

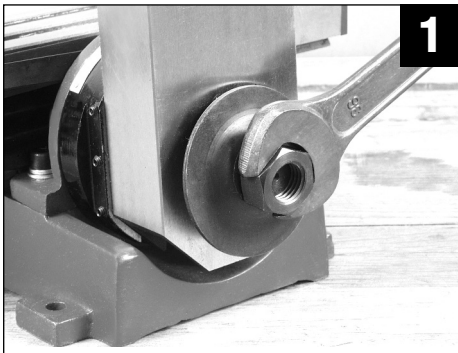
#82573 MICROLUX™ MILLING MACHINE ASSEMBLY INSTRUCTIONS

Your MicroLux milling machine was assembled and tested at the factory, but was disassembled for safe shipment. Assembly is not difficult, but care should be taken to follow these instructions in the proper sequence to assure safe and successful operation of the machine. We assume you already have the usual assortment of shop tools, such as wrenches, screw drivers, pliers and hex keys, needed to assemble small machinery.

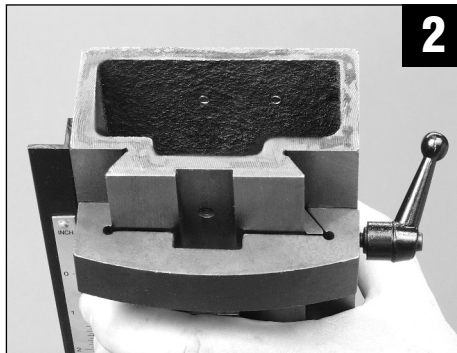
Before starting the assembly sequence, carefully unpack and clean all machine elements. For proper part identification and location, it will be most helpful to study the Assembly and Parts diagram included in the Instruction Manual.

Note: These instructions may be viewed in color on our web site.

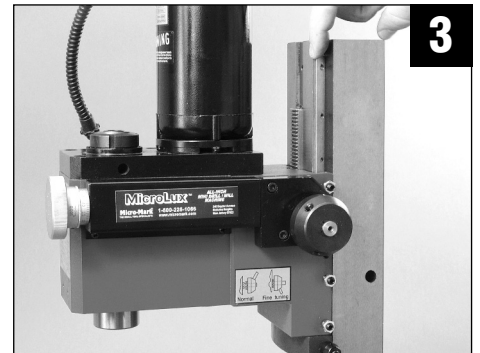
Assembly Procedure:



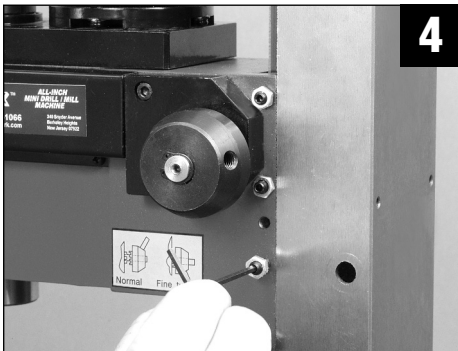
1 Attach the fuselage/column to the base with big washer and lock nut. Tighten the lock nut securely.



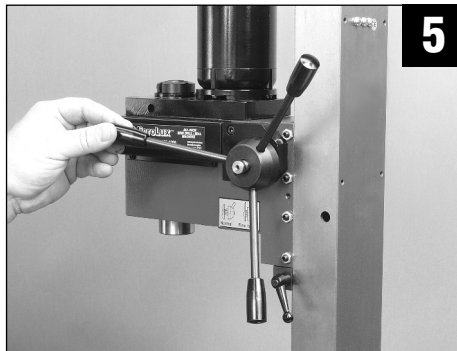
2 Install limit block and its wedge (gib) to the fuselage/column. Position it about half-way down the fuselage/column and tighten the lock handle. Top cover (#164 on parts diagram) must be glued to top of column.



3 Install head stock and its wedge (gib) to the fuselage/column. Parts #102 and #103 are mounted at this time. (See Vertical Z Axis parts diagram in the manual.)



4 See the instruction manual for wedge (gib) adjustment procedure.



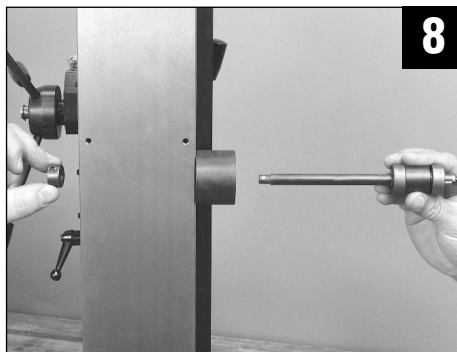
5 Install three long operating levers to handle stock of spindle shaft (pinion).



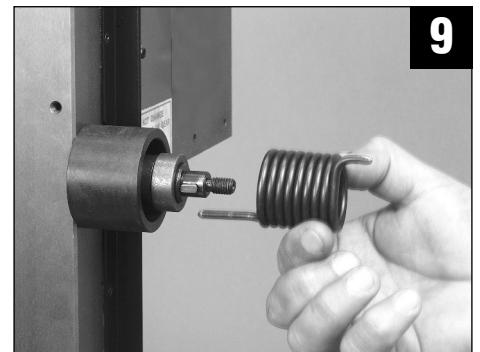
6 Install one short lever to High/Low gear shift handle seat on left side of head stock.



