Remove & Replace the Tooling Plate (Table)

SHCS M5 x 14 (4)
SHCS M5 x 30 (12)
Torque to 60 in-lbs)

SHCS 1/4-20 (4)
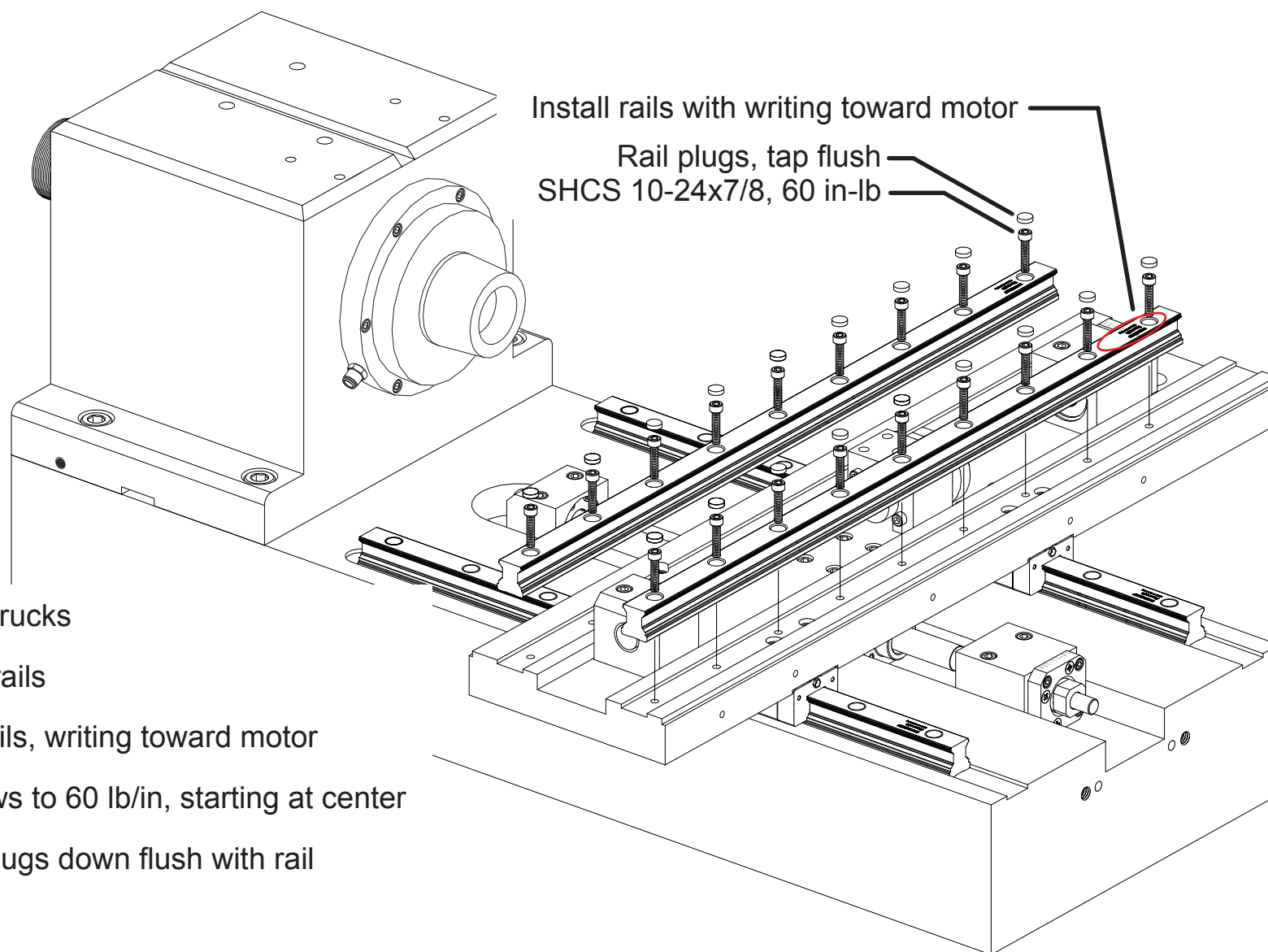