

MechMate

Drawing Number	Process	Revision	DATE dd/mm/yy	TITLE	DATE COMPLETED	NOTES
10 00 000	A	B	17-10-07	MechMate Router Table - General Assembly		
10 10 000	A	B	17-10-07	TABLE ASSEMBLY		
10 10 123	D	A	22-09-06	SUPPORT BOARD - DRILLED		
10 10 200	A	A	15-11-06	X-RAIL ASSEMBLY		
10 10 220	A	A	17-10-07	ALU / V-CAP X-RAIL ASSEMBLY		
10 10 240	W	A	20-10-06	STEEL X-RAIL- Welded		
10 10 241	W	A	17-10-07	ALU X-RAIL BASE - Welded		
10 10 246	D	B	06-09-07	X-RAIL - Drilled & Tapped		
10 10 247	D	A	17-10-07	X-RAIL SUPPORT ALU - Drilled & Tapped		
10 10 248	D	A	20-10-06	X-RAIL STOPPER BLOCK - DRILLED & TAPPED		
10 10 248	S	A	20-10-06	X-RAIL STOPPED BLOCK - SAWN		
10 10 300	D	A	15-11-06	TABLE DRILLED & TAPPED FOR X-RAILS		
10 10 300	W	B	27-06-08	TABLE STRUCTURAL WELDMENT		
10 10 302	D	A	23-08-06	CROSS BEARER - DRILLED		
10 10 302	S	B	27-06-08	CROSS BEARER - CUT		
10 10 304	S	A	03-09-06	CROSS ANGLE BRACE - CUT		
10 10 306	S	A	03-09-06	LOWER CROSS BRACE - CUT		
10 10 307	D	A	16-09-06	UMBILICAL PLATE - DRILLED		
10 10 307	S	A	14-09-06	UMBILICAL PLATE - SAWN		
10 10 310	W	A	01-09-06	SIDE FRAME - WELDMENT		
10 10 312	S	B	25-11-06	LOW LONGITUDINAL - CUT		
10 10 314	S	A	03-09-06	VERTICAL BEARER - CUT		
10 10 316	S	A	03-09-06	LONG, ANGLE BRACE - CUT		
10 10 320	W	A	22-07-06	MAIL LONGITUDINAL BEAM ENDS WELDED WITH CLOSING PLATES		
10 10 322	S	A	22-08-06	MAIN LONGITUDINAL BEAM - CUT		
10 10 324	G	A	21-07-06	END-CLOSING PLATE		
10 10 330	W	A	24-08-06	LEG & FOOTPLATE - WELDMENT		
10 10 332	S	A	24-08-06	TABLE LEG - CUT		
10 10 334	D	A	21-08-06	FOOT CLOSING PLATE		
10 10 334	G	A	21-08-06	FOOT CLOSING PLATE		
10 20 000	A	B	09-10-07	GANTRY ASSEMBLY		
10 20 200	A	A	15-11-06	ANGLE IRON Y-RAIL ASSEMBLY W/RACK		
10 20 210	A	A	15-11-06	Y-RAIL ASSEMBLY - (NO RACK)		
10 20 220	A	A	09-10-07	ALU / V-CAP Y-RAIL ASSEMBLY WITH RACK		
10 20 225	A	A	09-10-07	ALU / V-CAP Y-RAIL ASSEMBLY NO RACK		

