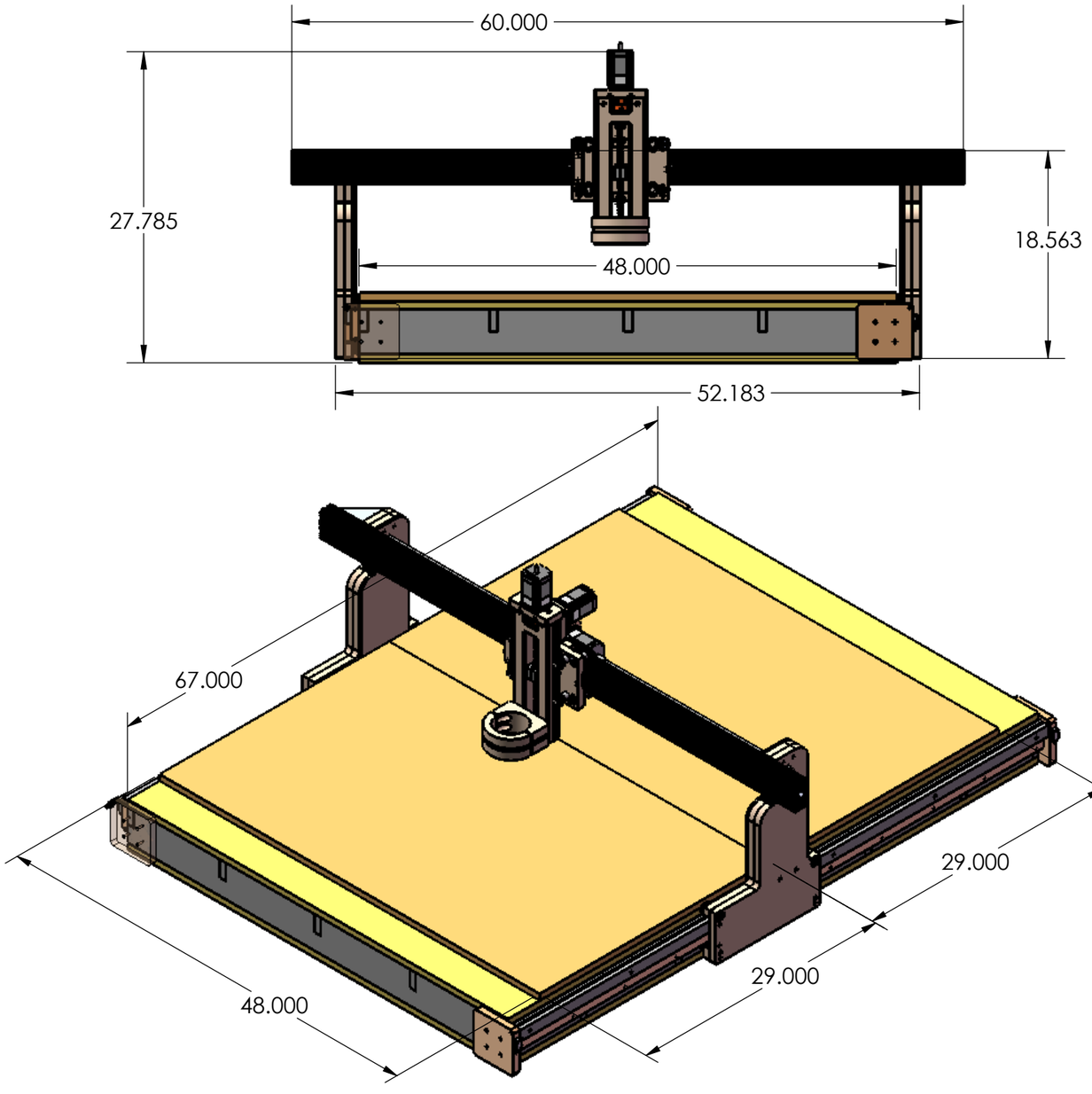
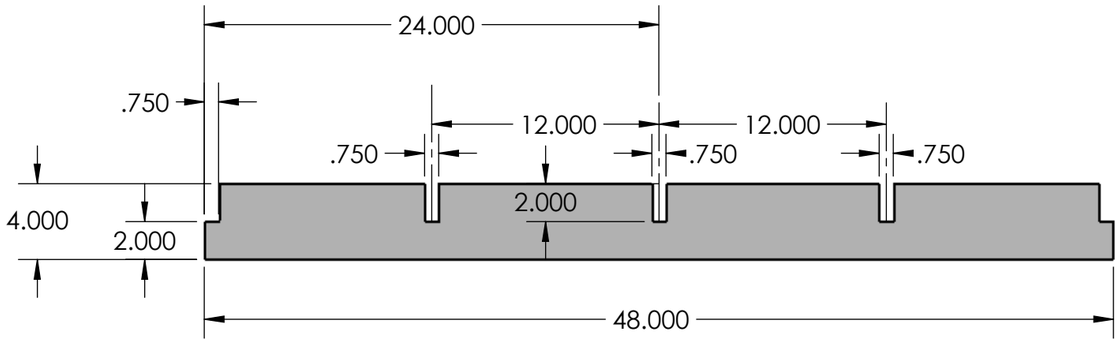
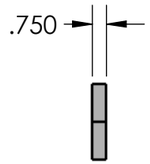
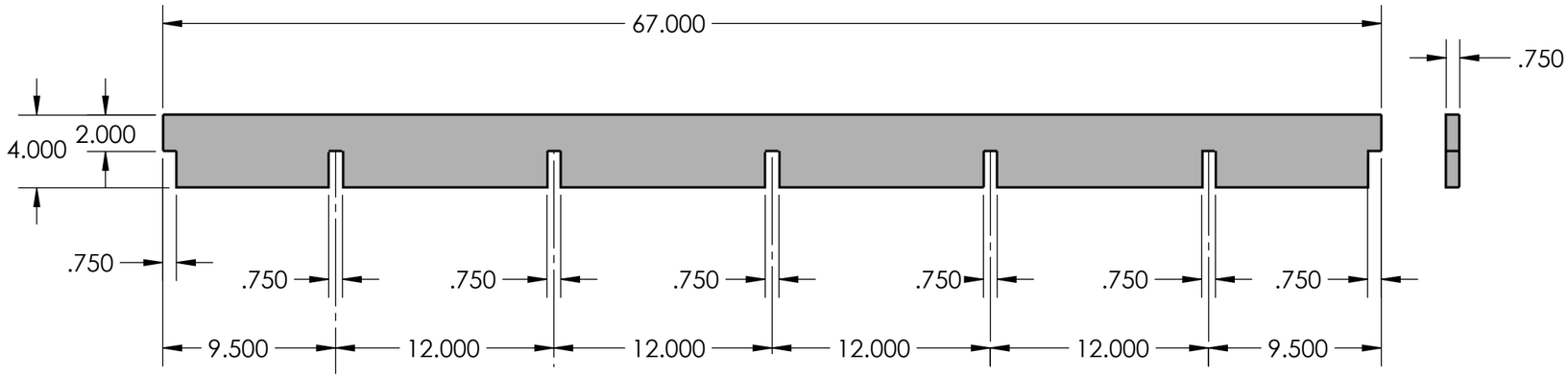
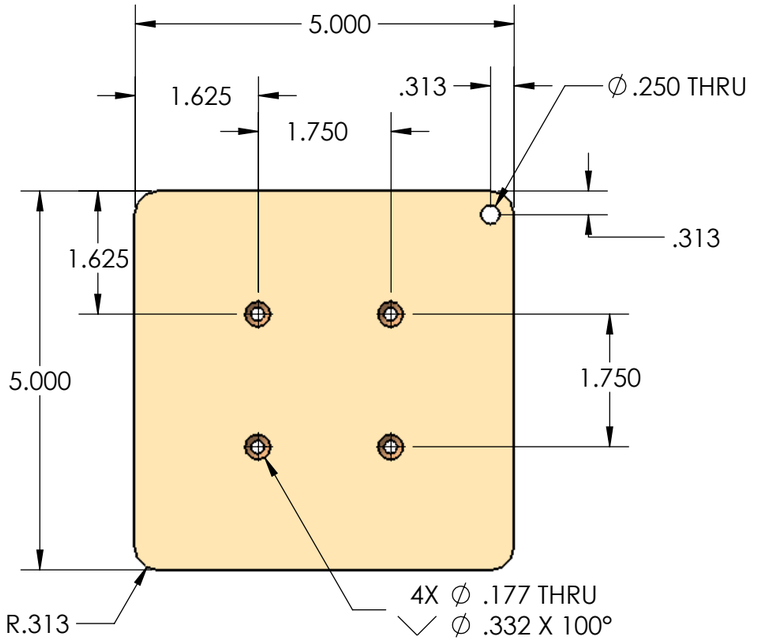


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	Material
1	1	router v mount - rev 3		
2	1	router v cup - rev 2		
3	1	59614	3/8 .2 lead 2 start lead screw	$10.17 ft - ROTON
4	2	6389K624	nylon bushing 3/8 id, .5 od x .75lg	$3.94 PACK OF 5
5	2	9414T800	Set Screw Shaft Collar 3/8 ID	$.72
6	1	Y-Z PLATE rev 3		
7	16	RM2-2RS v-groove bearing	V-GROOVE BEARING	$8.89EA OR 128 FOR 16
8	14	A-Y PLATE .75 lg SPACER		
9	4	HBOLT 0.3750-16x1.5x1-C		
10	1	Nut mount 4 rev 3		
11	1	y-motor mount plate-plywood		
12	3	nema 23 - 425in oz - stepper motor	NEMA 24 Stepping Motor (425 oz-in 1/4" dual shaft)	$49.00
13	1	2737T1	9 TOOTH Sprocket #25 Roller Chain	MCMASTER-CARR $5.61
14	1	motor mount b		
15	6	6663K110	20 tooth idler sprocket	$15.95 Build your own cnc
16	25	link1	CHAIN $2.40 A FT	
17	50	link2	CHAIN $2.40 PER FT.	
18	10	90598A031		
19	2	SBHCSCREW 0.375-16x1-HX-N		
20	1	bearing float block short		
21	1	load block-short		
22	6	90835A200	DOWEL NUT 12MM LG CENTER 1/4-20	BUY ON EBAY or 90835A200 mcmaster-carr
23	8	90598A050	Tee Nut Insert 1/4-20 (5/16 DRILL)	
24	2	HX-SHCS 0.25-20x1x1-S		
25	2	HBOLT 0.3750-16x2x1-C		
26	1	19700	3/8 .2 LEAD SCREW NUT	$27.82 - ROTON
27	2	98694A120		
28	2	HBOLT 0.3750-16x2.5x1-C		
29	2	93298A130	Nylon-Insert Hex Locknut 3/8-16	$8.49 PACK 50
30	1	987-xxxx-00100-02	MAIN POST	8020-1530 LITE X 12INCHES LG
31	2	X PLATE rev 3		
32	2	drive shaft 28.27		
33	2	6389K443	BEARING, FLANGED .2500 ID	MCMASTER-CARR
34	2	2737T1	9 TOOTH Sprocket #25 Roller Chain	MCMASTER-CARR $5.61
35	2	8020-14105-DEFAULT		
36	5	grid 1-67		
37	7	grid 2-60.75		
38	2	4 x 67 x .5 plywood		
39	2	4 x 4 x .75 spoilboard		
40	4	end plate anhcors		
41	1	-	MAKE FROM 1/4-20 X 2.5 BOLT	
42	2	91847A029	Hex Thin (Jam) Nut 1/4"-20 Screw Size, 7/16" Width, 5/32" Height	18-8 SST STL
43	2	7779K14	Miniature Snap-Acting Switch ROLLER	
44	2	X AXIS RAIL-67inch		
45	4	RAIL-67		
46	2	chain support 67		
47	2	X PLATE chain spacer		
48	2	X PLATE chain clocer		
49	1	z-frame		
50	2	13 inch rail		
51	1	z-frame end cap	PLYWOOD PART	
52	2	LOWER SPACER		
53	1	center motor mount 8020		
54	1	8020 center motor mount flange		