Torque to 80 in-lbs
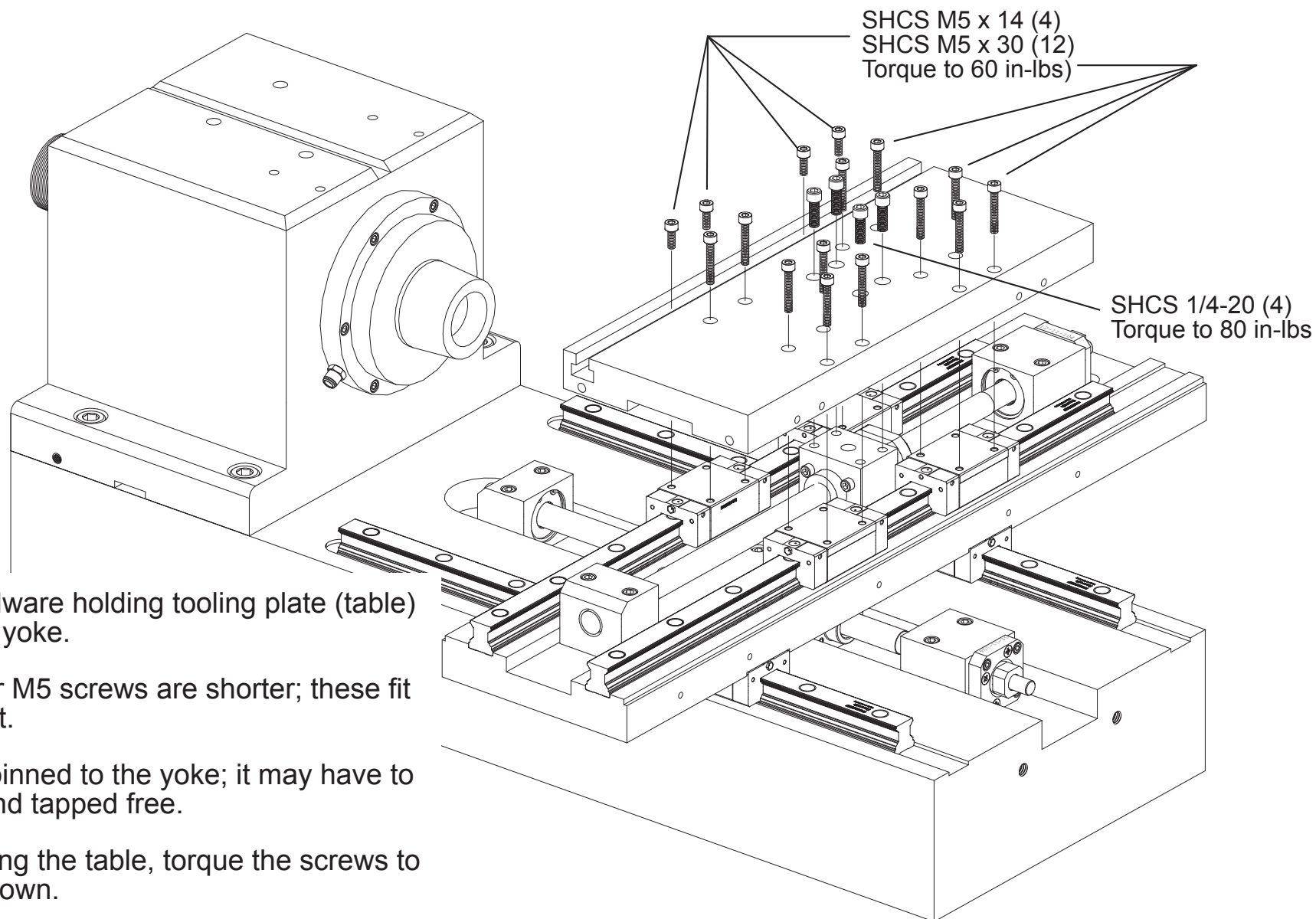
Remove hardware holding tooling plate (table) to trucks and yoke.