10 20 235	D	A	17-10-06	Y-RAIL CLAMP STRIP - DRILLED & TAPPED		
10 20 235	S	A	17-10-06	Y-RAIL CLAMP STRIP - SAWN		
10 20 240	W	A	19-10-06	ANGLE IRON Y-RAIL - Welded		
10 20 241	W	A	09-10-07	ALU RAIL BASE - Welded		
10 20 246	D	C	27-06-08	ANGLE IRON Y-RAIL - Drilled & Tapped		
10 20 247	D	A	08-10-07	Y-RAIL SUPPORT ALU - Drilled & Tapped		
10 20 248	S	A	20-10-06	Y-RAIL STOPPER BLOCK - SAWN		
10 20 400	W	B	08-10-06	GANTRY FRAME - WELDED		
10 20 440	D	B	27-06-08	CROSS MEMBER TUBE - DRILLED		
10 20 440	S	A	17-10-06	CROSS MEMBER TUBE - SAWN		
10 20 451	W	A	26-09-07	NEAR GANTRY END SUB-WELDMENT		
10 20 451	D	A	08-10-07	NEAR CARRIER PLATE - DRILLED CSK		
10 20 451	B	A	09-10-07	NEAR CARRIER PLATE - BENT		
10 20 451	P	C	17-06-08	NEAR CARRIER PLATE - PROFILE CUT		
10 20 452	W	A	26-09-07	FAR GANTRY END SUB-WELDMENT		
10 20 452	D	A	08-10-07	FAR CARRIER PLATE - DRILLED CSK		
10 20 452	B	A	08-10-07	FAR CARRIER PLATE - BENT		
10 20 452	P	C	17-06-08	FAR CARRIER PLATE - PROFILE CUT		
10 20 456	B	B	18-05-07	STIFFENING CLOSURE		
10 20 456	P	A	14-07-06	STIFFENING CLOSURE - PROFILE CUT		
10 20 457	B	A	26-09-07	STIFFENING CLOSURE - CABLE CARRIER		
10 20 457	P	A	26-09-07	STIFFENING CLOSURE - PROFILE CUT (AT CABLE CARRIER CORNER)		
10 20 458	B	A	26-09-07	STIFFENING CLOSURE - RH		
10 20 458	P	A	25-09-07	STIFFENING CLOSURE - PROFILE CUT		
10 30 000	A	B	25-09-07	Y-CAR ASSEMBLY		
10 30 420	W	A	22-11-06	Y-CAR FRAME WELDED		
10 30 422	B	D	08-06-08	CAR MAIN PLATE - BENT		
10 30 422	P	D	08-06-08	CAR MAIN PLATE - PROFILE CUT		
10 30 450	D	C	26-06-08	CAR CARRIER PLATE - CSK DRILLED		
10 30 450	P	G	17-04-08	CAR CARRIER PLATE - PROFILE CUT		
10 30 455	P	B	05-11-06	TOWER CARRIER PLATE - PROFILE CUT		
10 40 000	A	B	10-10-07	250mm [10"] Z-SLIDE ASSEMBLY		
10 40 014	A	A	17-10-07	350mm [14"] Z-SLIDE ASSEMBLY		
10 40 330	M	A	20-11-06	250mm [10"] SLIDE PLATE - MILLED/GROUND		
10 40 330	D	B	10-10-07	250mm [10"] Z-SLIDE PLATE -DRILLED		
10 40 330	S	A	20-11-06	250mm [10"] SLIDE PLATE - SAWN		
10 40 334	M	A	10-10-07	350mm SLIDE PLATE - MILLED/GROUND		

10 40 334	D	A	10-10-07	350mm [14"] Z-SLIDE PLATE - DRILLED		
10 40 334	S	A	10-10-07	350mm [14"] SLIDE PLATE -SAWN		
10 40 360	D	C	27-06-08	250mm [10"] SLIDE TUBE - DRILLED & TAPPED		
10 40 360	S	B	27-06-08	250mm [10"] Z-SLIDE TUBE - SAWN		
10 40 364	D	B	27-06-08	350mm SLIDE TUBE - DRILLED & TAPPED		
10 40 364	S	B	27-06-08	350mm [14"] Z-SLIDE TUBE -SAWN		
10 40 372	B	A	10-10-07	UPPER STRUT BRACKET - BEND		
10 40 372	P	A	10-10-07	UPPER STRUT BRACKET - LASER PROFILE		
10 40 386	D	A	30-11-06	Z-SPRING ANCHOR - DRILLED & RADIUSED		
10 40 386	B	A	30-11-06	Z-SPRING ANCHOR - BEND		
10 40 386	S	A	30-11-06	Z-SPRING ANCHOR - BLANK		
10 40 387	B	A	17-06-08	Z-SPRING ANCHOR - BEND		
10 40 387	P	A	17-06-08	Z-SPRING ANCHOR - PROFILE		
10 40 430	W	B	25-09-07	SPIDER - WELDED		
10 40 432	D	B	25-09-07	SPIDER PLATE - DRILLED		
10 40 432	B	C	27-06-08	SPIDER PLATE - BEND		
10 40 432	P	F	26-06-08	SPIDER PLATE - PROFILE CUT		
10 40 434	P	D	27-06-08	MOTOR PLATE LUG - PROFILE CUT		
10 60 100	A	A	06-11-07	CABLE CHAIN ASSEMBLIES		
10 60 210	W	A	06-11-07	X-CABLE CHAIN SHELF - WELD		
10 60 215	S	A	06-11-07	X-CABLE CHAIN SHELF - CUT		
10 60 215	B	B	27-06-08	X-CABLE CHAIN SHELF - BEND		
10 60 215	P	B	17-06-08	X-CABLE CHAIN SHELF - PROFILE CUT		
10 60 217	S	A	06-11-07	X-CABLE CHAIN SHELF ROD		
10 60 310	W	A	06-11-07	Y-CABLE CHAIN SHELF - WELD		
10 60 315	S	A	06-11-07	Y-CABLE CHAIN SHELF - CUT		
10 60 315	B	A	06-11-07	Y-CABLE CHAIN SHELF - BEND		
10 60 315	P	A	06-11-07	Y-CABLE CHAIN SHELF - PROFILE CUT		
10 60 317	S	A	06-11-07	Y-CABLE CHAIN SHELF ROD		
10 60 318	S	A	06-11-07	GANTRY CABLE DUCT		
10 60 325	P	A	25-09-07	Y-CAR CABLE CHAIN ANCHOR		
10 70 105	C	A	15-06-07	SINGLE PHASE "HOBBYIST" SUPPLY		
10 70 115	C	A	15-06-07	115V SINGLE PHASE SUPPLY (AMERICA'S)		
10 70 130	C	A	15-06-07	230V / 115V SPLIT-PHASE SUPPLY (AMERICA'S)		
10 70 230	C	A	15-06-07	230V SINGLE PHASE SUPPLY (non-AMERICA'S)		
10 70 380	C	A	15-06-07	380V THREE-PHASE SUPPLY (non-AMERICA'S)		
M1 10 110	M	C	27-06-08	STEEL RAILS - CUT & MILLED		