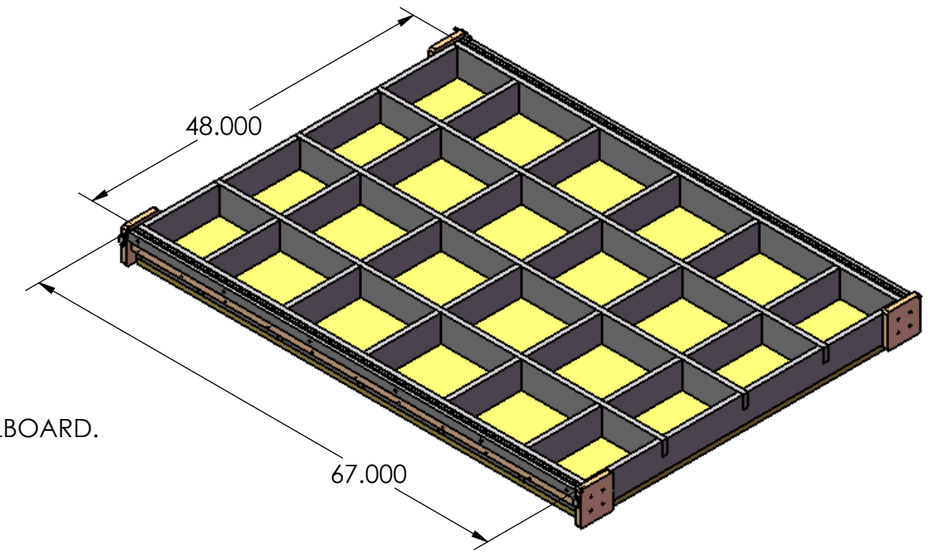


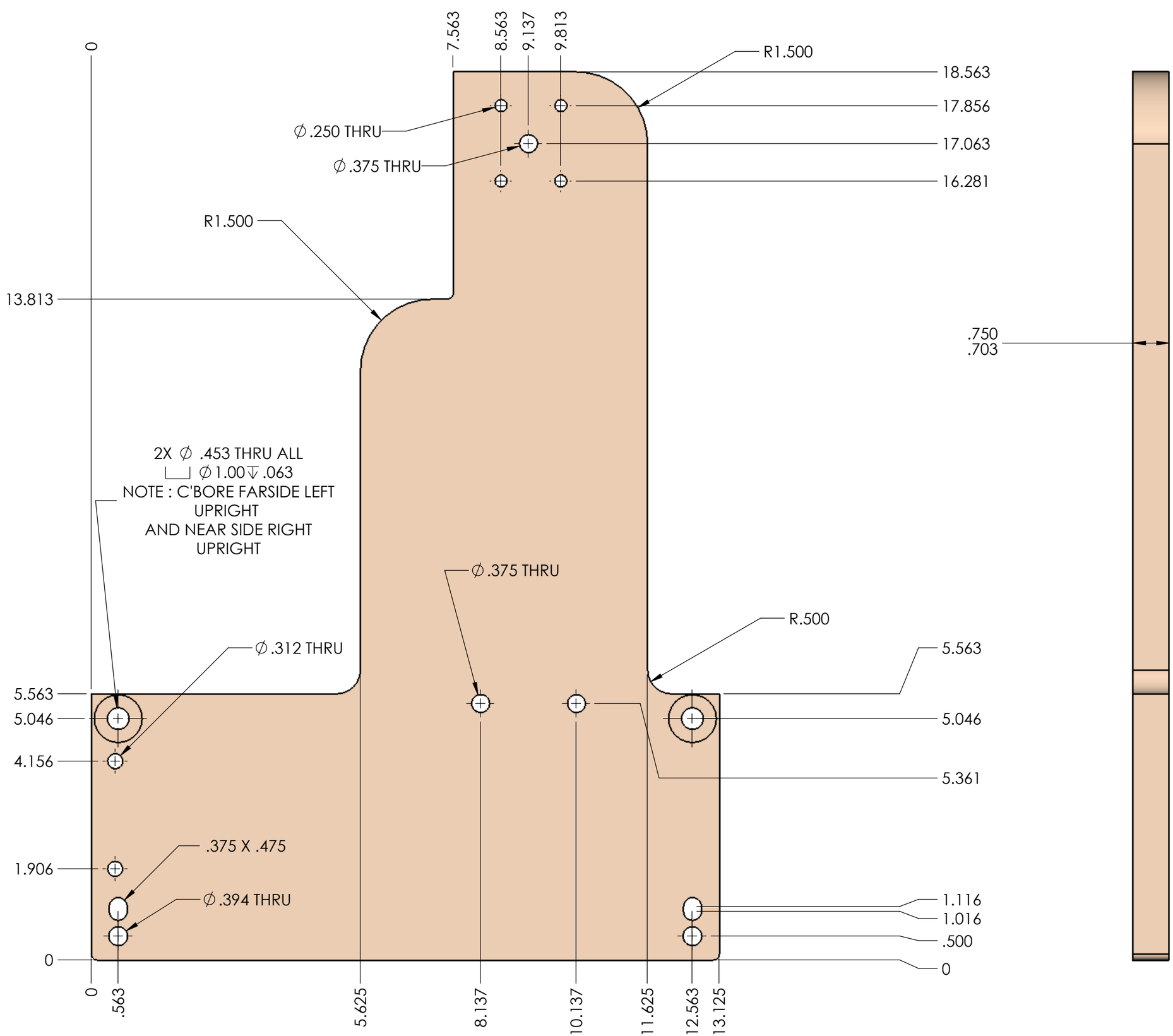


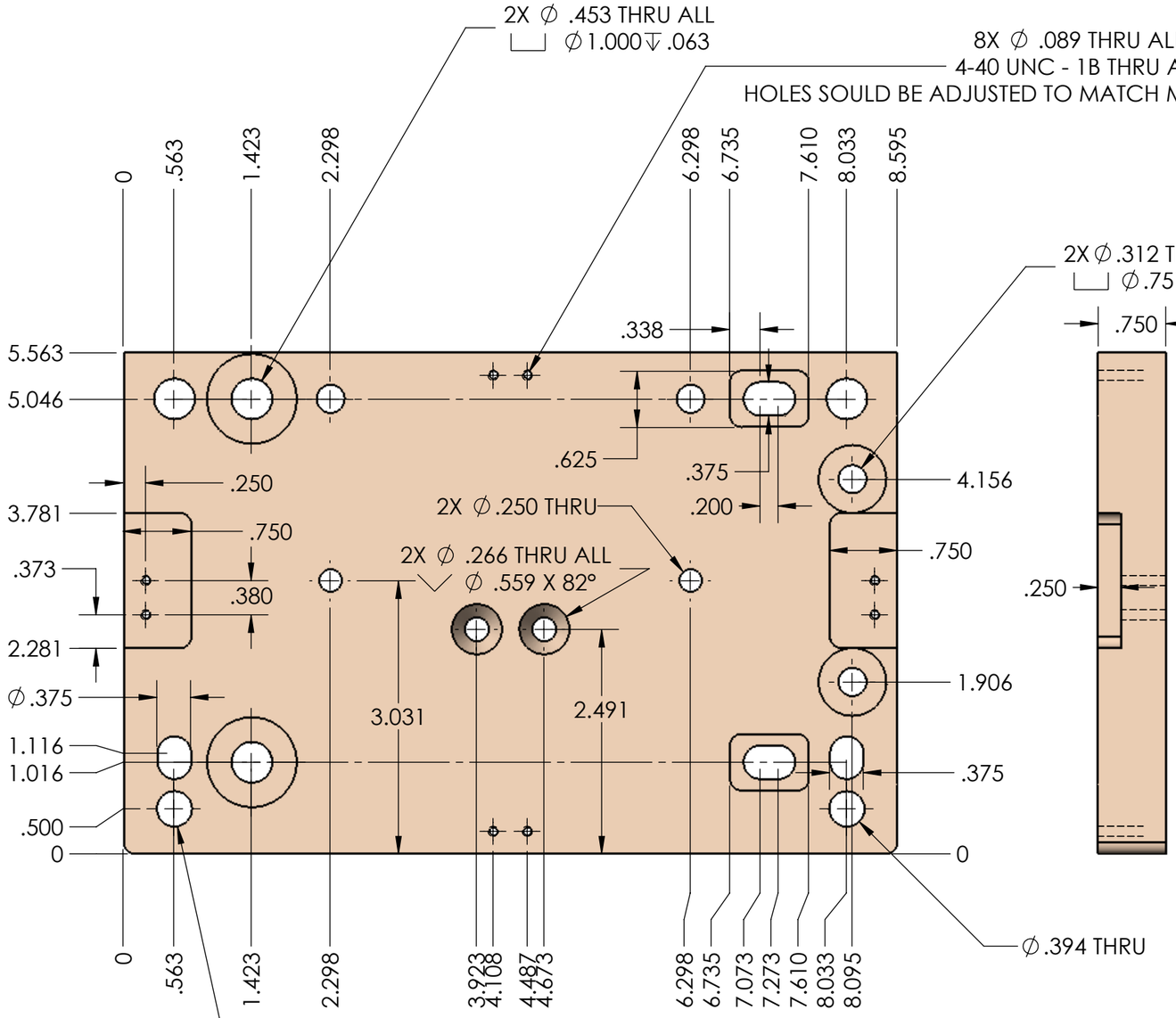


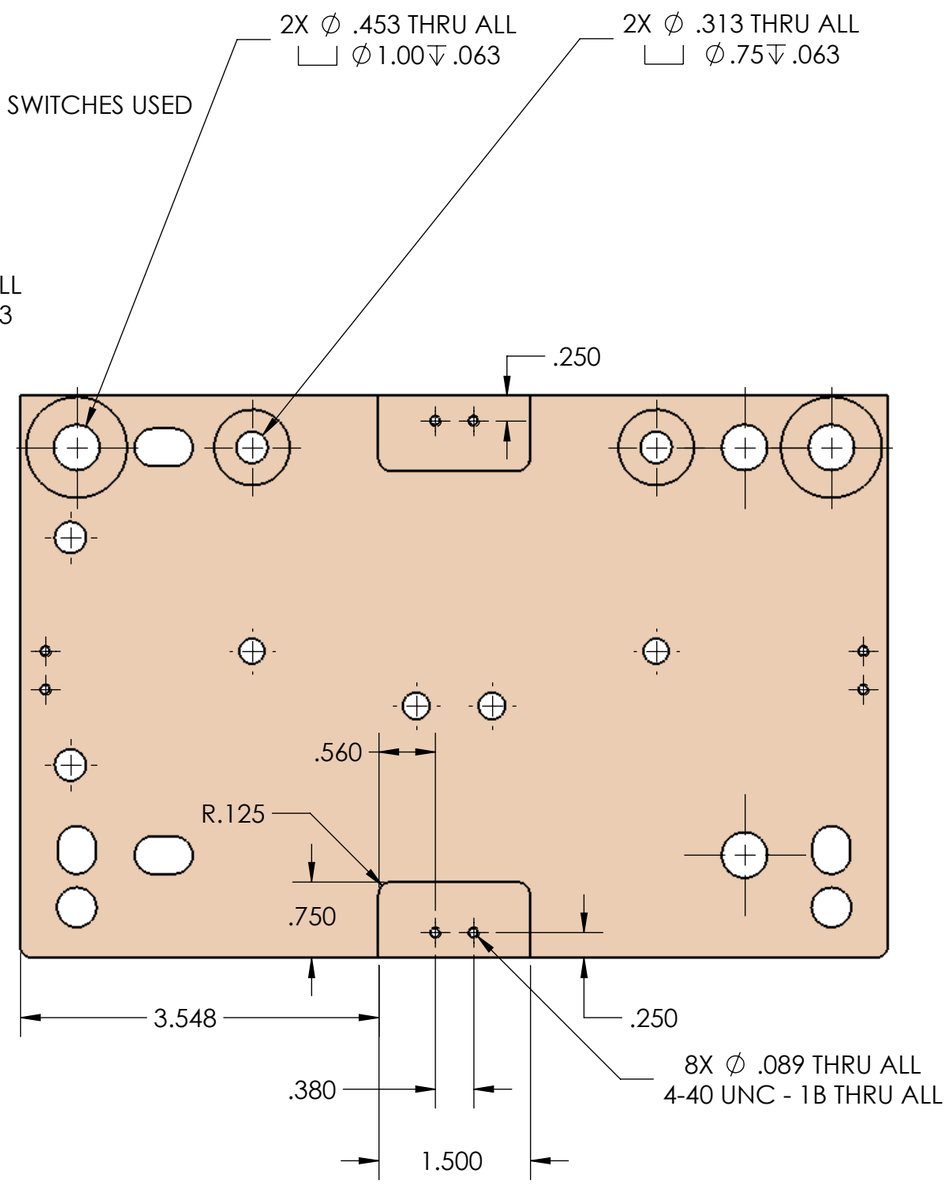
MEASURE YOUR MATERIAL THICKNESS 3/4 IS NOT ALWAYS .750 ADJUST THE .750 DIMS TO MATCH YOUR MATERIAL THICKNESS

