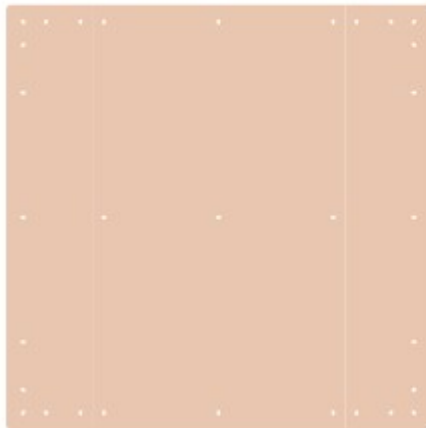


MPCNC TABLE BUILD

Materials



1/2" MDF At Least 740x740mm
(28x28")



2020 Aluminum Extrusion
660mm long (x5)



2020 Aluminum Extrusion
700mm long (x2)



M5 T Nut for
2020 Extrusion (x47)



M5x15mm Screw
(x19)



M5x22mm Screw
(x22)



M5x10mm
Threaded Insert
Nuts



2020 Extrusion
Corner Brace
(x16)



M5x8mm Screw
(x16)

Tools



M3 Allen Key



Mitre Saw



Drill



4.2mm Drill Bit



M5 Tap



Countersink
Bit



1/8 Endmill



1/4" Drill Bit



Centerpunch



Hammer



Aluminum
Cutting Blade



1000mm XCarve



Tablesaw



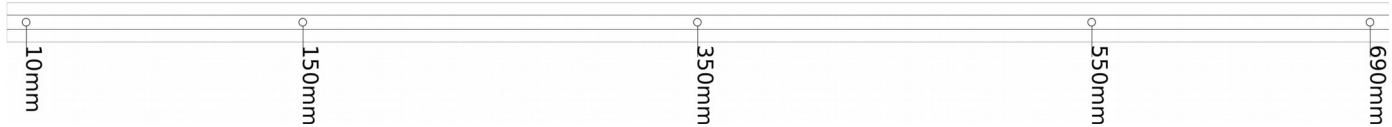
M5 Allen Key



5mm Drill Bit

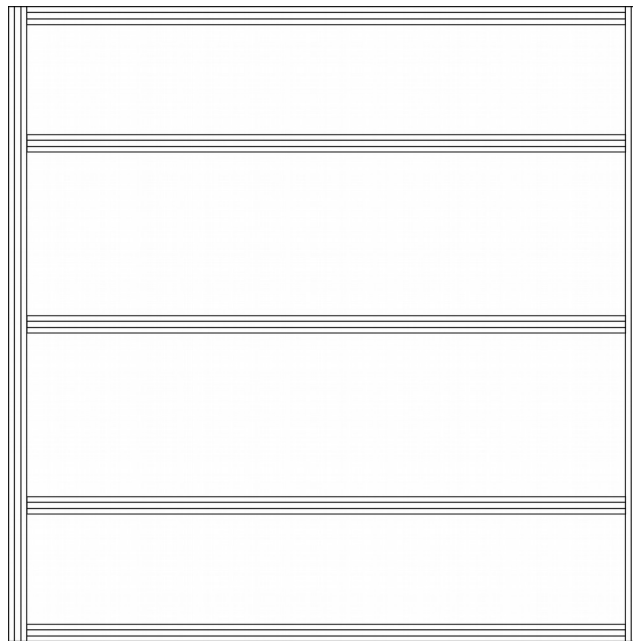
Step 1. Cut 2020 Aluminum extrusion with mitre saw equipped with aluminum cutting blade. 2 pieces should be 700mm long and 3 pieces should be 660mm long. Lengths should be exact and extrusion should be cut square with flush edges.

Step 2. Measure holes for drilling. Use a centerpunch to make drilling easier. Drill 4.2mm holes in 700mm extrusions.



Step 3. Place 1 T Nut in 3 of the 660mm extrusions and 5 T Nuts in 2 of the extrusions.

