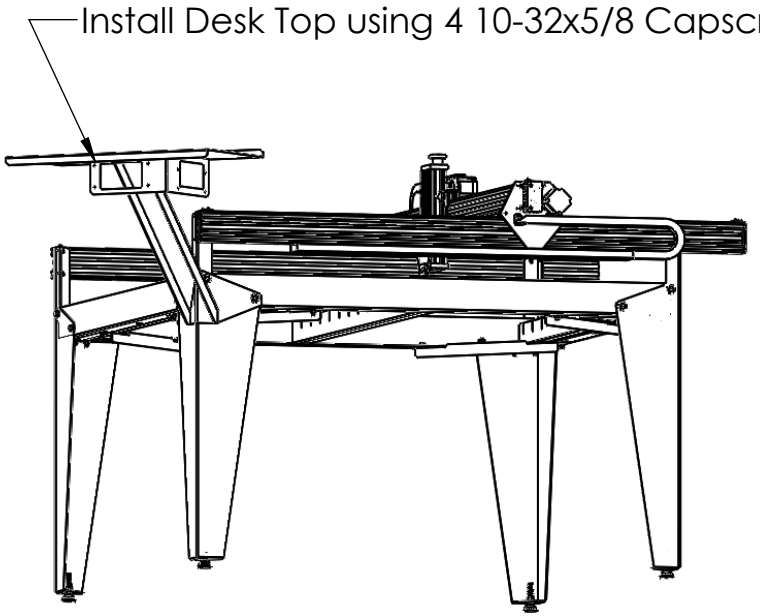


Push Gantry & Torch Head to their max travel to ensure full extension of Drag Chain to position it, then drill the tray to rivet or bolt the Chain

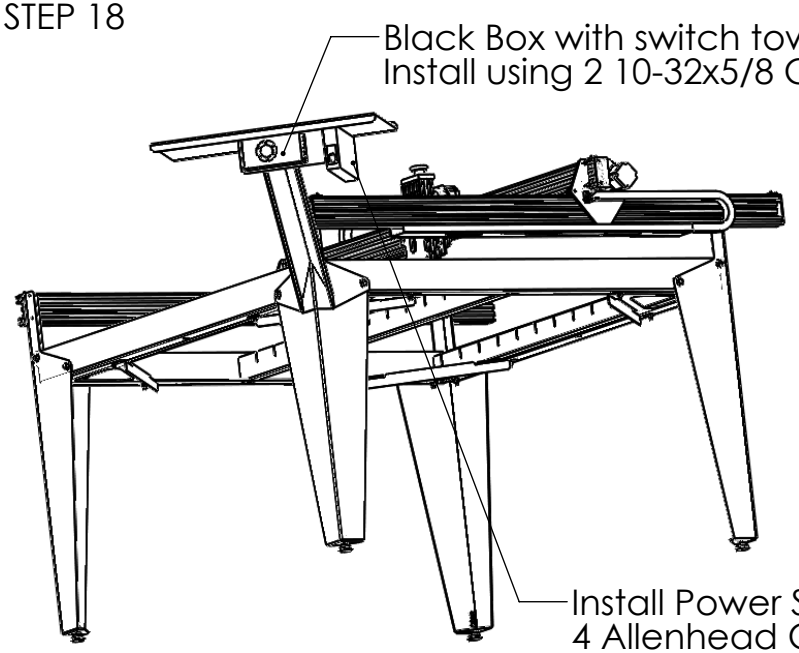


3 Wire Conduit are provided, all 3 must be run thru the lower drag chain, one long must run thru the upper
The torch head is considered the X Axis
The gantry is considered Y1 & Y2

STEP 17



STEP 18



STEP 19

Connect Wire as Shown, Y2 has a different color combination to account for the direction change from Y1
When connecting at the motors, match color to color on all motors

STEP 20