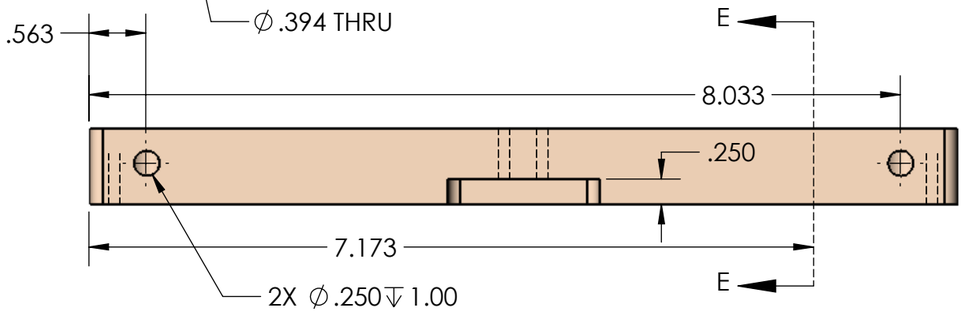
DECK BOTH THE TOP AND BOTTOM CUTTING
PANELS TO MATCH THE SUPPORT FRAMES.
GLUE AND SCREW ON A LEVEL SURFACE.
ANY ERRORS HERE WILL SHOW UP A Z AXIS
ERRORS LATER AND CAN ONLY BE CORRECTED
BY FLY CUTTING YOUR SPOIL BOARD FLAT.
THE REMAINING TWO 29 X 48 BECOME THE SPOILBOARD.

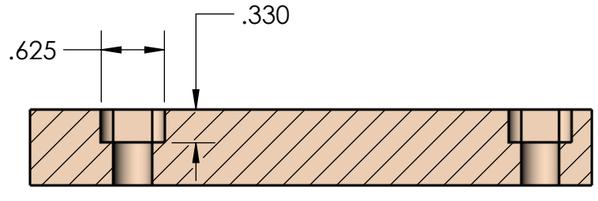



0
7.563
8.563
9.137
9.813
R1.500
18.563
17.856
17.063
16.281
∅.250 THRU
∅.375 THRU
R1.500
13.813
2X ∅ .453 THRU ALL
⌴ ∅1.00↧.063
NOTE : C'BORE FARSIDE LEFT UPRIGHT
AND NEAR SIDE RIGHT UPRIGHT
∅.375 THRU
∅.312 THRU
R.500
5.563
5.046
4.156
5.563
5.046
5.361
.375 X .475
1.906
∅.394 THRU
1.116
1.016
.500
0
0
0
.563
5.625
8.137
10.137
11.625
12.563
13.125
.750
.703

