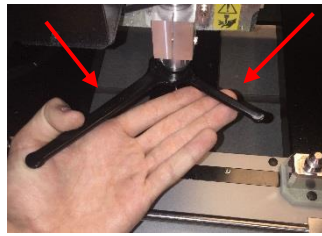


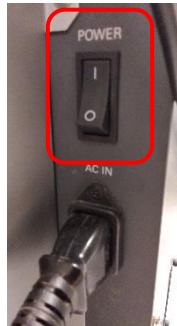
HOW TO INSTALL ROTARY AXIS UNIT INTO CNC MILL

Remove brown bed

1. If a milling bit is in toolhead, remove it using two black wrenches from accessory box (pull wrenches together to loosen).



2. Turn on CNC machine via switch behind machine.



3. Hold-down green & black power button in front of machine until Modeling and Scanning lights are lit.



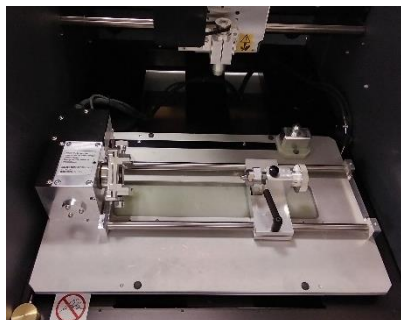
4. Press View button on front of machine to move bed to front of machine.

5. **Turn off** CNC machine via rear switch.

6. Use hex wrench to remove eight black bolts from bed, then remove bed. Place bolts in plastic bag, then place in CNC accessory box. **Do not use them for rotary axis unit.**

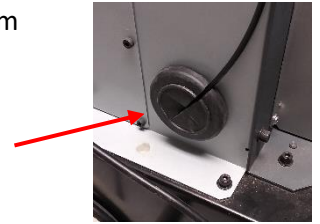
Install rotary axis unit

1. Place rotary axis unit in machine with large spindle and secure with four silver bolts from accessory box. Cover bolts with rubber caps.



(next column)

2. Remove rubber grommet from rear left of machine.



3. Remove brass sensor by disconnecting its cable from back of machine, place sensor & cable in accessory box.



4. Fish rotary cables through grommet hole, attach to connectors on left rear of machine. Use screwdriver to secure larger connector. **Leave slack cable inside machine.** Replace rubber grommet.

Calibrate tool sensor

1. Find detection pin (a small metal cylinder). Find collet from collet bag that snuggly fits detection pin. Insert pin into collet end, opposite of threaded end.

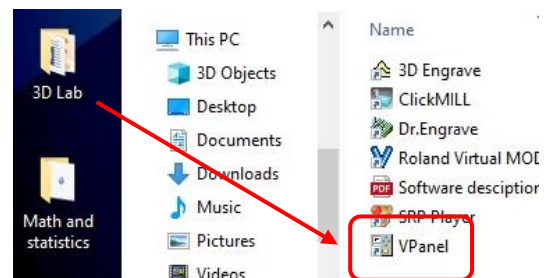


2. Insert collet & pin into machine's toolhead. Tighten with two black wrenches (push wrenches apart to tighten).

3. Turn on CNC machine via switch behind machine.

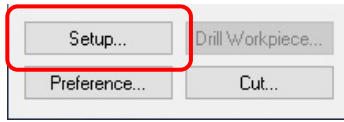
4. Hold-down green & black power button in front of machine until Modeling and Scanning lights are lit.

5. Open VPanel via 3D Lab > Roland CNC Machine on desktop.



(flip over)

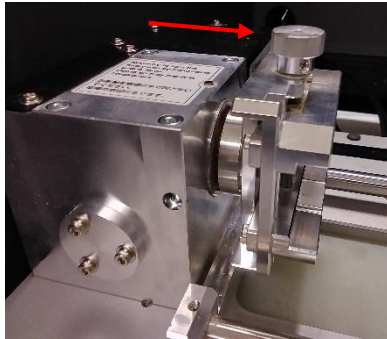
6. Click Setup in lower-left, then Adjust Location, then Start Sensing, then Continue.



7. After sensing is finished, click OK twice to return to VPanel home screen.

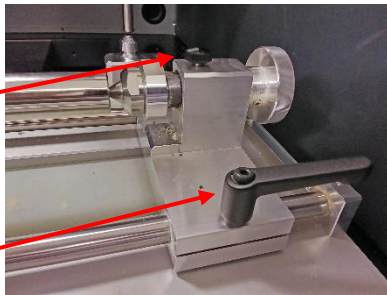
Calibrate rotation origin

1. Rotate vice on left side of rotary tool until its silver knob faces up. Use army-green arrows in VPanel to rotate **(do not rotate vice by hand)**.



2. Loosen:

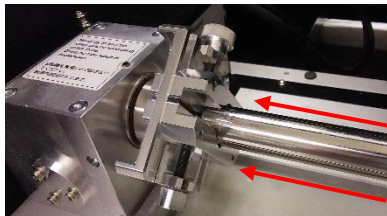
- a. Black tailstock knob.
- b. Black tailstock lever on right side of rotary.
- c. Silver vice knob on left side of rotary.



3. Locate long, chrome rod in CNC accessory box.

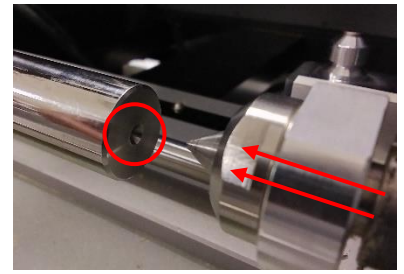


4. Insert rod into left side of vice, then turn silver vice knob to secure it.



(next column)

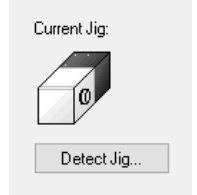
5. Slide tailstock into chrome rod on the right, fitting point of tailstock into divot on the rod's end.



- a. Tighten black tailstock level.
- b. Tighten black tailstock knob.

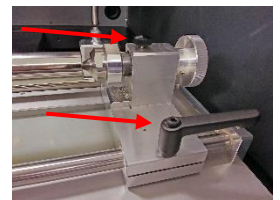
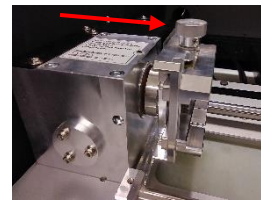
6. Close cover.

7. In VPanel, click Detect Jig in lower-left, then Start Sensing, then Continue.



8. Once detection has finished, click Close then OK to return to home screen.

9. Open cover, then loosen silver vice knob, black tailstock lever, and black tailstock knob to remove chrome rod. Place rod in accessory box.



10. Remove detection pin & collet from toolhead, then place both accessory box.