M1 10 120	S	A	06-10-07	ALUMINUM RAIL BASES - SAWN		
M1 18 000	A	B	06-10-07	CAR STOPPER LIMIT SWITCH ASSY.		
M1 18 020	D	A	28-06-08	CAR STOPPER BLOCK - DRILLED & TAPPED		
M1 18 020	W	B	28-06-08	CAR STOPPER BLOCK - WELDED		
M1 18 021	S	B	28-06-08	STOPPER BASE - SAWN		
M1 18 022	S	B	28-06-08	STOPPER LIP - SAWN & NOTCHED		
M1 18 023	S	A	28-06-08	PROX EXTENSION - CUT		
M1 18 027	T	A	30-11-06	PROXIMITY TARGET - TURNED		
M1 20 100	A	B	27-06-08	V-ROLLER ASSEMBLY		
M1 20 120	A	B	23-02-07	V-WHEEL		
M1 20 121	T	B	23-02-07	V-TYRE		
M1 20 210	T	B	23-02-07	ECCENTRIC BUSH		
M1 20 220	T	B	23-02-07	BEARING SUPPORT BASE - TURNED		
M1 30 200	A	A	07-10-07	HOLD-DOWN IDLER ROLLER - ASSEMBLY		
M1 30 222	W	A	07-10-07	HOLD-DOWN IDLER ROLLER - WELDED		
M1 30 224	T	A	07-10-07	HOLD-DOWN IDLER STUB SHAFT		
M1 30 332	P	A	24-09-07	HOLD-DOWN SWING PLATE - PROFILE CUT		
M2 10 110	D	A	01-11-06	X&Y RACKS - DRILLED		
M2 10 110	W	A	01-11-06	RACKS - WELDED & CUT TO LENGTH		
M2 10 120	D	C	29-06-08	250mm [10'] Z-RACK - DRILLED & TAPPED		
M2 10 120	S	C	29-06-08	250mm [10'] Z-RACK - SAWN		
M2 10 124	D	A	10-10-07	350mm [14'] Z-RACK - DRILLED & TAPPED		
M2 10 124	S	A	10-10-07	350mm [14'] Z-RACK - SAWN		
M2 30 110	T	A	01-11-06	PINION GEARS - MACHINED		
M3 10 100	K	B	22-11-06	MOTOR SPRING		
M5 10 100	A	A	01-11-06	MOTOR ASSEMBLY - DIRECT DRIVE		
M5 10 150	A	A	21-11-06	Z-MOTOR ASSEMBLY - DIRECT DRIVE		
M5 10 160	A	B	27-06-08	Z-MOTOR ASSEMBLY - GEARED DRIVE		
M5 10 200	A	C	27-06-08	MOTOR ASSEMBLY - GEARED DRIVE		
M5 10 312	D	B	27-06-08	UNIVERSAL MOTOR PLATE - DRILLED		
M5 10 312	P	B	12-05-06	MOTOR SWING PLATE - PROFILE CUT		
M5 10 314	D	A	27-06-08	GEARED MOTOR PLATE - CSK DRILLED		
M5 10 314	P	B	09-11-07	GEARED MOTOR PLATE - PROFILE CUT		
M5 10 322	D	A	24-11-06	Z-MOTOR PLATE - DRILLED & TAPPED		
M5 10 322	P	C	21-11-06	UNIV. Z-MOTOR PLATE - PROFILE CUT		
M5 10 324	P	A	06-10-07	GEARED Z-MOTOR PLATE - PROFILE CUT		
M6 10 100	A	A	07-11-07	RAIL GRINDING HEAD - BEVEL ASSY		