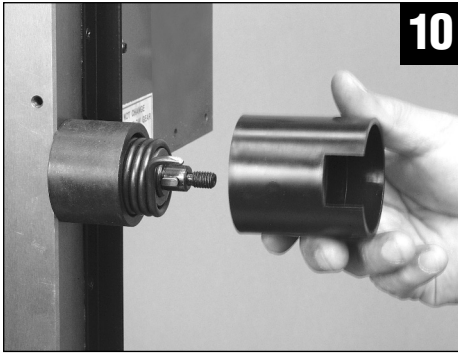
7 Install spring support to left side of column with 3 screws.



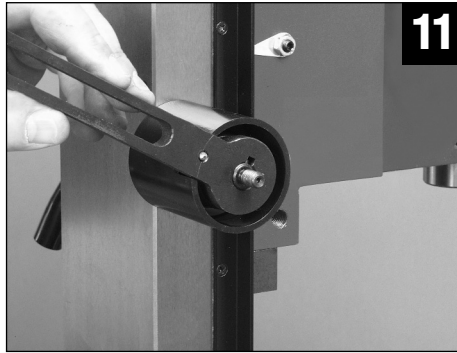
8 Install rotor shaft, washers (collars), key and lock sleeve through the spring support and column. Secure lock sleeve in place.



9 Install torsion spring with long end passing through hole in column.



10
Install spring cover over torsion spring with notch adjacent to short spring end.



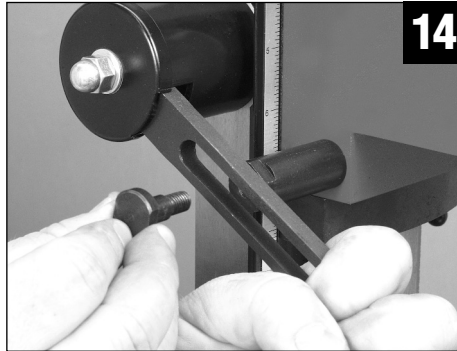
11
Install supporting shank (slotted crank arm) over key and short end of torsion spring.



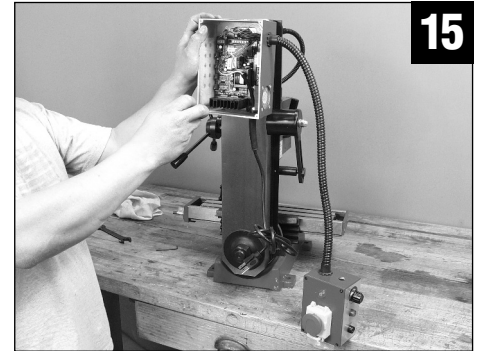
12
Install internal ring, cover, washer, and cap nut to end of rotor shaft.



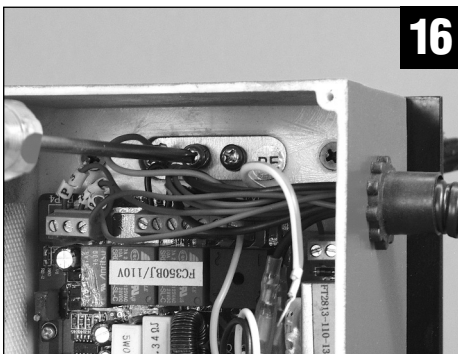
13
Install prop to left side of head stock.



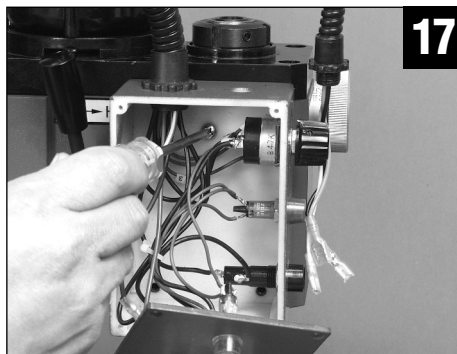
14
Rotate supporting shank clockwise to a position in line with prop, and install screw to hold supporting shank to prop.



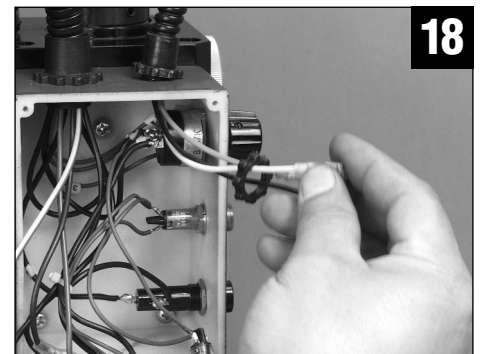
15
Install larger electrical box to top rear of fuselage (column). Take care with the lower-left mounting screw; it must be placed (and may already be installed) behind printed circuit board. Do not overtighten the screws or the box may crack.



16
Connect the loose (ground) wires to the blank screws at the top center of the electrical box (to the back of the fuselage/column). Install the larger box cover. Do not overtighten the screws or the cover will certainly crack.



17
Install the smaller electrical box (motor control) to the left side of the head stock with 3 screws. Pass the motor wires through the hole in the box.



18
Install the nut over the wires to secure the cable cover grommet from inside the box. Connect the motor leads to the control box leads (match wires by color). Install the box cover. Be careful...do not overtighten the screws or the cover will be damaged.

Install all remaining handles, cranks, caps, covers and shields in the locations shown in the assembly diagrams.

Warning! Do not start the machine until you are certain that the gears of the High/Low shift lever are properly engaged inside the head stock; otherwise, damage to the gears will occur if they are not engaged properly.

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