Step 4. Attach extrusions with Corner brackets and M5x8 screws. The 3 extrusions with 1 T Nut should be in the middle and the 2 with 5 nuts should be on the outside. The two long extrusions should be parallel to each other on the outside edges. 4.2mm holes should be aligned with M5 center hole in perpendicular extrusions.



Step 5. Tap 4.2mm holes with an M5 tap. Bolt frame with m5x20 screws.

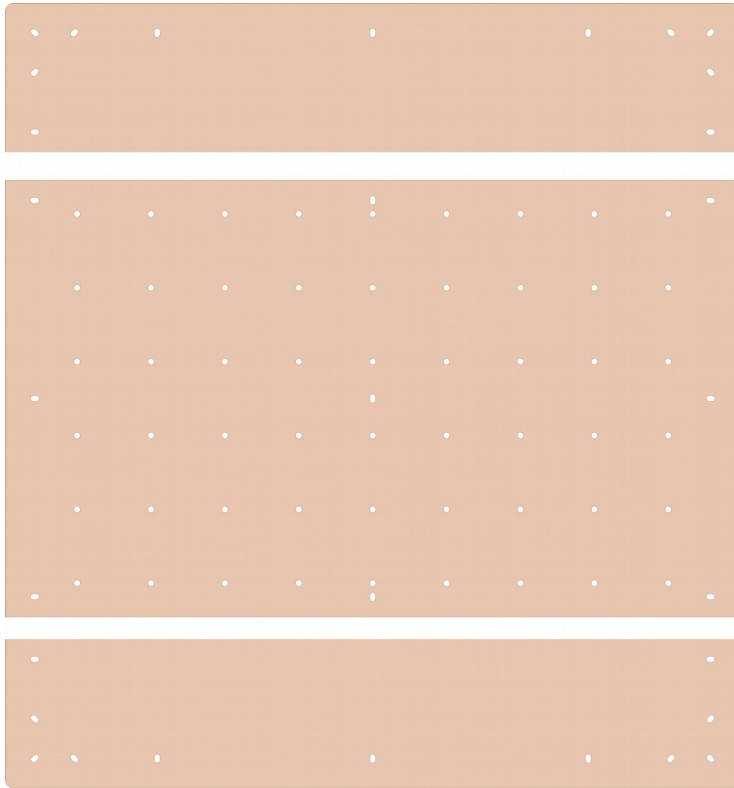
Step 6. Cut MDF to exactly 740x740mm.

Step 7. Secure MDF to the bed of a 1000x1000mm XCarve. Load a 1/4" drill bit into the Xcarve and run the program to drill holes.

Step 8. Change tools to the endmill. Run program to cut the slotted holes and trim the wasteboard

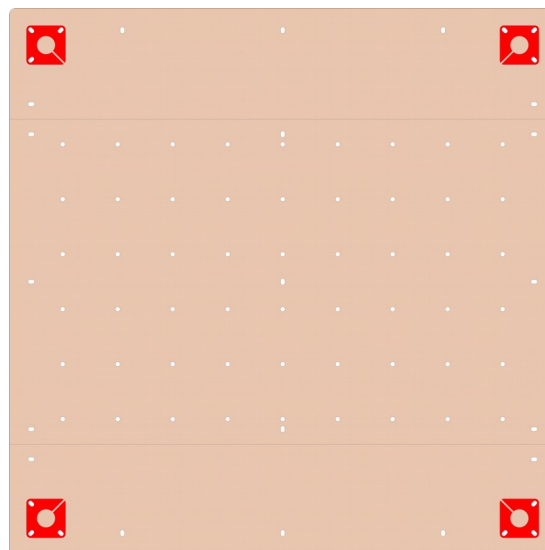
Step 9. Remove wasteboard from XCarve. Using a drill + countersink bit, countersink center hole until M5x18 bolt will sit flush or slightly depressed.

Step 10. Using a tablesaw, cut 150mm off both ends of the wasteboard.



Step 11. Turn over center section of wasteboard and install M5 threaded inserts into the 1/4" holes.

Step 12. Secure board to frame with M5x15 screws. Use M5x23 screws to bolt down feet for MPCNC



Continue with final assembly steps per v1engineering.com