M6 10 115	B	A	07-11-07	GRIND HEAD TOP PLATE - BEND		
M6 10 115	P	B	17-06-08	GRIND HEAD TOP PLATE - PROFILE		
M6 10 116	B	A	07-11-07	GRIND HEAD BOTTOM PLATE - PROFILE		
M6 10 116	P	B	27-06-08	GRIND HEAD BOTTOM PLATE - PROFILE		

TEXT IN RED INDICATES CHANGES SINCE LAST ISSUE

WHERE THIS PART/PROCESS GOES TO NEXT, or "WHAT FOLLOWS AFTER THIS"

APPROX. DRAWING PAPER SCALE IF PRINTED A4 SIZE

THIS SYMBOL PLACED ON DRAWING TO MARK THE POSITION OF THE REVISION
 Δ = DELTA = DIFFERENCE

MATERIAL NEEDED TO MAKE THIS PART, or THE MATERIAL INVOLVED IN THE PROCESS.

Higher drawing/s: 10 40 000 A	1:2	Mounting for strut bracket	10-10-07	B
	Δ	Floated spring bracket mounting holes	27-06-08	C
Material: 3mm STEEL TUBING		Title: SLIDE TUBE - DRILLED & TAPPED		
MechMate www.mechmate.com		Drawing Number: 10 40 360	Process: D	Revision: C

HISTORY OF TWO MOST RECENT REVISIONS

OPTION

LATEST REVISION PUBLISHED

Denotes that more drawings exist that show another way of doing it. This part is not essential.

- PROCESSES:**
- A - ASSEMBLY, NORMALLY CAPABLE OF DISASSEMBLY
 - B - BEND
 - W - WELDED
 - S - CUT BY SAWING FROM "LENGTHS" STOCK
 - D - DRILLED, WITH OR WITHOUT TAPPED THREADS
 - P - PROFILE CUT, TYPICALLY LASER (or JIGSAW, PLASMA, etc.)
 - G - CUT BY GUILLOTINE FROM SHEET STOCK
 - K - SPRING
 - T - TURNED ON A LATHE
 - M - MILLED (or GROUND)
 - H - HARDEN, HEAT TREATED.
 - C - CIRCUIT

BROAD "STYLE" OF MACHINE. MIGHT USE 20 FOR A WALL MOUNTED MACHINE, OR 30 FOR TRAILER MOUNTED, OR 40 FOR ROCK CARVER, WHO KNOWS WHAT THE FUTURE HOLDS. . . .

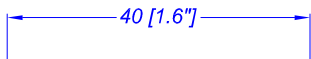
- SUB-ASSEMBLIES:**
- 10 - TABLE
 - 20 - GANTRY
 - 30 - Y-CAR
 - 40 - Z-SLIDE
 - 50 - TOOLHOLDER
 - 60 - CABLE MANAGEMENT
 - 70 - ELECTRICAL

CONVENIENT NUMBER WITH NO LOGIC.

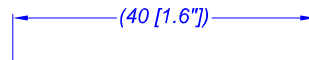
THE "M" NUMBERS ARE FOR ELEMENTS THAT COULD BE COMMON TO A NUMBER OF STYLES, OR LOCATIONS ON A MACHINE

