

Step 2

Assemble the X and Y Slides

The X and Y slides are put together using 5/16-18 button head screws and T-nuts. They must be square with each other and centered as shown below. The better you square these two parts the better the machine will make parts square.

Put together the button head screws and T-nuts. Then slide the T-nuts into the Y axis slide so that 3 button head screws stick out of each of the slots on one side of the extrusion. (See Fig. 4) Slide the X axis slide on to the Y axis slide so that you can get at the heads of the screws through the 6 holes in the X axis slide. (Fig. 5) Square and center the X and Y axis slides with each other and tighten the 6 screws with a 3/16" hex wrench. These must be good and tight but not so tight as to strip out the T-nut's. The minimum Torque should be 10 Ft-lbs. The Maximum torque is 15 Ft-lbs. (Fig. 6)

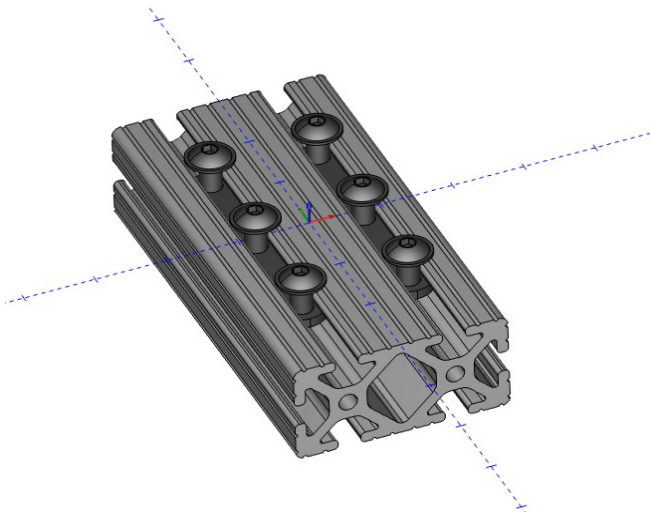


Fig. 4

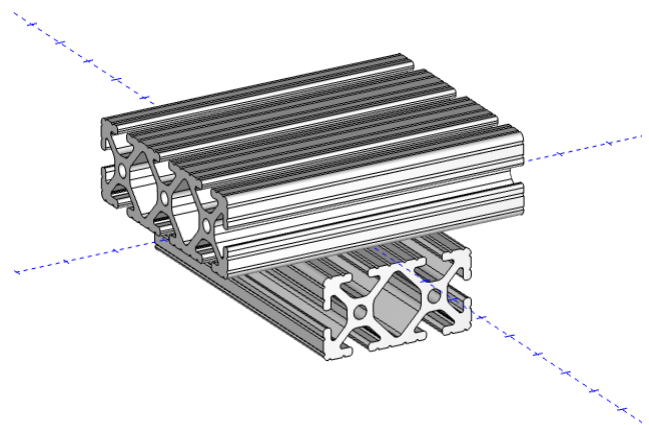


Fig. 5

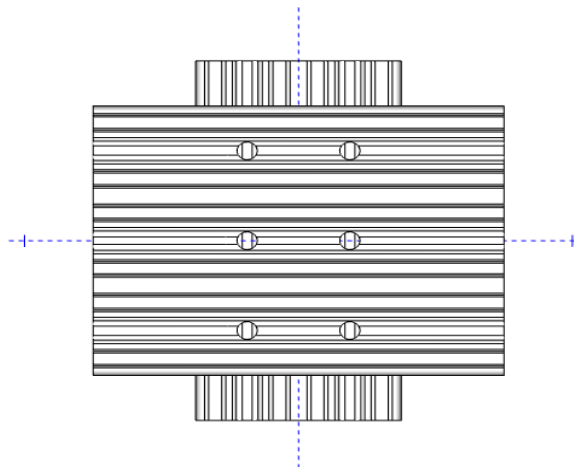


Fig. 6