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## Table Support Bracket Installation Procedure

### Materials Supplied

- 1x Table Support Bracket
- 6x #8-32 x .375" long screws (only 4 are needed)
- 2x Template for Right Endplate (only 1 needed)
- 2x Template for Left Endplate (only 1 needed)

### Materials / Tools Needed

- 11/32" (.344", 9mm) hex wrench or pliers
- Scissors
- Tape: masking or clear
- Center punch and Hammer: not required, but recommended
- Drill
- 13/64" (.203") or 5mm drill bit. No larger than .230" or 5.84mm
- 33" (84 cm) straight edge/ruler or longer

### Procedure

#### Placing the Template

- Turn cutter power off and disconnect the power and serial cables.
- Slide the cutter table to the back of the machine.
- Remove the "L" bracket at the front of the right and left endplates using an 11/32" hex wrench or pliers (See fig. 3).
- Using scissors carefully cut the right template as indicated by the arrows on the template. (To get the template to fit right, you may need to remove more paper).
- Place the endplate template on the outside surfaces of the endplate.
- Line up the following features:
  - o Top surface of endplate with top edge of template.
  - o Front edge of endplate with front edge of template.
- **Note:** Accuracy of template placement can be checked by verifying that the bracket hole on template lines up with bracket hole in endplate. Also the notch at the top of the surface of endplate near the end cover should line up.
- Attach the template to endplate with tape to hold position.
- Recheck the template position.

#### Drilling the Holes

- **Note:** It is recommended that the plastic covers are removed before this operation, but not required.
- Through the paper template mark the two hole locations using the center punch (See fig. 1). If a center punch is not available, a sharp pin or needle can be used to mark the hole location.
- Do not remove template. Peel back to make sure that the hole position is well marked in the endplate. If not repeat the previous step.
- Remove template.
- Drill two holes using a 13/63" (.203") or 5mm drill bit. A smaller bit can be used, but hole will need to be made longer with the drill bit or with small files.
- Vacuum, sweep, or wipe away the dust and metal chips.

Repeat the **Placing the Template** and **Drilling the Holes** steps for other endplate.

## Mounting and Adjusting the Bracket

- Attach the bracket with four #8-32 screws. Lightly tighten the back screws out approximately 1/2 turn (See fig. 2).
- Set straight edge on edge across the legs above the white strip on the support bracket (See fig. 2).
- One side at a time, lift the support bracket so that white strip touches the bottom of the ruler. It is also best to rotate the bracket slightly so that the white strip under the table just starts to lift the table. Firmly tighten the 2 screws.

**Note:** if the support bracket cannot be lifted high enough the top edge of each hole will need to be enlarged slightly.

- Repeat for the other side.
- Replace the "L" bracket on the front legs when done. (See fig. 3)

Reconnect the power and serial cables to the cutter.

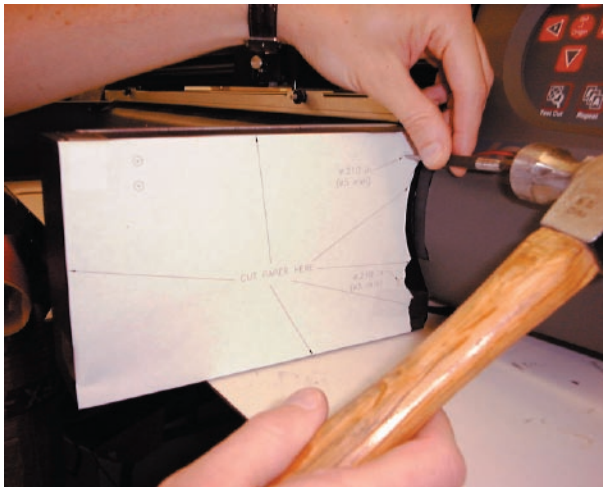


Fig. 1 - Use a metal punch to mark the location for the holes to be drilled.



Fig. 2 - Place a ruler on the white strips while tightening the mounting screws.

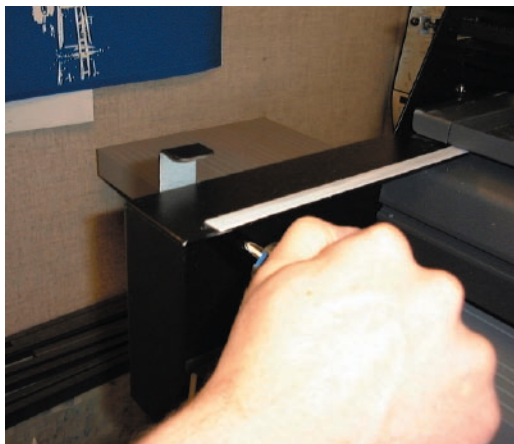


Fig. 3 - Removing and installing the "L" bracket