ABOVE DOES NOT APPLY TO COMMON PARTS

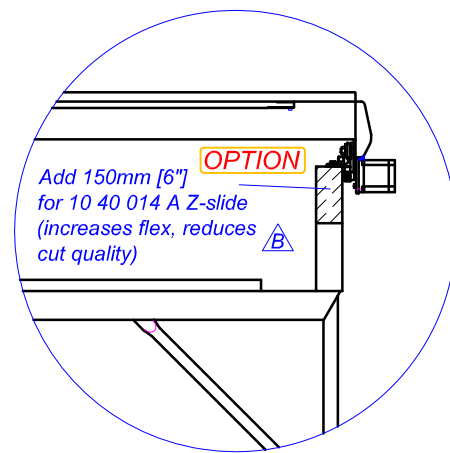
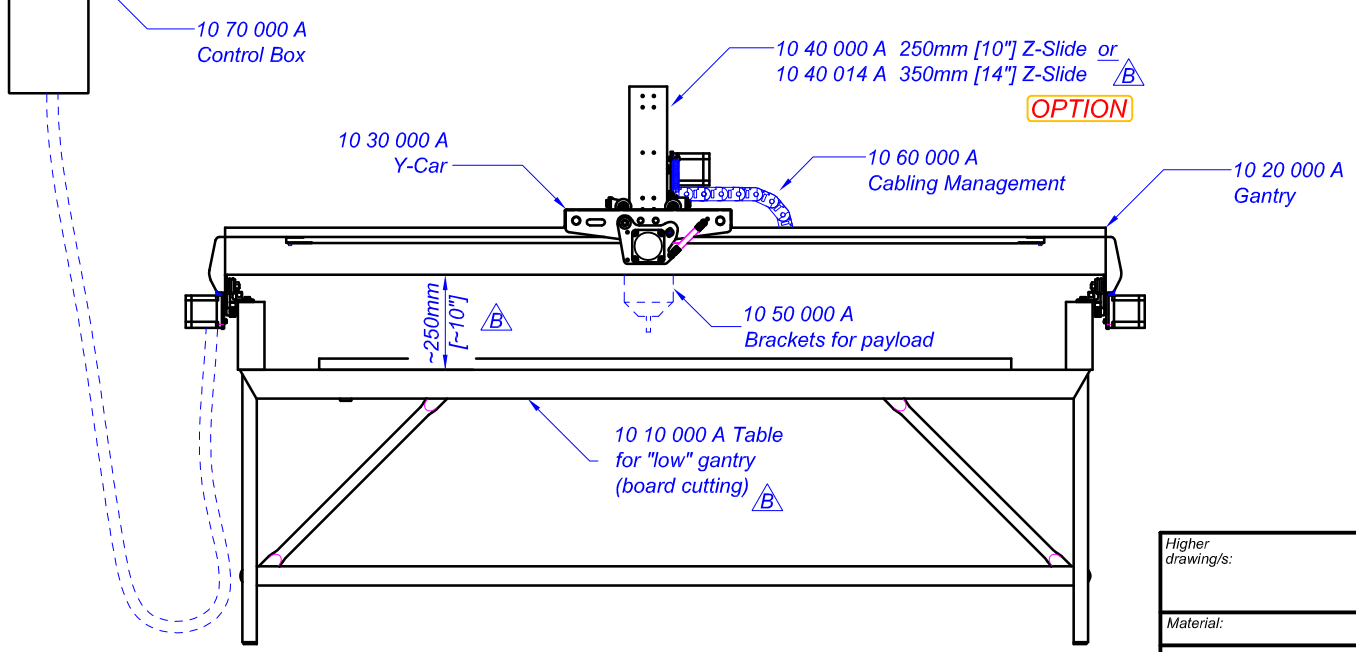
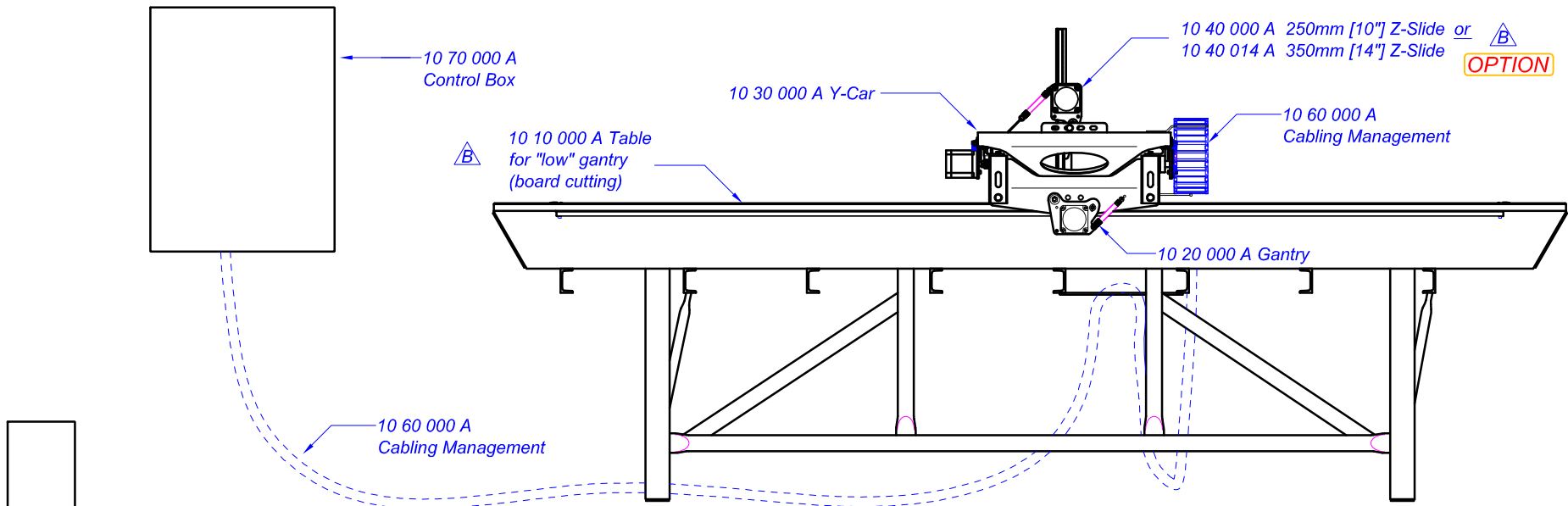
The mm symbol is seldom used. 40 millimeter or 1.6 inches. Inches in [] brackets