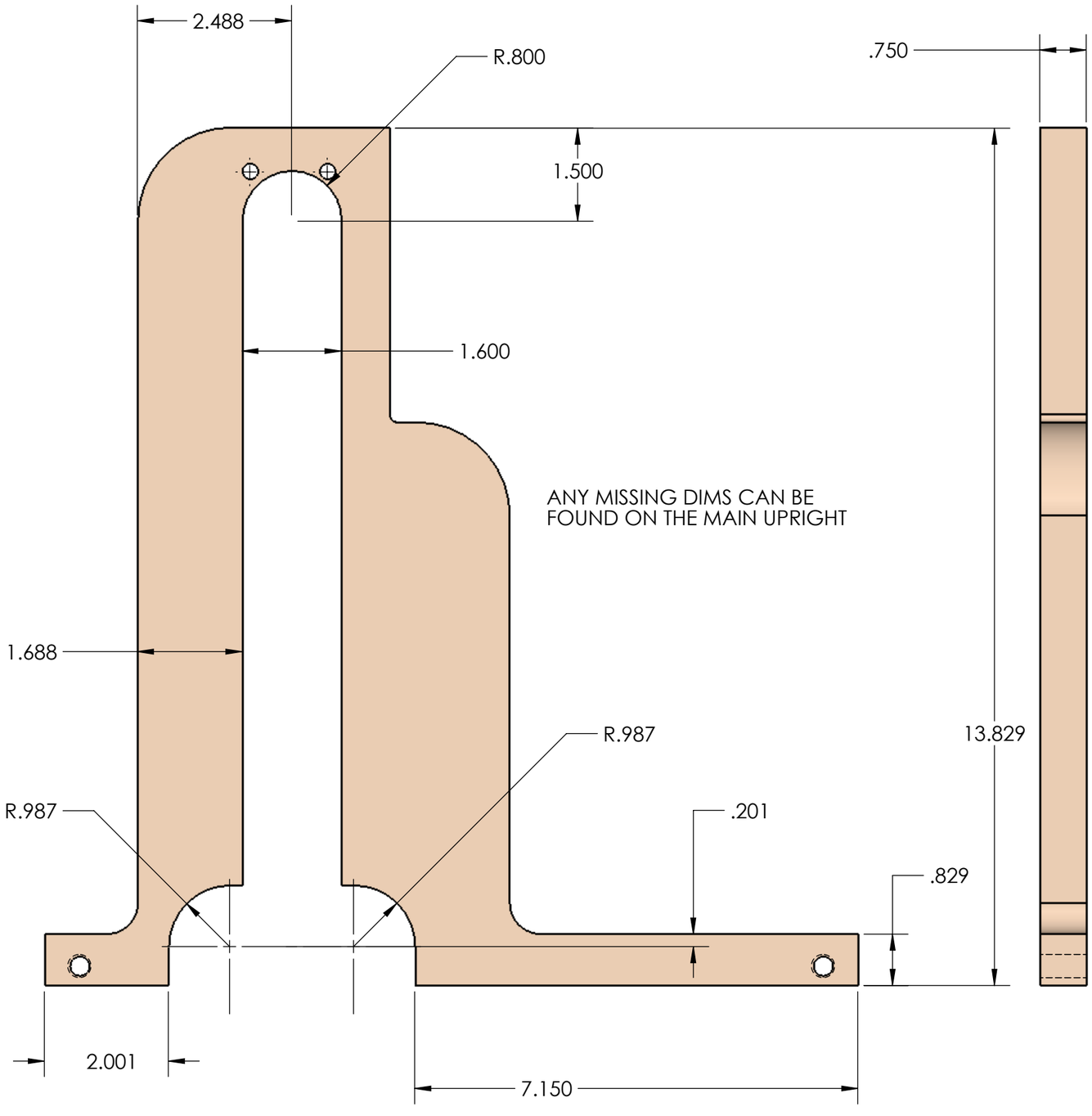


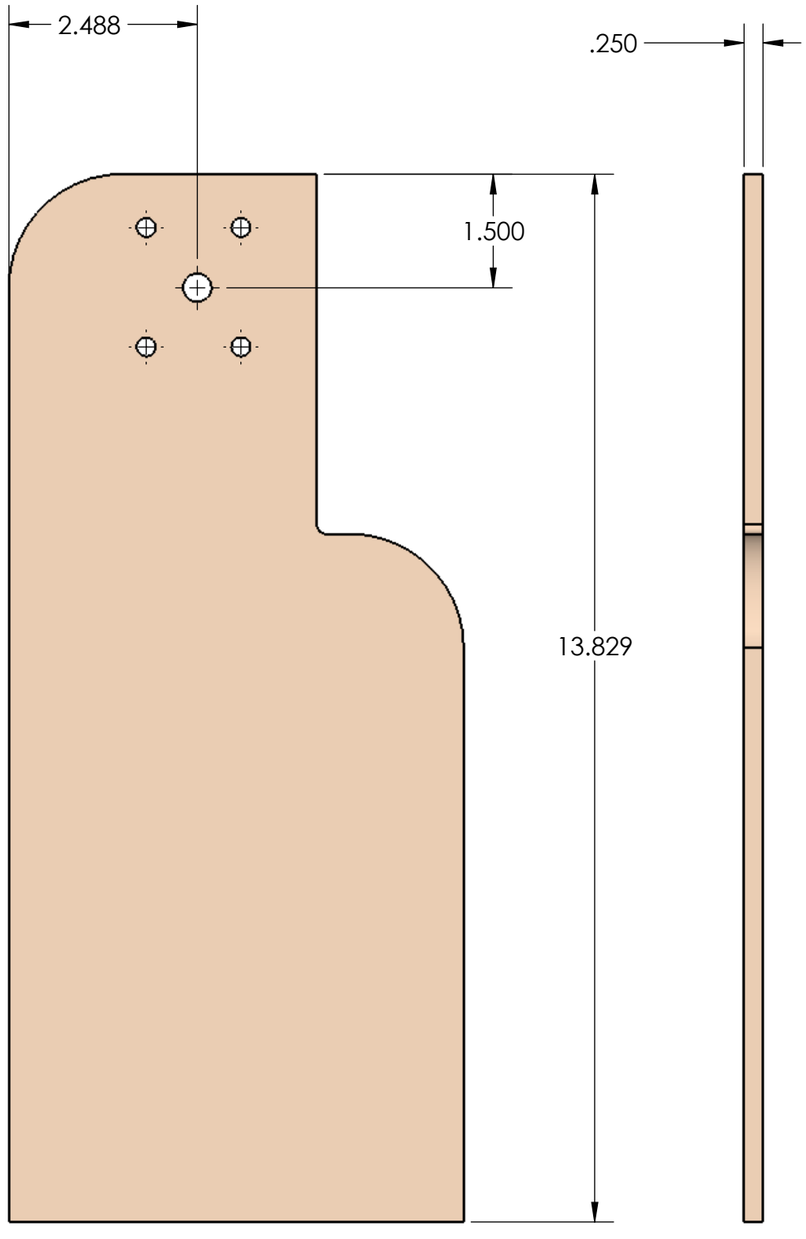


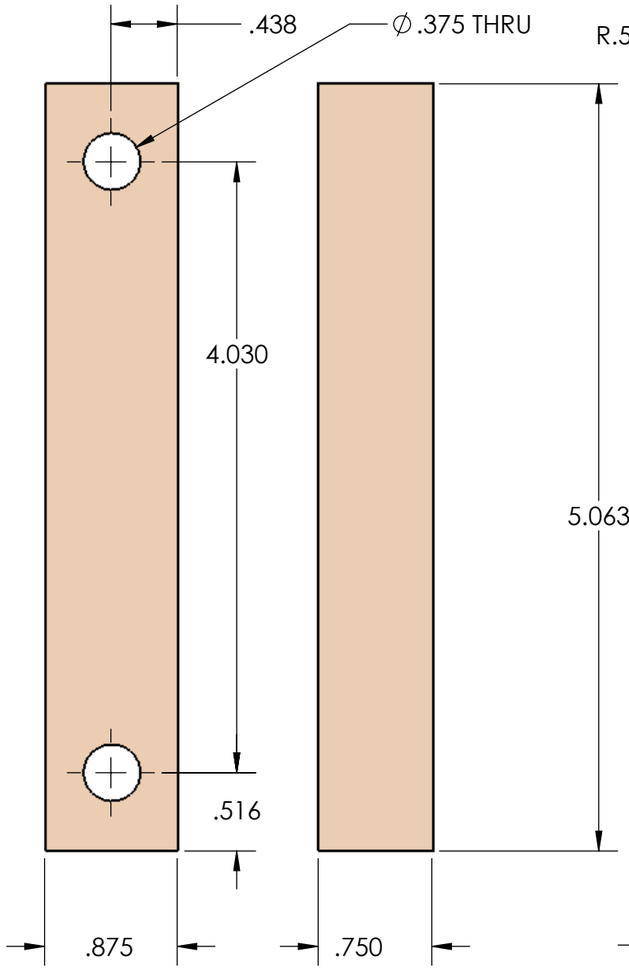


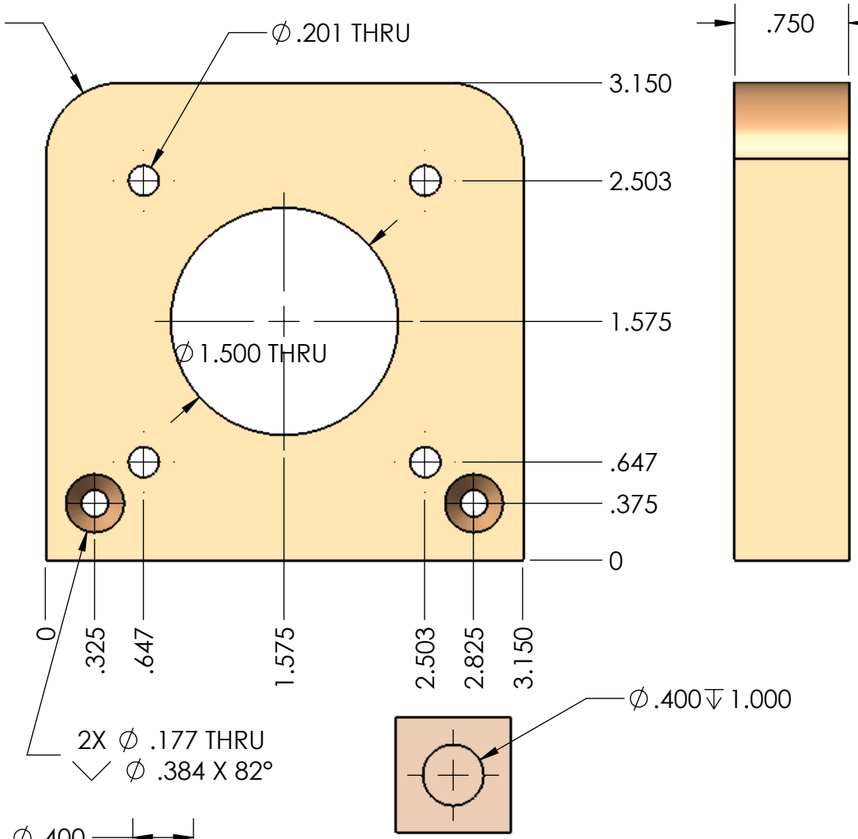


SECTION E-E
SCALE 1 : 1.5

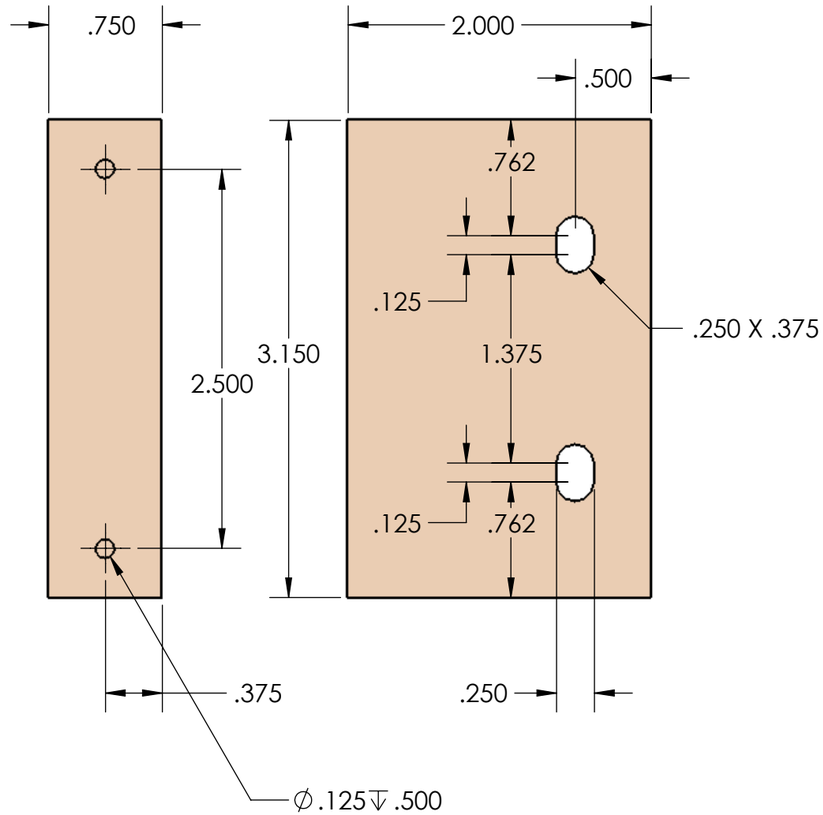

2.488
R.800
.750
1.500
1.600
ANY MISSING DIMS CAN BE
FOUND ON THE MAIN UPRIGHT
1.688
R.987
R.987
13.829
.201
.829
2.001
7.150

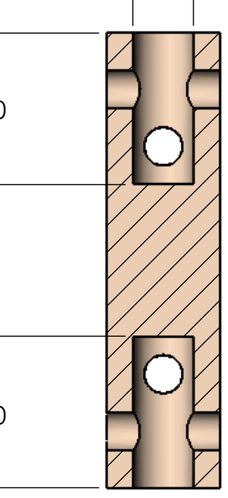

2.488
.250
1.500
13.829
ANY MISSING DIMS CAN BE
FOUND ON THE MAIN UPRIGHT


.438
∅.375 THRU
4.030
5.063
.516
.875
.750

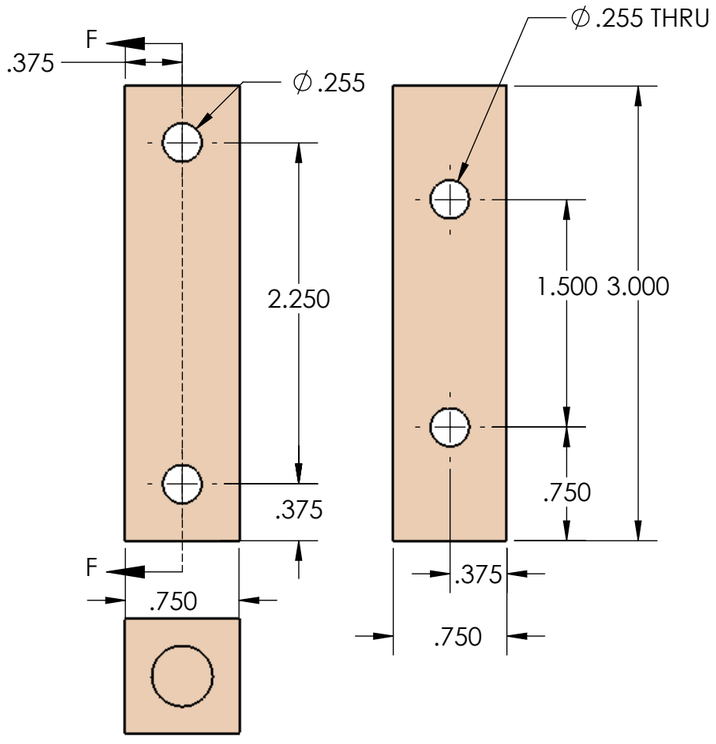

R.500
∅.201 THRU
3.150
2.503
1.575
∅1.500 THRU
.647
.375
0
0
.325
.647
1.575
2.503
2.825
3.150
2X ∅.177 THRU
∅.384 X 82°
∅.400↧1.000

