Accessory Installation Guide

4th Axis Rotary Positioner for Bench/ProMill

Accessory Name	4th Axis Rotary Positioner
Accessory P/N	011153
Applicable to	BenchMill 6000 ProMill 8000

1 Additional Requirements

To complete this installation you will require:

1. M6 allen key
2. M6 wrench
3. M10 wrench

2 Unpacking Instructions

1. Unpack and open all boxes in the crate.
2. Ensure that all boxes are emptied completely; additional parts may be revealed when packaging is removed.
3. Unwrap and wipe down all components. The complete part set is shown below.

3 Mount the Backplate to the Chuck

1. Prepare the chuck, the backplate, and three M6X12mm screws.

2. Assemble as shown to form the chuck assembly.

4 Mount the Chuck Assembly to the 4th Axis Drive

1. Prepare the 4th axis drive, the chuck assembly, four T-nuts, and four M6X12mm screws.

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2. Insert one T-nut into each of the four slots on the 4th axis drive.

3. Place the 4th axis drive on its back and attach the chuck assembly to it using the M6X12mm screws.
4. Tighten the screws using the M6 allen key.

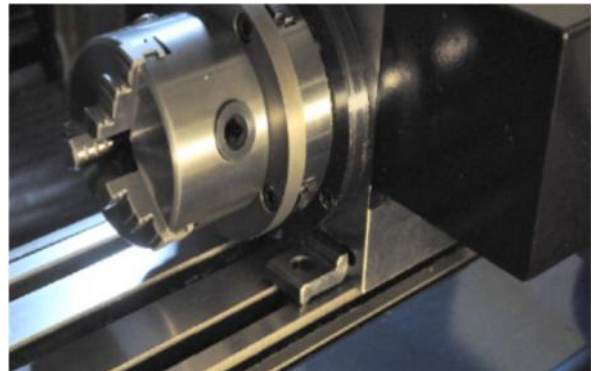## 5 Mount the 4th Axis Assembly to the Table

1. Prepare the 4th axis assembly, two M10X24mm bolts, the two matching T-nuts and the clamps.

2. To place the 4th axis assembly onto the table:
   a. Position the assembly so that the key at the bottom of the drive faces downwards, and the chuck assembly points towards the center of the table.
   b. Align the key at the bottom of the 4th axis drive with the middle T-slot on the machine table.
   c. Place the 4th axis assembly on the table, ensuring that the key rests in the middle slot.
3. Slide one of the two T-nuts down one of the two outer T-slots, facing the chuck of the 4th axis assembly.
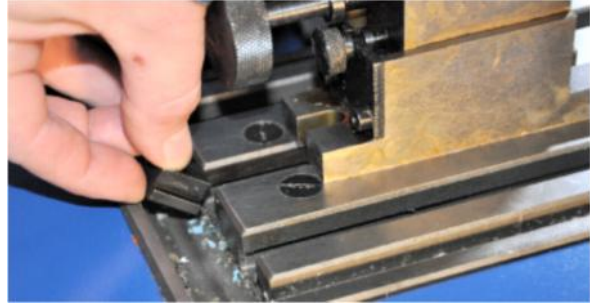

4. Push the T-nut along until it reaches the 4th axis drive.
5. Place a clamp over the T-nut so that the clamp's foot is on the table, and its hook enters the horizontal clamping groove on the 4th axis drive.

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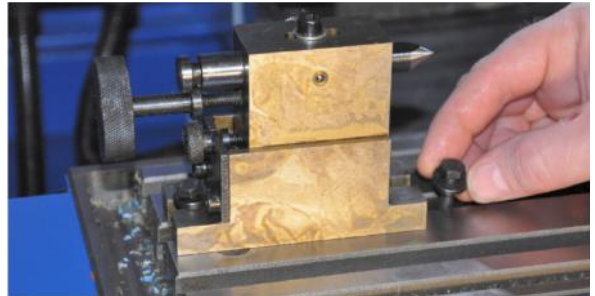| Technical Support	
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6. Slide the second T-nut down the T-slot at the opposite corner of the table. (The 4th axis assembly will be clamped at two diagonally opposite corners.)

7. Place the second clamp over the second T-nut inserted so that the clamp's foot is on the table and its hook enters the horizontal clamping groove on the 4th axis drive.

8. Slide the 4th axis assembly and the two clamps along the table, positioning the 4th axis at the far end of the table.

9. Fasten the two clamps to the T-nuts using the M10X24mm bolts.

6   Mount the Tailstock

1. Prepare the tailstock, two T-nuts, and two M6X25mm screws with washers.

2. Slide the two T-nuts down the center slot, at the end opposite the 4th axis assembly.

3. Place the tailstock on the table between the two T-nuts.

4. Thread the bolts and washers into the T-nuts.

5. Position the tailstock at the required distance from the 4th axis assembly, and tighten the bolts.

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7   Plug in the 4th Axis Port

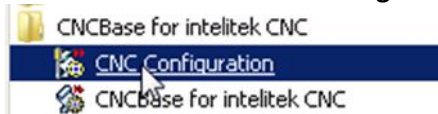1. Remove the black plastic cap from the 4th axis port on the right side of the Z-axis.
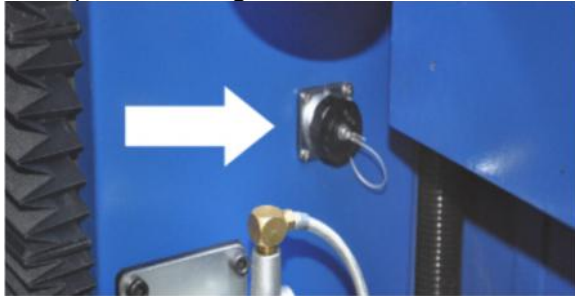
2. Plug the 4th axis cable into the 4th axis port. Note that it will fit in only one orientation.
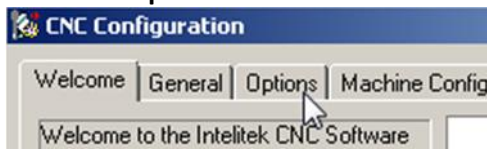

3. Tighten the plug collar by hand.

8   Configure the Software

1. Click **Start → All Programs → CNCBase for Intelitek CNC → CNC Configuration**.
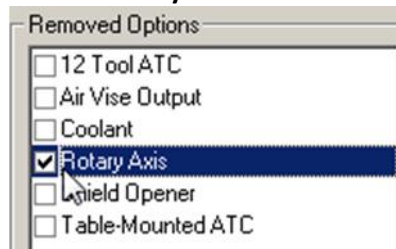

2. Click the **Options** tab.

3. Click **Reinstall**.

4. Select **Rotary Axis**.

5. Click **Reinstall**.

6. Click **OK** to close CNCBase.

Installation complete.