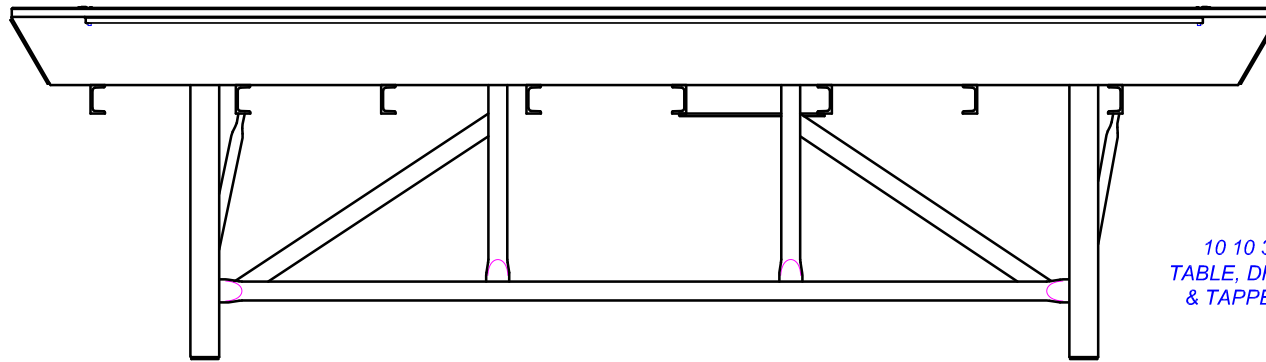
Dimensions in () brackets are approximate or typical. Not used for marking out.



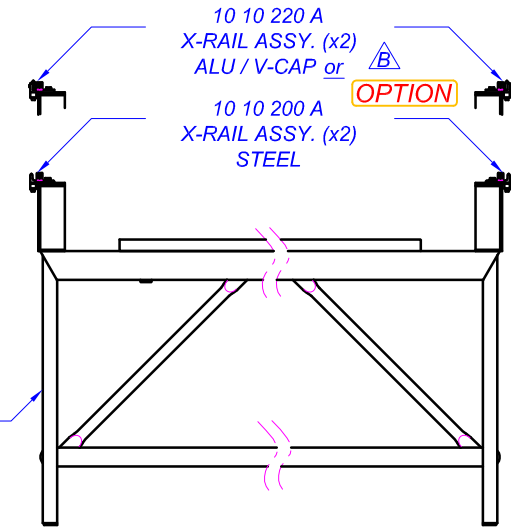
Higher drawing/s:	1:1	First issue	29-06-08	A
	Δ	Description of change	Date (d-m-y)	Rev.
Material:		Title: READING THE DRAWINGS		
MechMate www.mechmate.com		Drawing Number: 00 00 000	Process:	Revision: A



Higher drawing/s:	1:20	General revision	17-10-07	B
		First issue	28-11-06	A
Description of change			Date (d-m-y)	Rev.
Material:		Title		
 www.mechmate.com		MechMate Router Table - General Assembly		
		Drawing Number	Process	Revision
		10 00 000	A	B