Note that four M5 screws are shorter; these fit holes in T-slot.

The table is pinned to the yoke; it may have to be wiggled and tapped free.

When replacing the table, torque the screws to the values shown.

Remove & Replace X-axis Rails

Install rails with writing toward motor

Rail plugs, tap flush
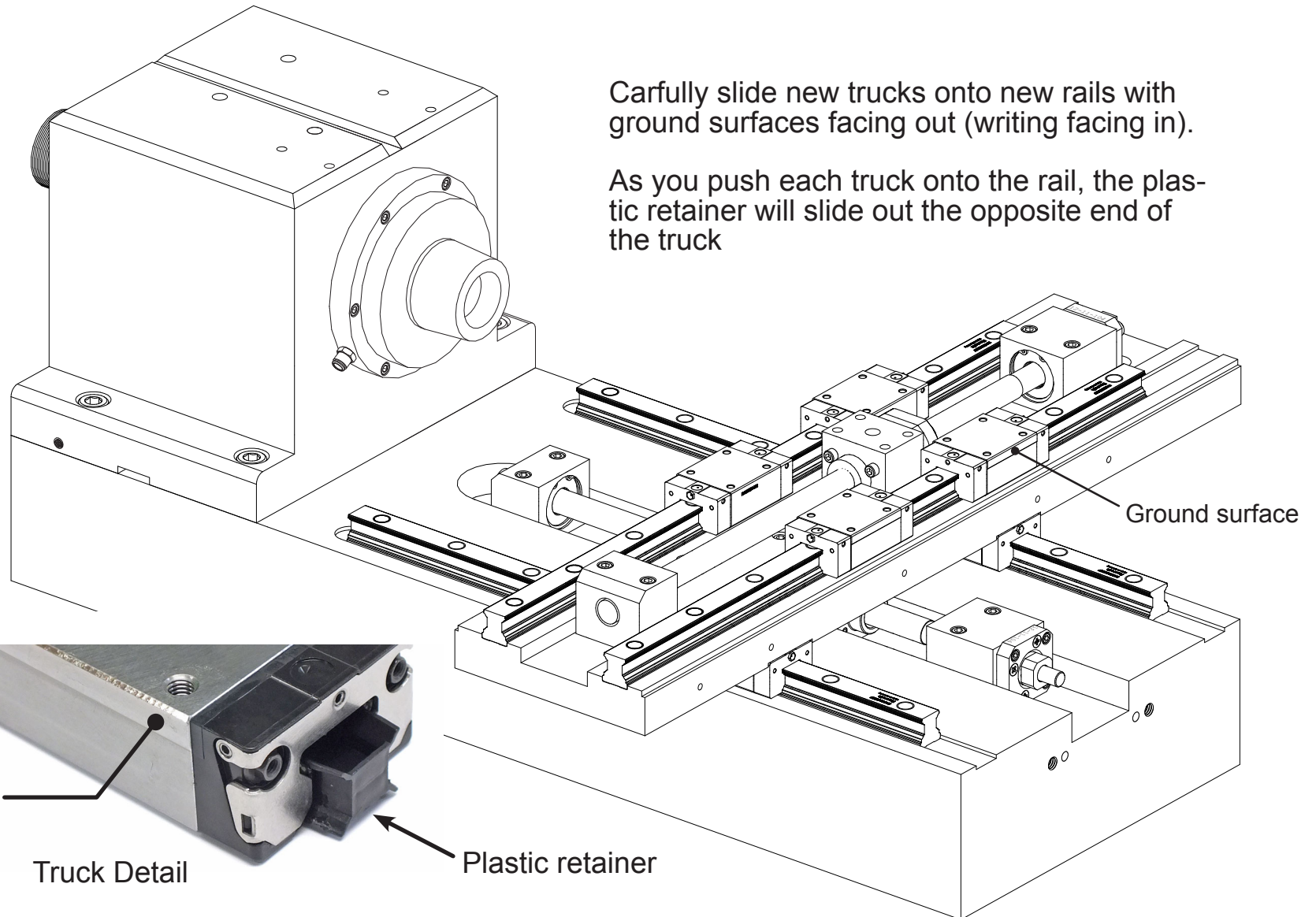SHCS 10-24x7/8, 60 in-lb

Remove old trucks

Remove old rails

Install new rails, writing toward motor

Tighten screws to 60 lb/in, starting at center

Tap the rail plugs down flush with rail

Replace X-axis Trucks

Carfully slide new trucks onto new rails with ground surfaces facing out (writing facing in).

As you push each truck onto the rail, the plastic retainer will slide out the opposite end of the truck

Ground surface

Ground surface

Truck Detail

Plastic retainer

Remove & Replace the Saddle
Note: X-axis rails must be removed to remove saddle

SHCS M5 X 25: outside (60 in-lb) (8)
SHCS M5 x 20: inside (60 in-lb) (8)
SHCS 1/4-20 x 3/4 (80 in-lb) (4)

Remove hardware holding saddle to trucks
and yoke.