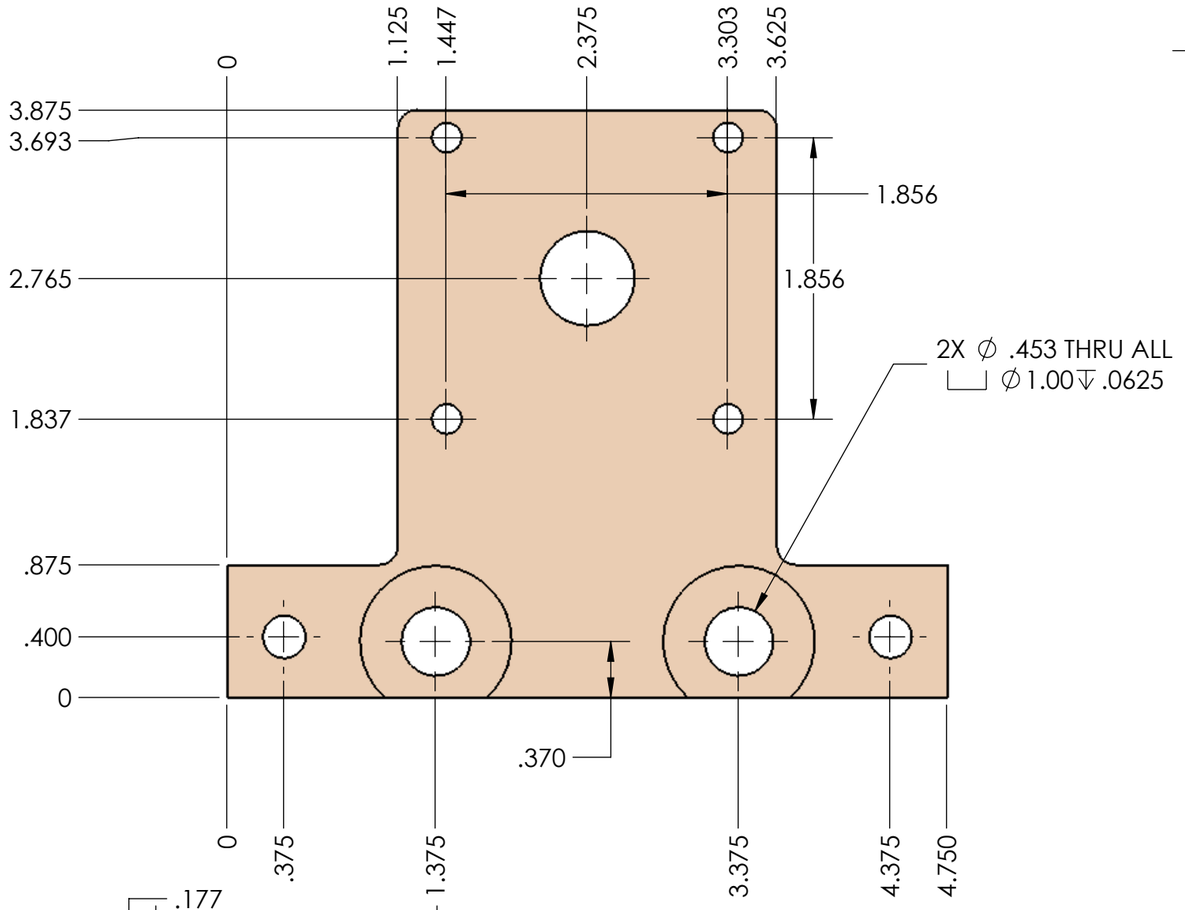
.750

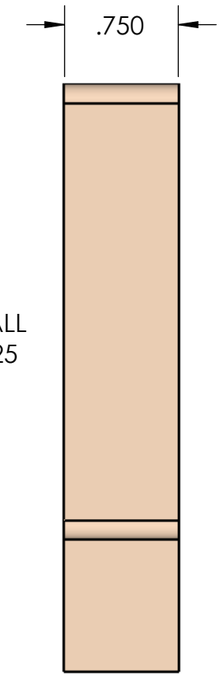

.750
2.000
.500
.762
.125
1.375
.250 X .375
3.150
2.500
.125
.762
.375
.250
∅.125↧.500

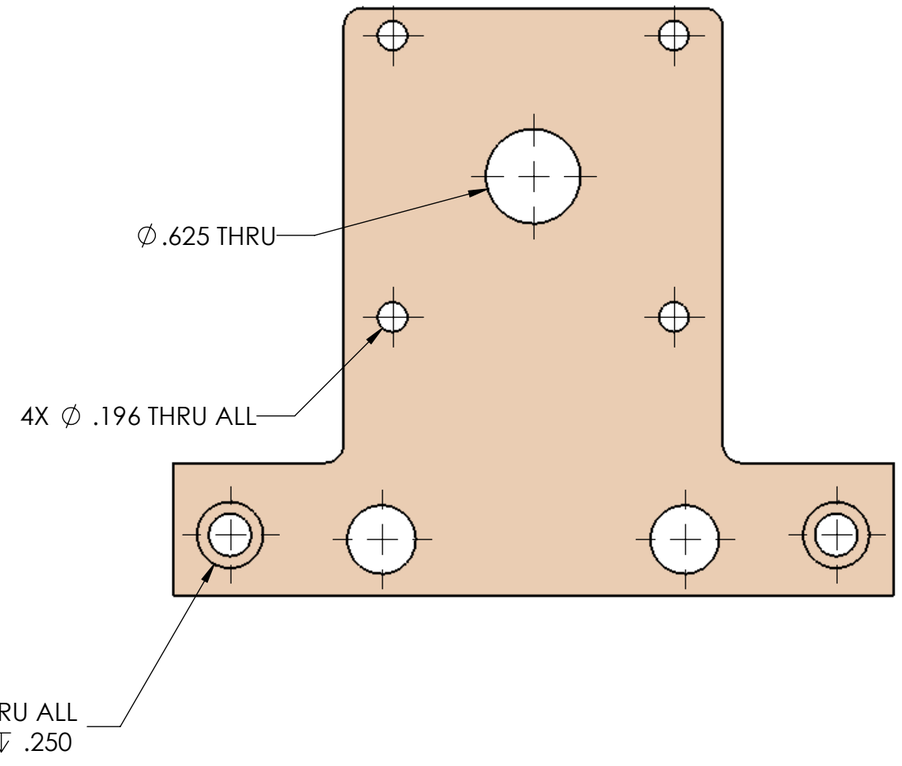

∅.400
1.000
1.000

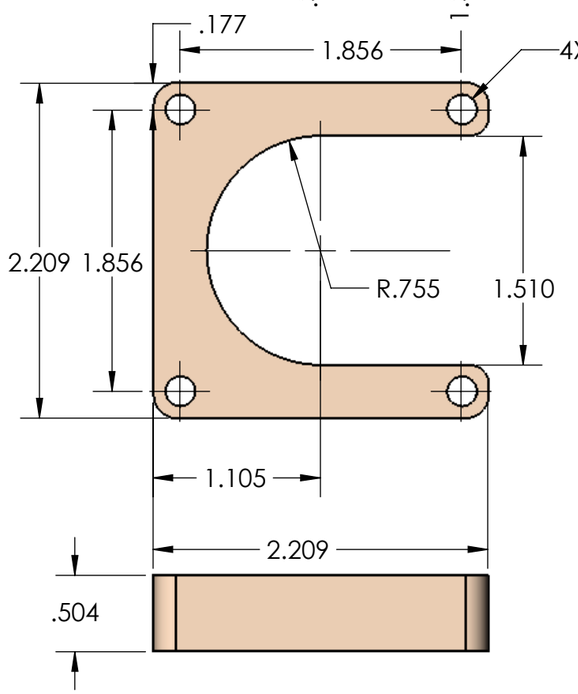
SECTION F-F

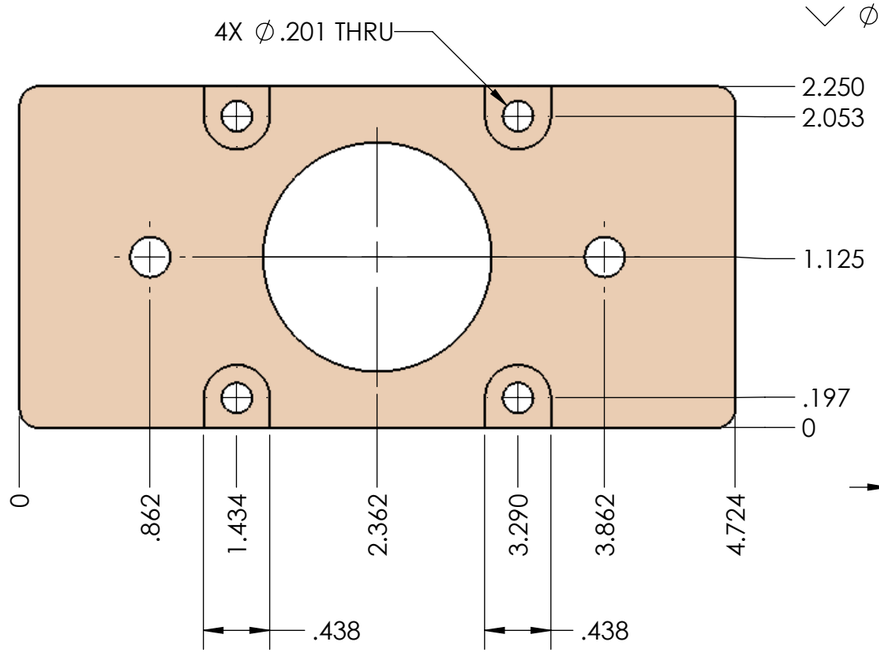

∅.255 THRU
F
.375
∅.255
2.250
.375
F
.750
1.500
3.000
.750
.375
.750

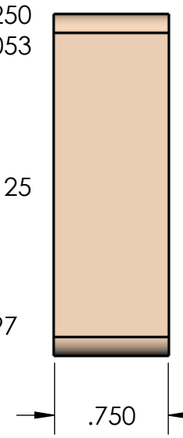

0
1.125
1.447
2.375
3.303
3.625
3.875
3.693
1.856
2.765
1.856
2X ∅ .453 THRU ALL
⌴ ∅1.00↧.0625
1.837
.875
.400
0
.370
0
.375
1.375
3.375
4.375
4.750

