

Table Assembly Manual for 2018 and Later Aluminum Stands

Each Kit will include:

64 – M6 x 12mm Socket Cap Screws

64 – M6 T-nuts

16 – Corner Brackets

8 – M5 x 20mm Socket Cap Screws

5 – M5 Push in T-Nuts

5 – M5 x18mm Socket cap screws

16 – 5/16” - 18 x 1” Socket Cap Screw **QTY for Castors 24, QTY for Feet 8**

8 – Plastic end caps(4 rectangular, **0 square**)

4 – 60/60 Base plates

4 – Leveling feet or casters(depending on which option chosen)

1 – MDF Shelf

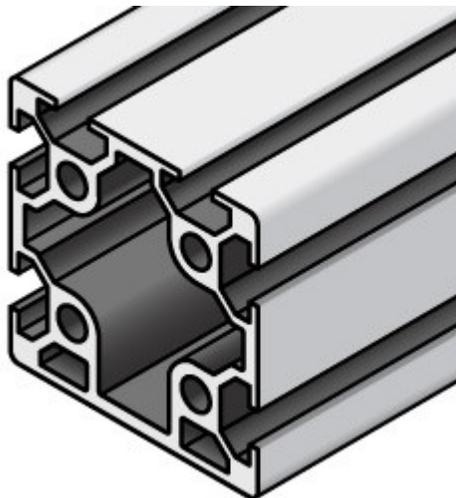
4 - Machine Pads for Castors, 8- Feet Adapters for leveling table feet

12 – Aluminum Extrusions per kit. Please see chart below for corresponding sizes.

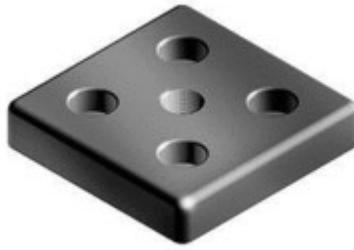
Extrusion:	Comet	Asteroid	Meteor	Nebula
1528 mm			2	2
1414 mm			2	2
987 mm		4		4
832 mm	2	2		
704 mm	4		4	
718 mm	2	2		
692 mm 60/60	4	4	4	4

Assembly Procedure:

- 1) After removing all hardware from its packaging you will need to lay out the four 60/60 692 mm square extrusions.



- 2) At this time you will want to install the 4 base plates (**or feet adapters**) to threaded side of the extrusions using the 5/16” - 18x 1” Socket cap screws



- 3) Next you will take the four rectangular extrusions that are of the same size and slide four M6 T-nuts in both the top and bottom slots of one side, on all four extrusions.
- 4) Next you will secure the corner brackets into these T-nuts using your M6-12mm socket cap screws, with the opposite side of the brackets facing in towards another paired 60/60 extrusion.
- 5) With the brackets loosely secured to the 60/60 extrusions, place a pair of the four common sized extrusions within the brackets between a pair of your 60/60 square extrusions.
- 6) Next step you will slide the corresponding amount of T-nuts into the 30/60 extrusion to be able to secure the 30/60 extrusion to your 60/60 legs. Measure the bottom of the 30/60 extrusion to the base plate to ensure your shelf is at the desired height, and start with bottom extrusion while securing them down as you will not be able to slide T-nuts further past your top most extrusion. Place the top 30/60 extrusions level with the top of the 60/60 extrusion.
- 7) When all four extrusions have been attached to each pair of legs you should have the front and back of the table assembled and laying face down.
- 8) Next you will take the middle sized extrusions. That will be the lowest cross bar for the Y-axis of your table. Set up the corner brackets and T-nuts just like you did for the front and back cross bars. Chose only one side of the table, either front or back, and secure both of these extrusions to that single side at the same height as your lower cross bars on the front and back.
- 9) With the middle sized extrusion secured to either the front or back and perpendicular to it and the ground, slowly stand the front/back up to its correct position. Stand the other front/back assembly up to the new crossbars (you may need a friend to hold one side for you) and secure the crossbars to the other side at the appropriate chosen height.
- 10) Next you will take the two longest extrusions and secure the corner brackets as you did the extrusions before. Secure them to the table assembly like you did with the other extrusions level with the top of the 60/60 extrusions, on the outside of the table assembly.
- 11) Now you will assemble the shelf. Take your five M5 x 18mm socket cap screws and place them in the five outer holes on the mdf shelf.
- 12) Next take the five push in T-nuts and loosely secure them onto the screws.

- 13) Place the shelf on the lower extrusions in the front of the table allowing the T-nuts to drop in the channels on the top of the extrusions. Tighten the M5 x 18mm screws.
- 14) Next, lift each leg individually and thread your feet or casters to the appropriate, level, height.
- 15) **Now attach the machine mounting pads to the tops of the 6060 extrusion.**
- 16) Use the **eight remaining M5 x 20mm socket cap screws** to secure your machine to the table using the holes provided at the bottom of each of the machines feet.
- 17) Now place the protective black plastic end caps on the top of the square 60/60 extrusions and the ends of the two longest cross bar extrusions.
- 18) **If the machine does not fit on stand properly, and there is a gap between the mounting pads and the back of the feet. You may need to loosen the bolts that hold the front and back to the stand (1 side at a time) and either pulling the top front in or out depending on where it has a gap or is too tight. One way to ensure your stand is square is by measuring the top and bottom of the lengths of each side. They should all be the same so your machine fits on top square so there are no issues with the machine performance.**