Note that eight M5 screws are shorter; these
fit holes on the inside.

The saddle is pinned to the yoke; it may have
to be wiggled and tapped free.

When replacing the saddle, torque the screws
to the values shown.

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Remove & Replace Z-axis Rails

Rail plugs (16), pound flush
SHCS 10-24x7/8 (16), 60 in-lb

Install rails with writing
away from headstock

Remove old trucks

Remove old rails

Install new rails, writing toward motor

Tighten screws to 60 lb/in, starting at center

Tap the rail plugs down flush with rail
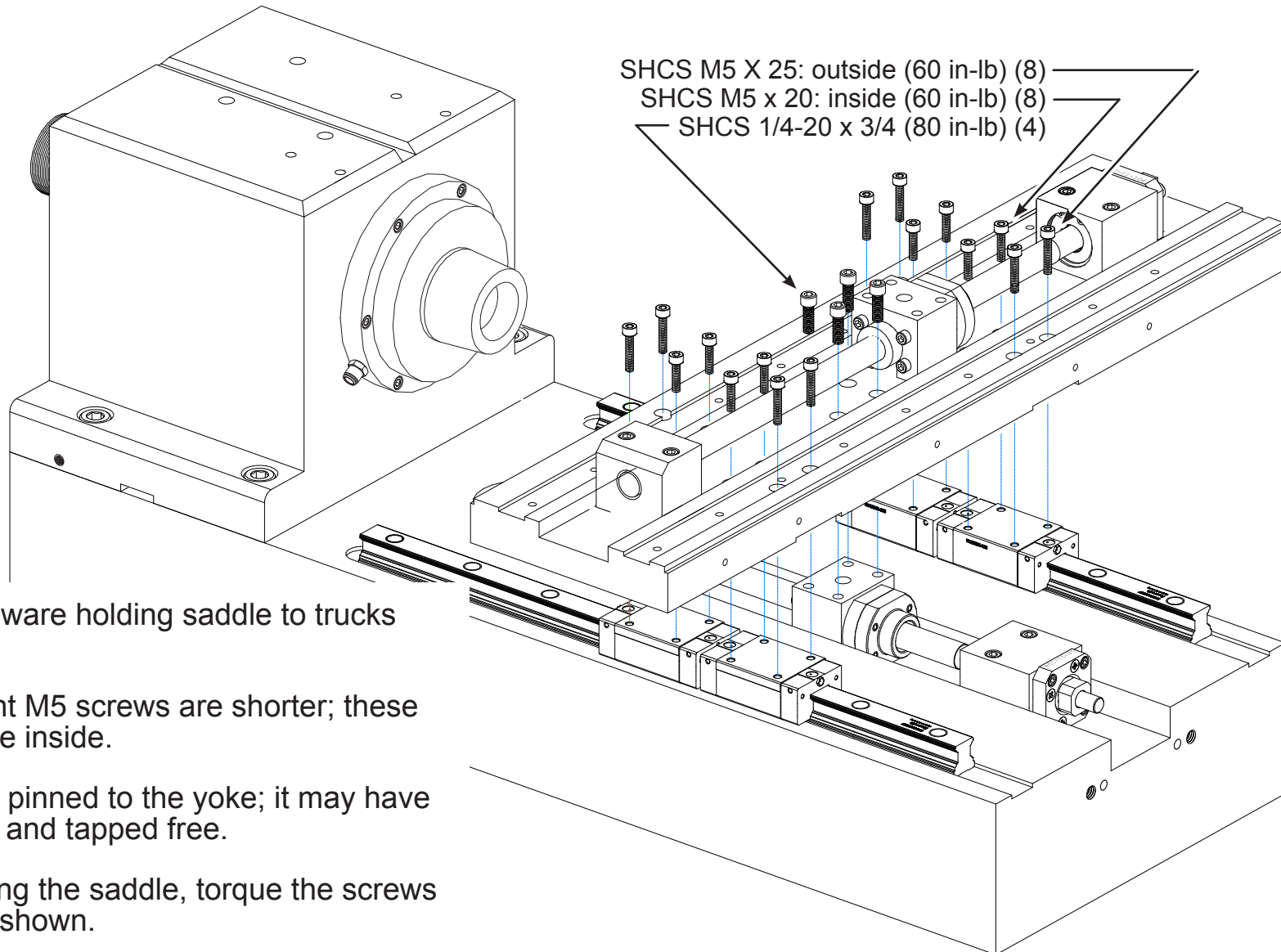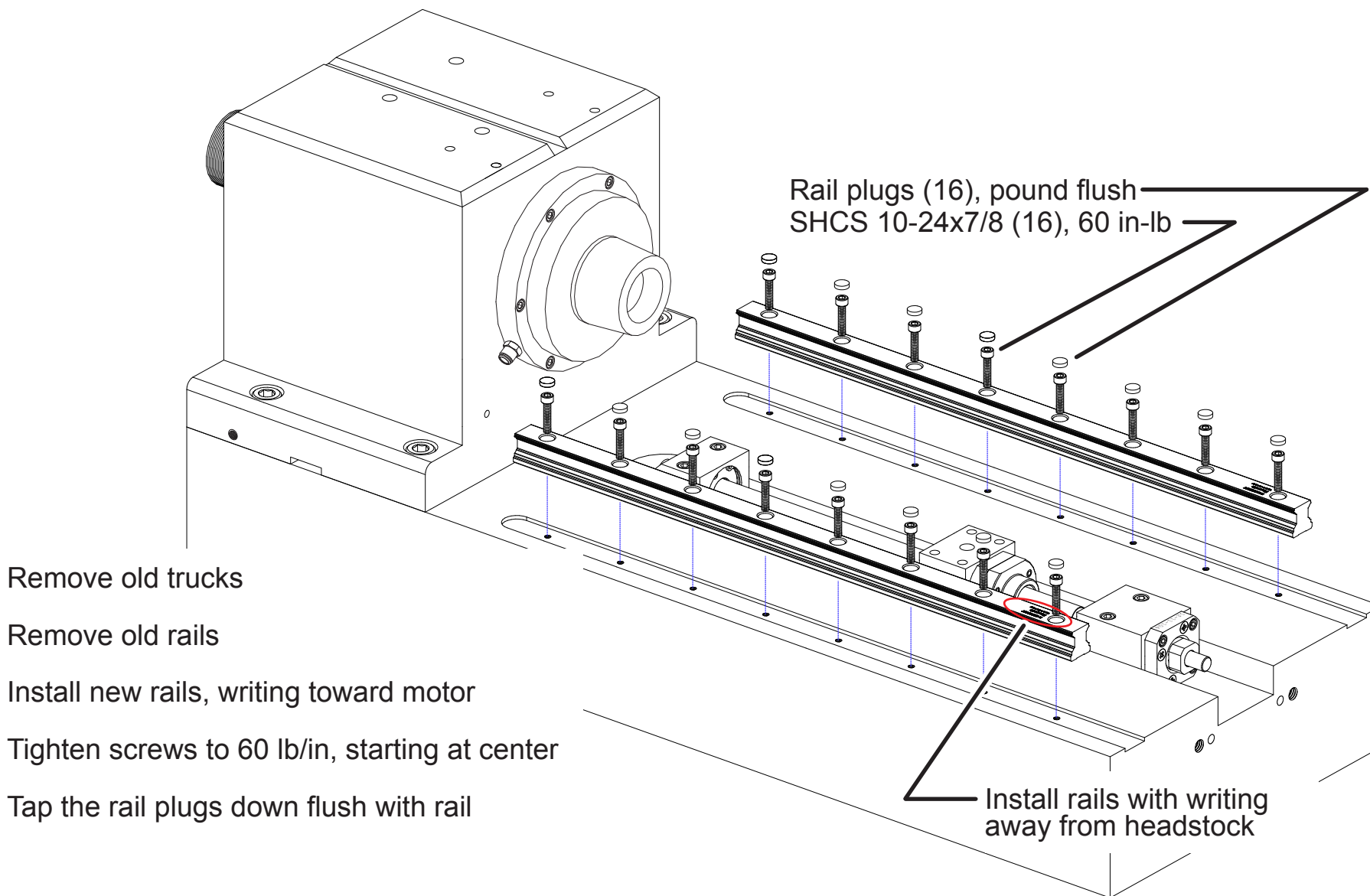
Replace Z-axis Trucks

Carfully slide new trucks onto new rails with ground surfaces facing out (writing facing in).

As you push each truck onto the rail, the plastic retainer will slide out the opposite end of the truck

Writing inside

Ground surface outside

Ground surface

Truck Detail

Plastic retainer