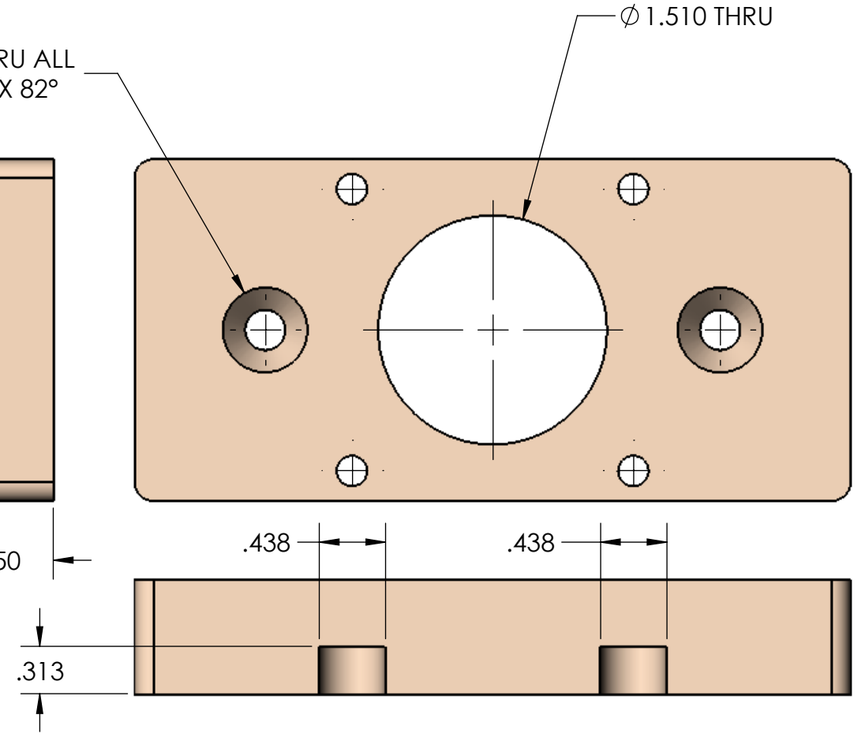

.750

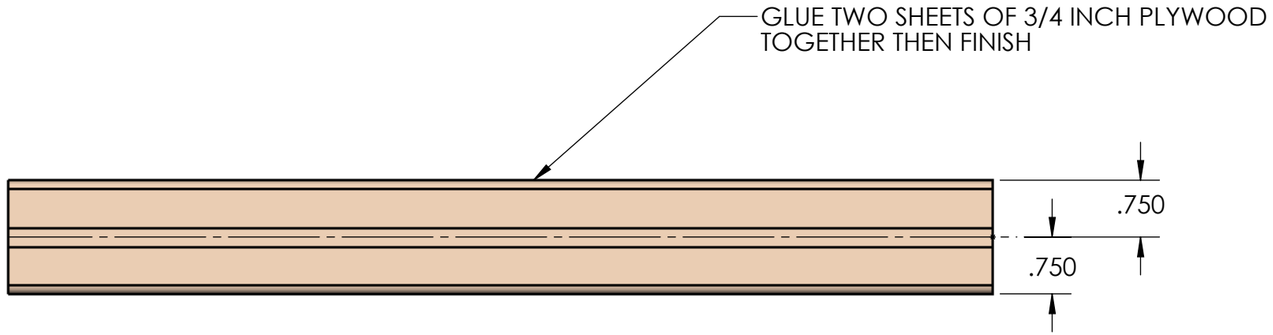

∅.625 THRU
4X ∅ .196 THRU ALL
2X ∅ .281 THRU ALL
⌴ ∅ .438 ↧ .250

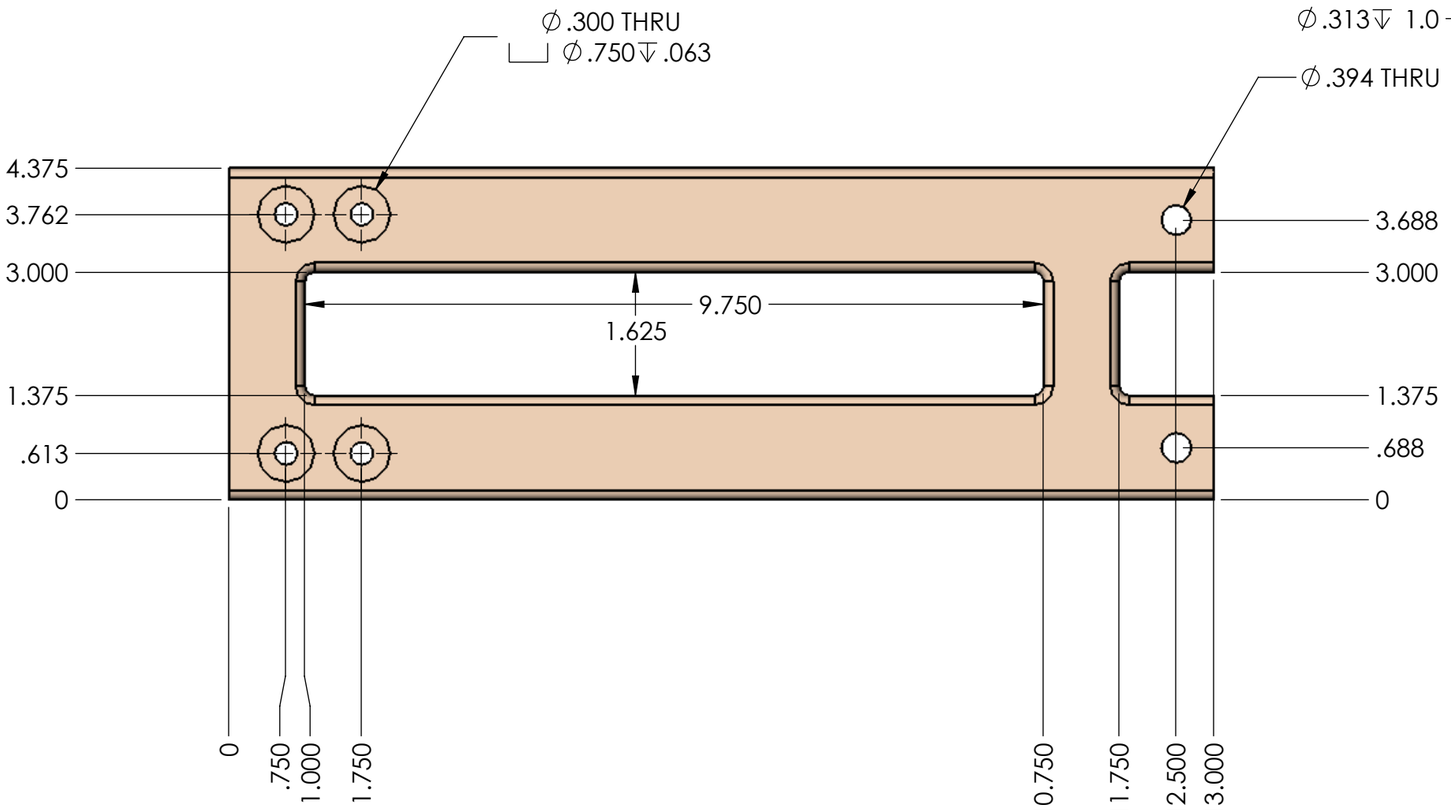

.177
1.856
4X ∅ .196 THRU ALL
2.209
1.856
R.755
1.510
1.105
2.209
.504

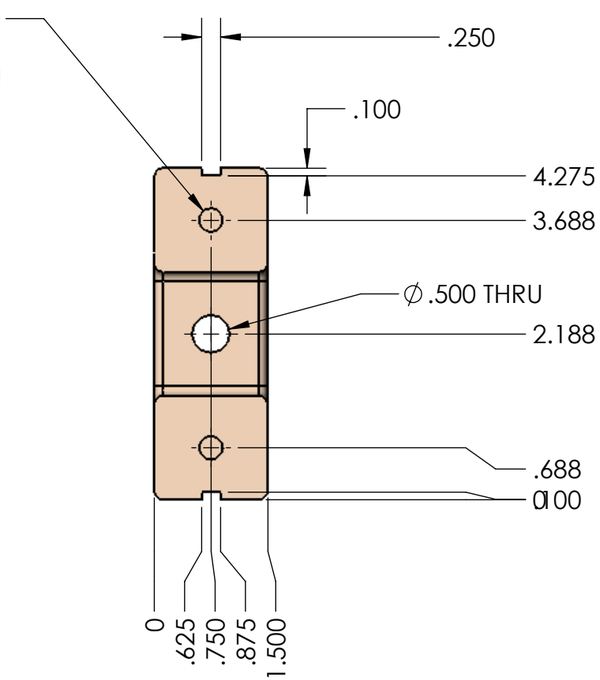

4X ∅.201 THRU
2.250
2.053
1.125
.197
0
0
.862
1.434
2.362
3.290
3.862
4.724
.438
.438

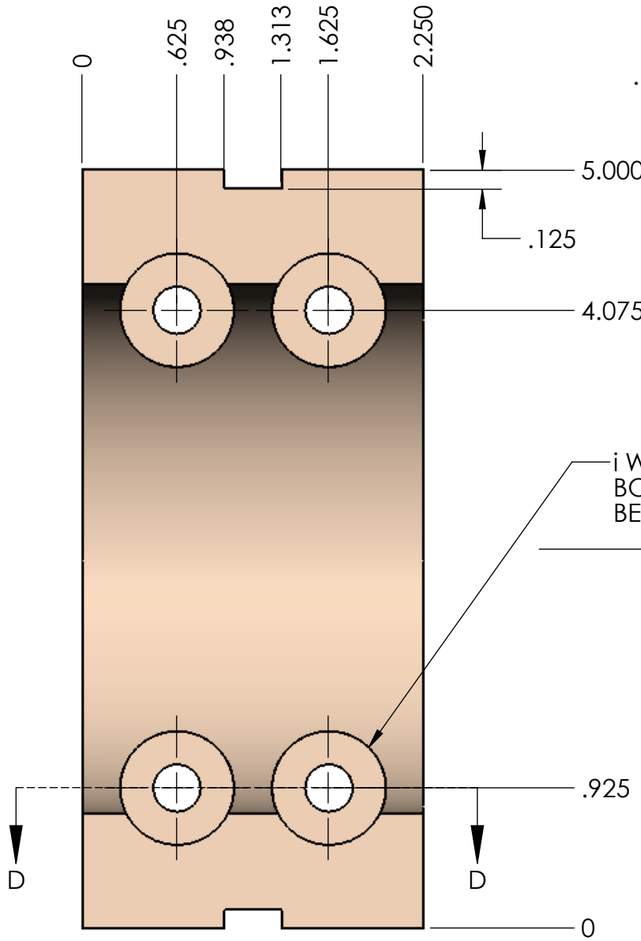

.750

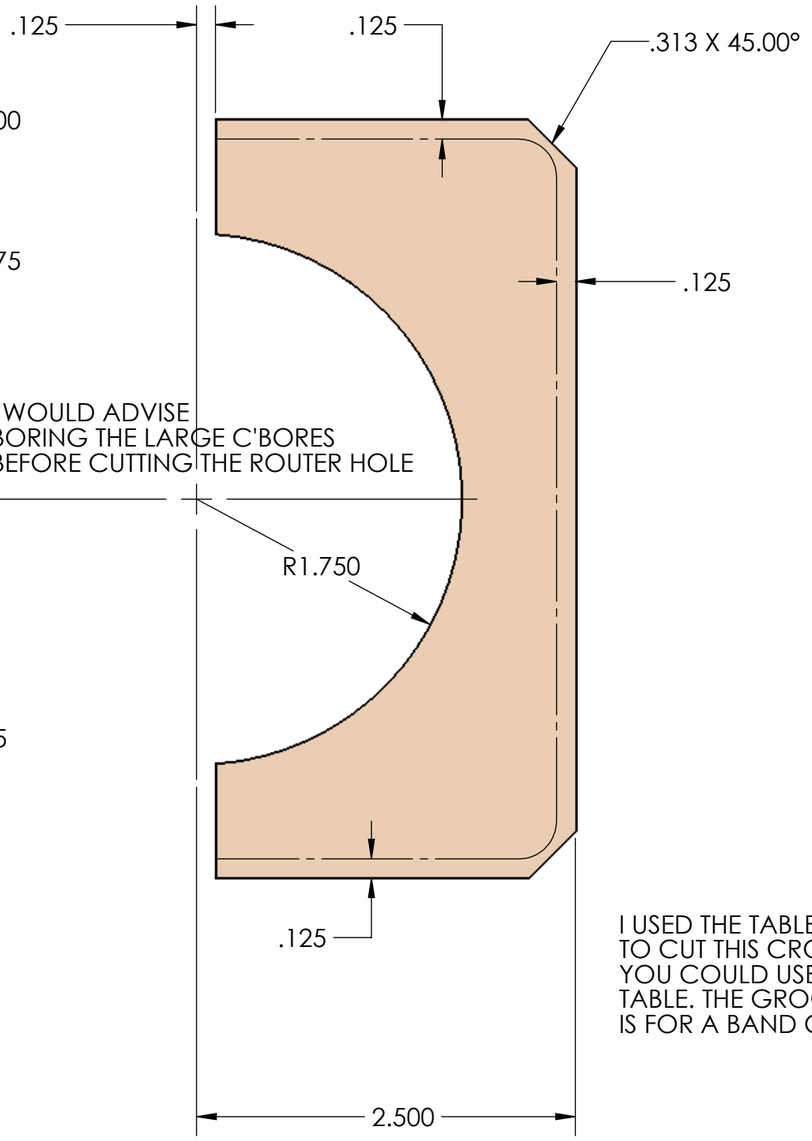

2X ∅ .266 THRU ALL
⌵ ∅ .559 X 82°
∅1.510 THRU
.438
.438
.313

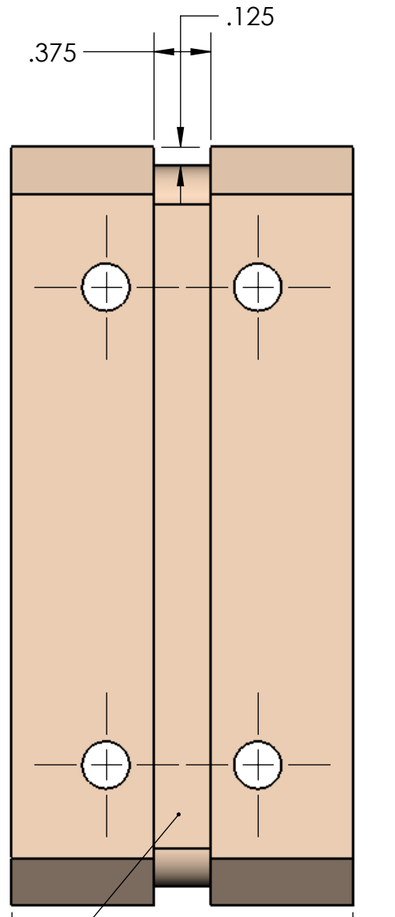

GLUE TWO SHEETS OF 3/4 INCH PLYWOOD
TOGETHER THEN FINISH
.750
.750


∅.300 THRU
⌴ ∅.750↧.063
∅.394 THRU
4.375
3.762
3.000
1.375
.613
0
3.688
3.000
1.375
.688
0
9.750
1.625
0
.750
1.000
1.750
10.750
11.750
12.500
13.000


