

This manual will aid in the assembly of the Aluminum T-Slot Table for the FireBall V90 and FireBall X90 CNC Machine. The assembly of the Spoil Board will be the same on either the FireBall V90 or the FireBall X90 machine.

Step #1

Lay all parts out to verify quantities.

The V90 table will have the following items:

- (4) Aluminum T-Slot panels
- (2) Aluminum Support Bars
- (4) 1/4-20 Socket Cap Bolts with Washers
- (16) T-Nuts and Socket Cap Bolts

The X90 table will have the following:

- (4) Aluminum T-Slot panels
- (2) Aluminum Support Bars
- (4) 1/4-20 Socket Cap Bolts with Washers
- (24) T-Nuts and Socket Cap Bolts



(V90 T-Slot Table Shown)

Step #2

Place all of the panels flat with the side with 2 slots facing up. Then insert a single T-Nut into each slot at both end of each panel.



Step #3

Place a Aluminum Support Bar at each end of the Spoil Board with the tapped holes toward the inside. Then take the M5 x 18mm Socket Cap Screws and thread them into the T-Nuts as shown. Do this to both ends of the spoil board.



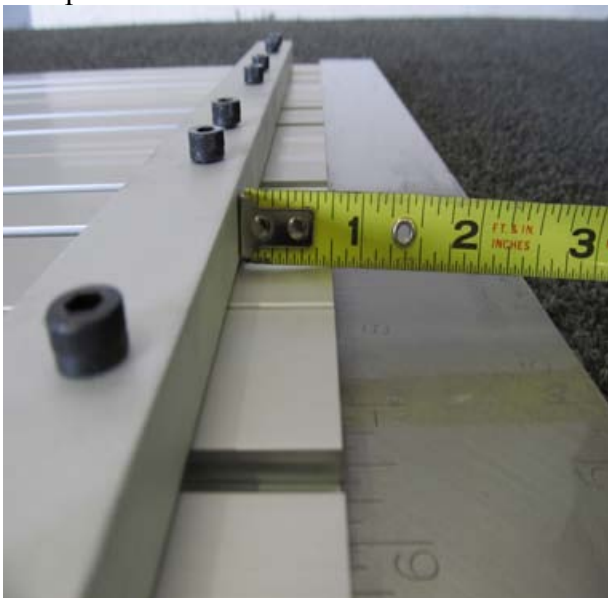
Step #4

Use a square or something with a true edge to line up the ends of the panels.



Step #5

Then using a tape measure or something that is $\frac{3}{4}$ " of an inch thick. Move the Aluminum Support Bar towards the middle of the Spoil Board until it is $\frac{3}{4}$ " of an inch from the end. Do this to both ends of the Spoil Board.



Step #6

Tighten all of the M5 x 18mm bolts until the assembly is tight. Do this to both ends of the Spoil Board. Once this is done then place the assembled Spoil Board on to the machine.



(Shown without gantry installed. Gantry must be installed before Spoil Board goes on)

Step #7

Remove the pronged T-Nut from the bottom of the MDF support bars on the machine. There will be a total of (4) to remove.



Step #8

Once the pronged T-Nuts are removed then insert the (4) 1/4-20 x 3.5" Socket Cap Screws up through the MDF Support Bar and into the Aluminum Support bar. Tighten so the table is mounted solid, but do not over tighten the bolts.



Step #9

ENJOY!!!