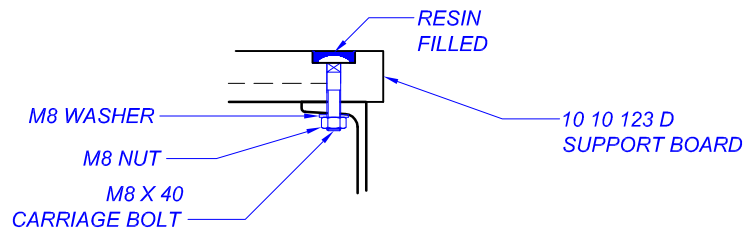
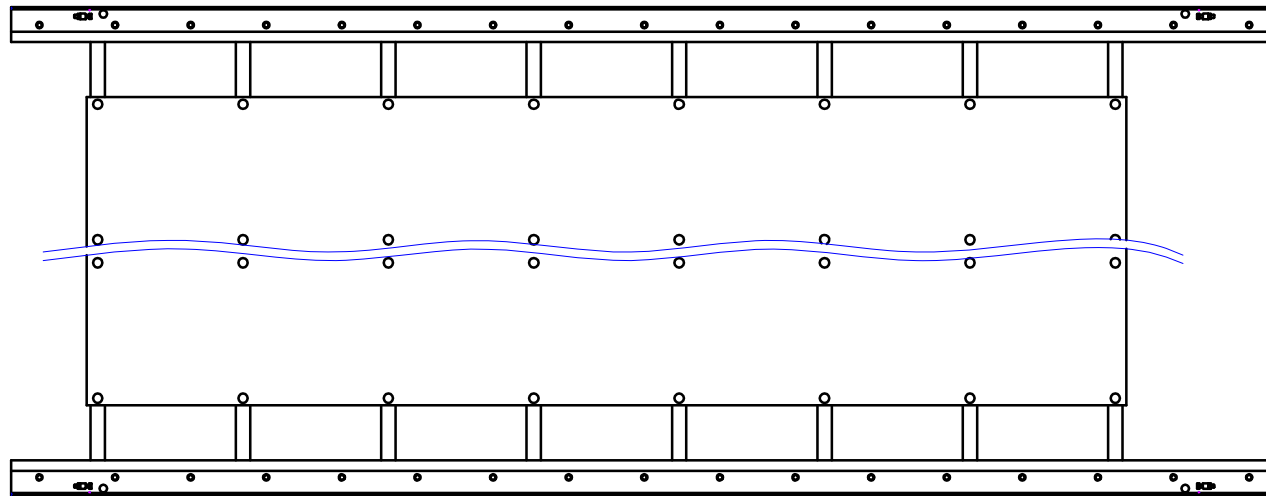


10 10 300 D
TABLE, DRILLED
& TAPPED(x1)



10 10 220 A
X-RAIL ASSY. (x2)
ALU / V-CAP or $\triangle B$
10 10 200 A
X-RAIL ASSY. (x2)
STEEL