∅.313↧ 1.0
.250
.100
4.275
3.688
∅.500 THRU
2.188
.688
.100
0
.625
.750
.875
1.500

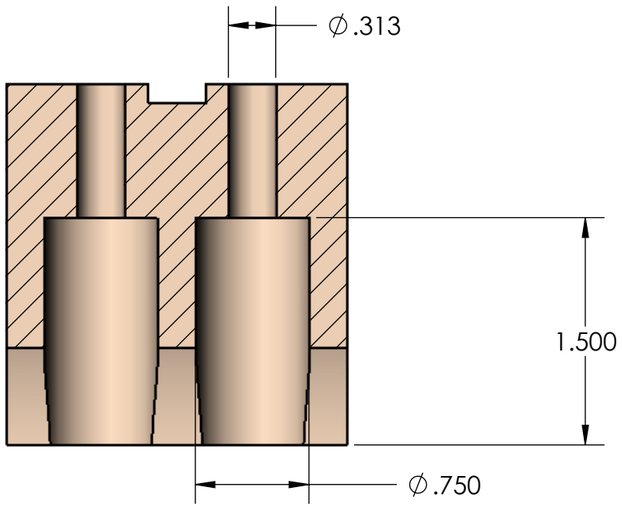




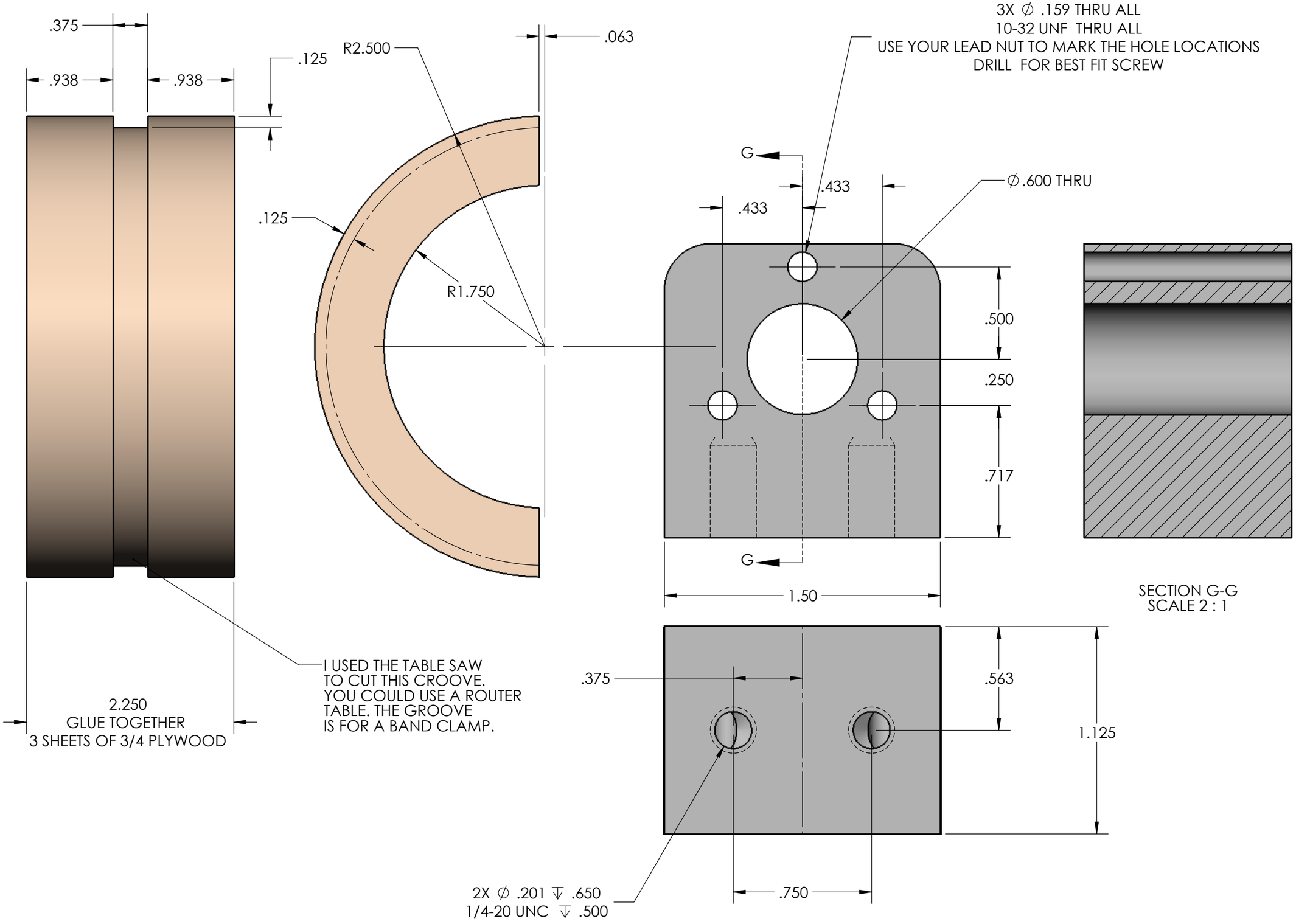


I USED THE TABLE SAW
TO CUT THIS CROOVE.
YOU COULD USE A ROUTER
TABLE. THE GROOVE
IS FOR A BAND CLAMP.

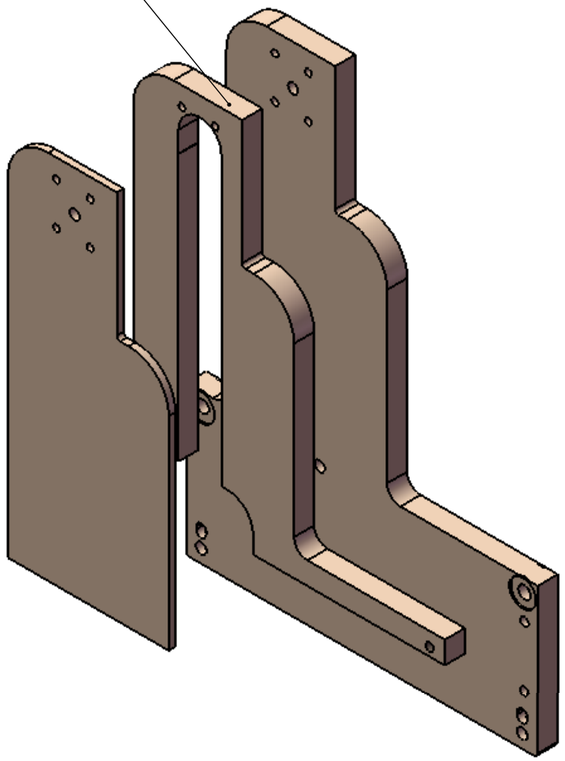
2.250
GLUE TOGETHER
3 SHEETS OF 3/4 PLYWOOD



SECTION D-D
SCALE 1 : 1

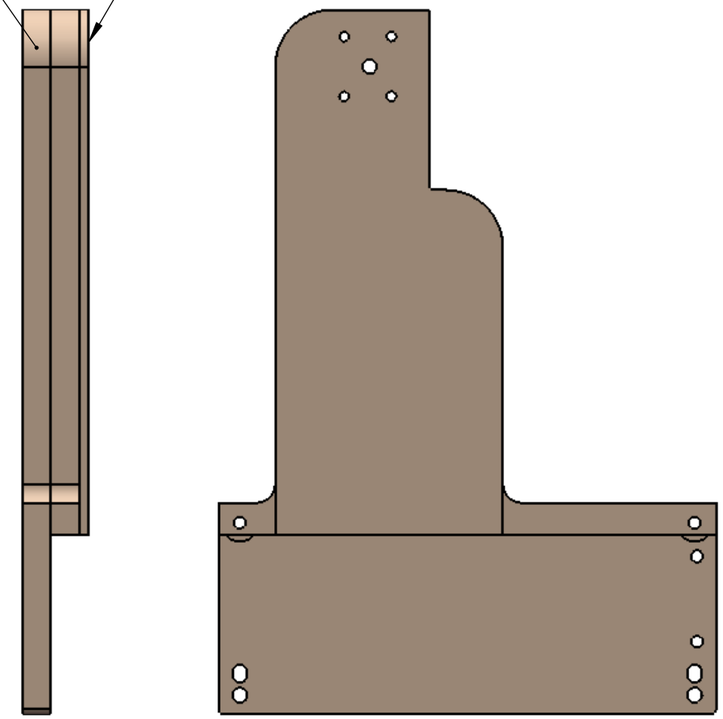

.375
.938
.938
.125
R2.500
.063
.125
R1.750
3X ∅ .159 THRU ALL
10-32 UNF THRU ALL
USE YOUR LEAD NUT TO MARK THE HOLE LOCATIONS
DRILL FOR BEST FIT SCREW
G
.433
.433
∅.600 THRU
.500
.250
.717
G
1.50
SECTION G-G
SCALE 2 : 1
I USED THE TABLE SAW
TO CUT THIS CROOVE.
YOU COULD USE A ROUTER
TABLE. THE GROOVE
IS FOR A BAND CLAMP.
2.250
GLUE TOGETHER
3 SHEETS OF 3/4 PLYWOOD
.375
.563
1.125
2X ∅ .201 ↧ .650
1/4-20 UNC ↧ .500
.750

