

110242CK CNC KIT INSTRUCTIONS

Thank you for ordering this part. Your kit will consist of:

- 1 Aluminum bracket**
- 1 60 Tooth pulley/ handwheel**
- 1 400 OZ/IN Stepper motor wired for Gecko 540 drive**
- 1 14 tooth drive pulley for motor**
- 1 204 XL 037 drive belt (some versions have a longer bracket and will come with a 230 XL037 belt)**
- 4 10-32 X ¾" standoffs**
- 4 10-32 button head cap screws**
- 3 10-32 flathead screws**
- 1 M6 X 35 set screw**
- 1 M6 nylock nut**

Remove the original handle from your rotary table being careful not to lose the small key in the shaft. Loosen the set screw holding the dial to the pulley and remove it. Place the dial in the corresponding place on the new drive pulley/ handwheel. You will see that there is a round collar with 3 tapped holes on the table. Attach the aluminum bracket to this collar with the 3 flathead screws. The collar has 2 set screws to locate it, loosen the set screws and rotate it and the bracket to be horizontal to the rotary table surface and then tighten it in place. Clean the threads in the end of the shaft where the original bolt holding the handwheel was threaded in. Use some Loctite on the threads of the 35 MM set screw

and thread it into the shaft until it leaves enough thread for the washer and nylock nut to secure the handwheel. After the Loctite has time to set, place the new pulley/handwheel over the shaft and secure it with the original thick washer and the 6 MM nylock nut. Tighten the nut until there is a minimum gap between the bracket and dial, but the handwheel rotates freely. Thread the 4 standoffs into the bracket and slip the motor through the opening and using the 4 button head screws, attach the motor to the bracket. Place the 14 tooth drive pulley on the motor shaft and secure it with the 2 set screws. The pulleys come with a ¼" hole which fits most all NEMA 23 steppers unless they have metric shafts, in which case you may need to drill the hole to the correct size. Put the belt over the motor pulley and roll it onto the drive pulley/handwheel.