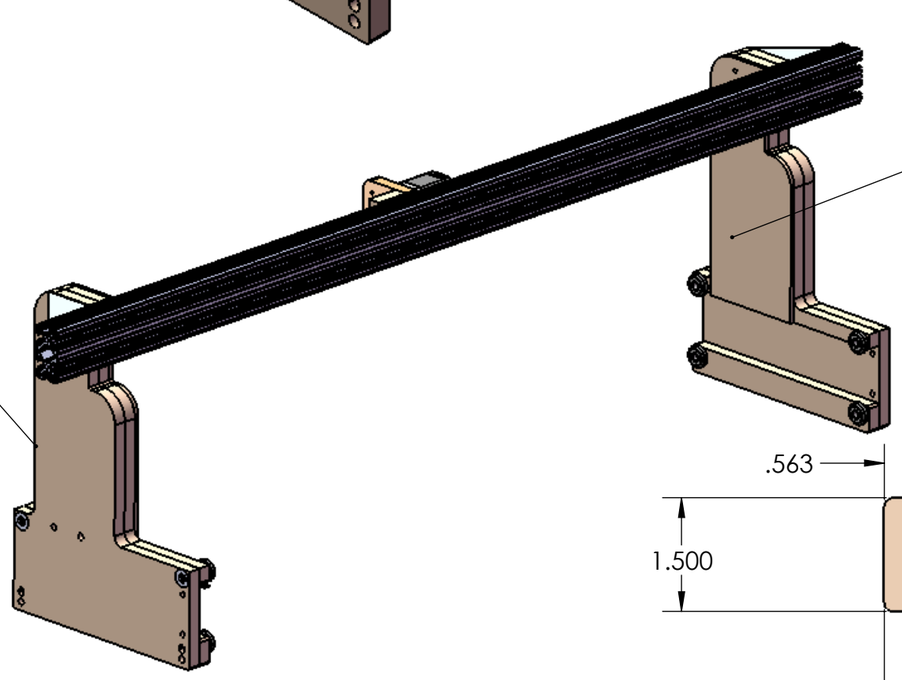
NOTE THERE IS A RIGHT
AND A LEFT ASSY



GLUE THE TWO 3/4 PLYWOOD PARS TOGETHER

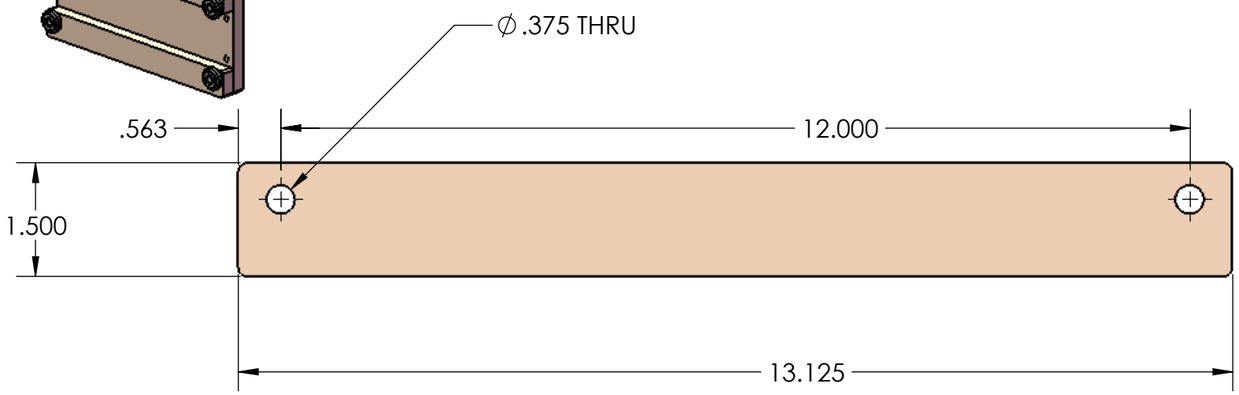
THE CHAIN COVER SHOULD ONLY BE SCREWED

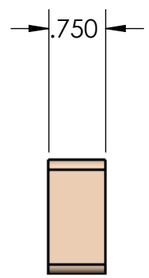


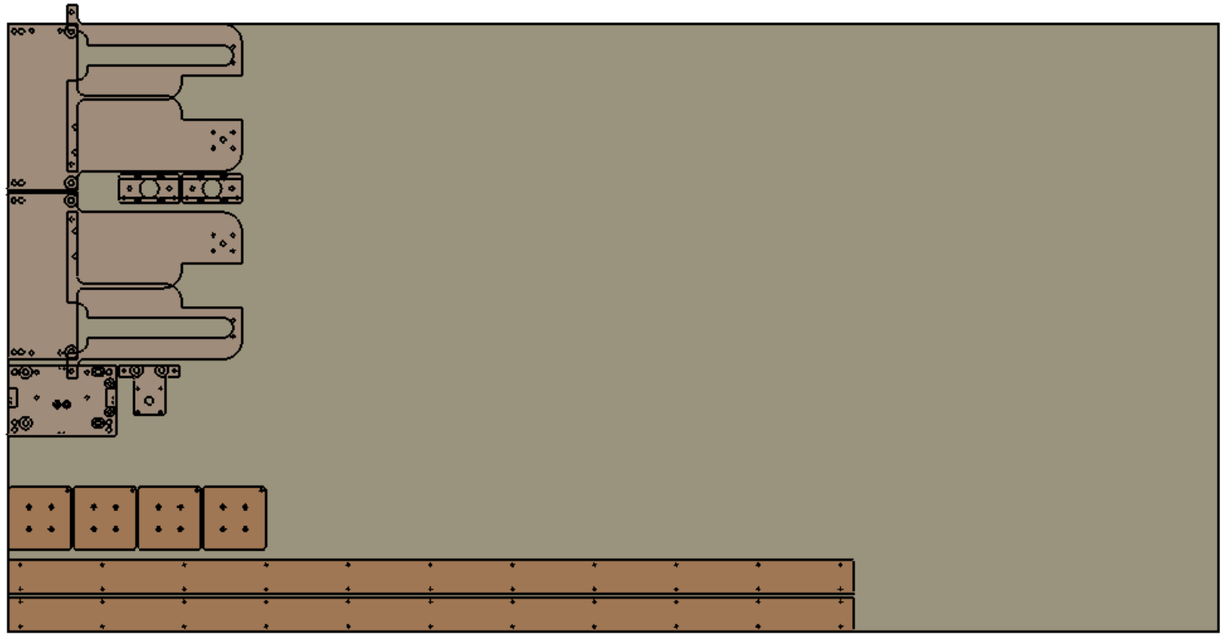


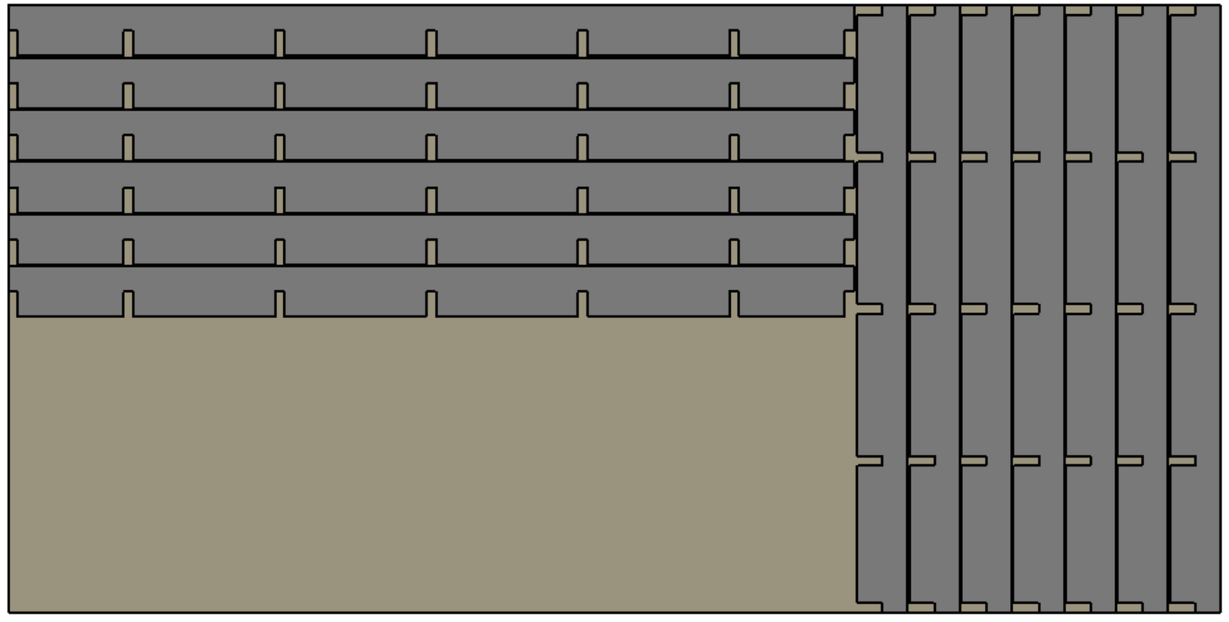
NOTE THERE IS A RIGHT
AND A LEFT ASSY

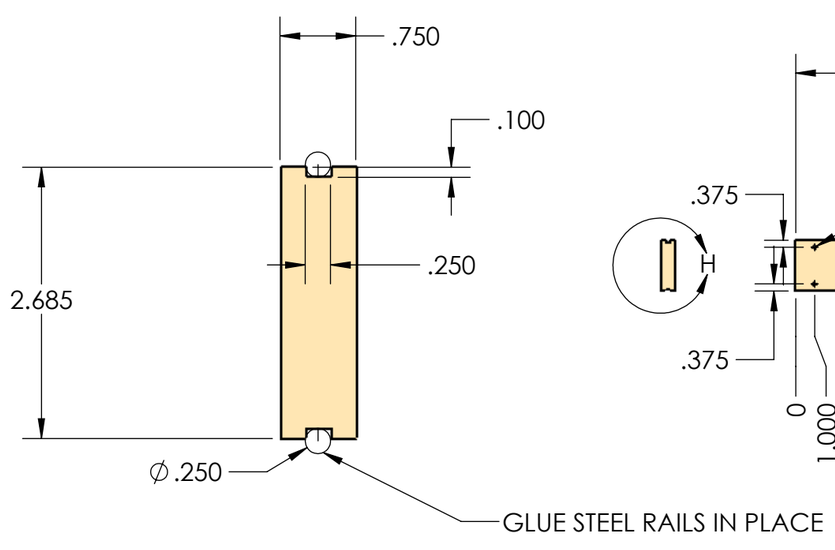
NOTE THERE IS A RIGHT
AND A LEFT ASSY



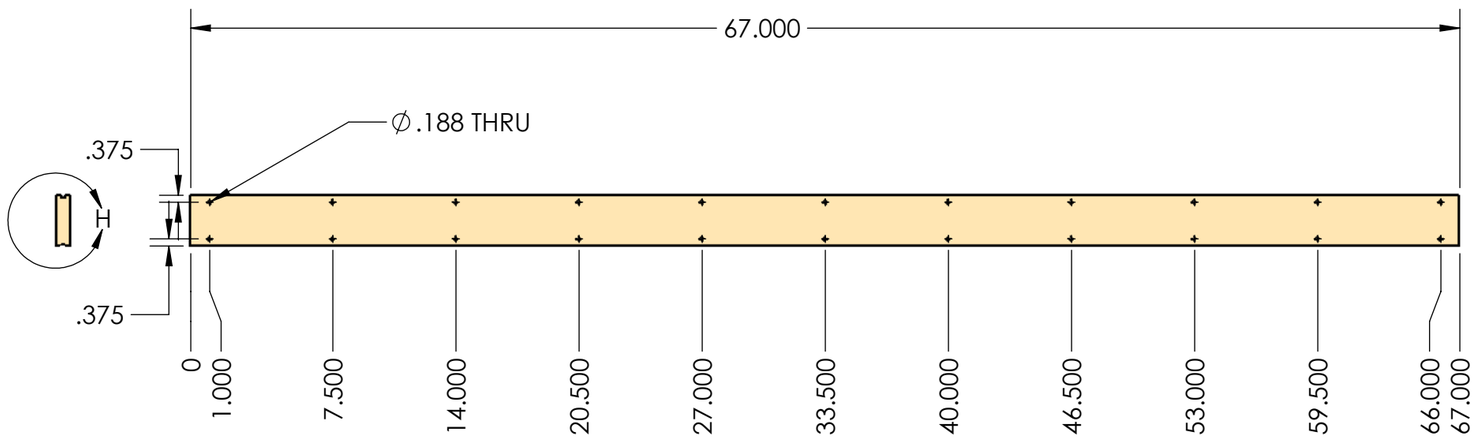


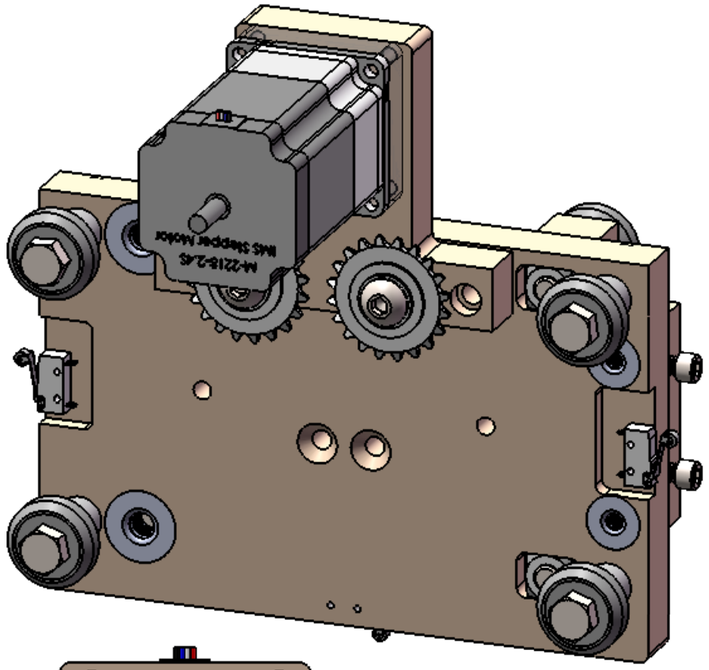






DETAIL H
SCALE 1 : 1.5




M-2218-2.4S
Stepper Motor