OPTION



M8 WASHER

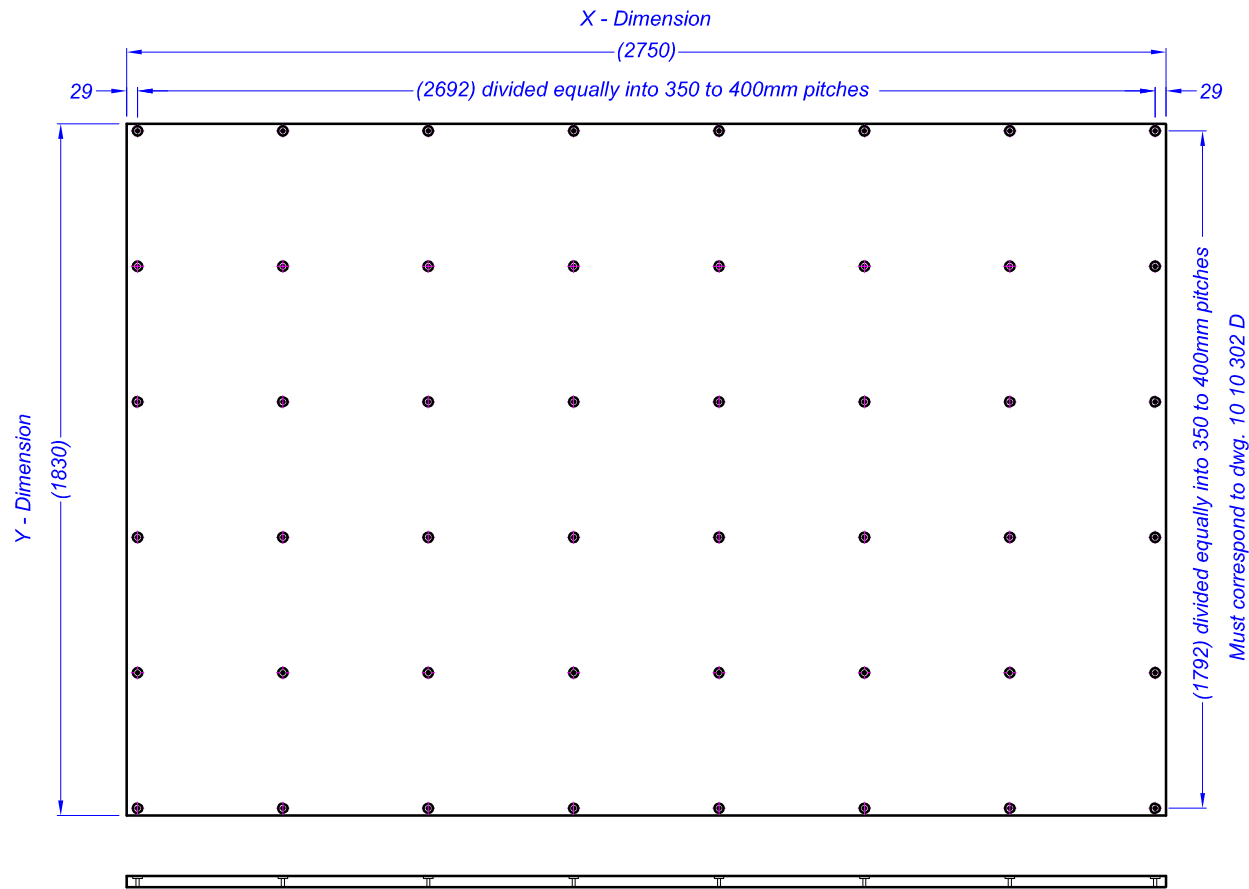
M8 NUT

M8 X 40
CARRIAGE BOLT

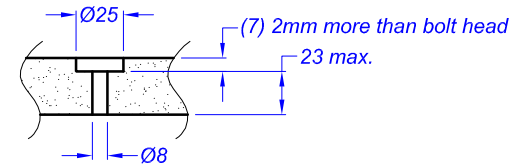
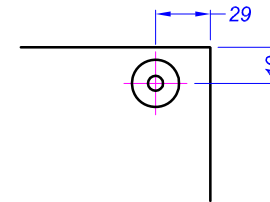
RESIN
FILLED

10 10 123 D
SUPPORT BOARD

Higher drawing/s:	10 00 000 A	1:20	Optional V-Cap (BWC /Hepco) rails	17-10-07	B
		$\triangle B$	First issue	11-06-07	A
			Description of change	Date (d-m-y)	Rev.
Material:	ASSEMBLY		Title		
MechMate			TABLE ASSEMBLY		
www.mechmate.com			Drawing Number	Process	Revision
			10 10 000	A	B

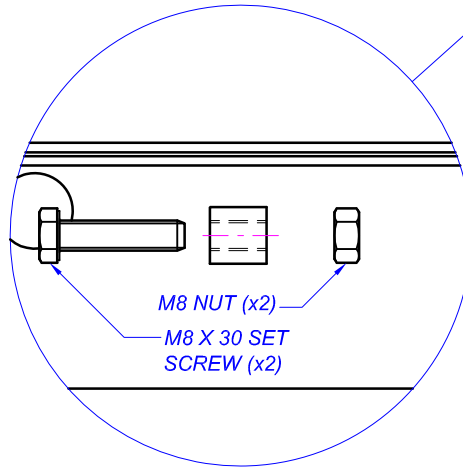
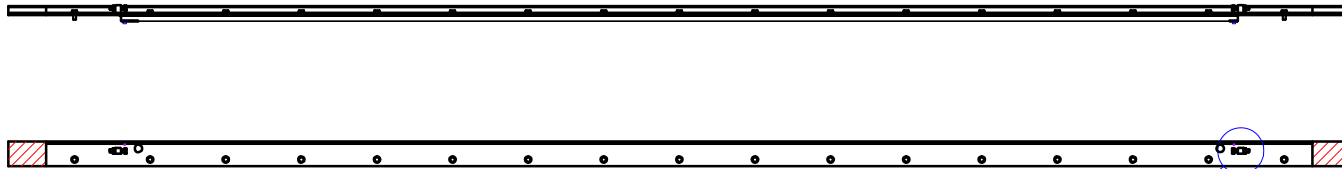


Note difference in dimensions from edges



Higher drawing/s:	10 10 000 A	1:20		
			First issue	22-08-06 A
			Description of change	Date (d-m-y) Rev.
Material:	MDF or PLYWOOD		Title	
			SUPPORT BOARD - DRILLED	
Drawing Number		Process	Revision	
10 10 123		D	A	

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The Y-gantry stops against the screw head. The stopping position is finely adjustable to serve as a reference "square" of the y-axis to the x-axis. This determines the starting "lock-up" position of the twin x-motors to keep the gantry permanently square for a session.

M8 x 20 SET SCREW
(per table size)

M8 WASHER
(per table size)

10 10 240 W
X-RAIL (x1)

3M DOUBLE-SIDED
TAPE

M2 10 110 D
X-RACK (x1)

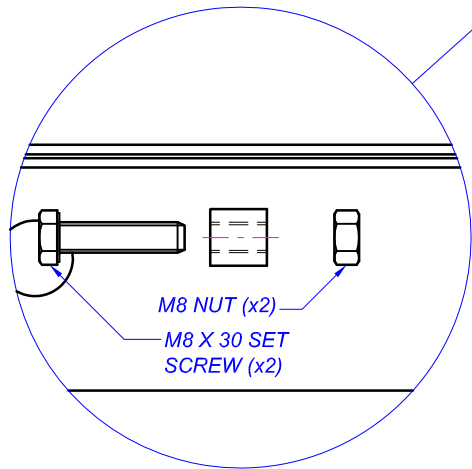
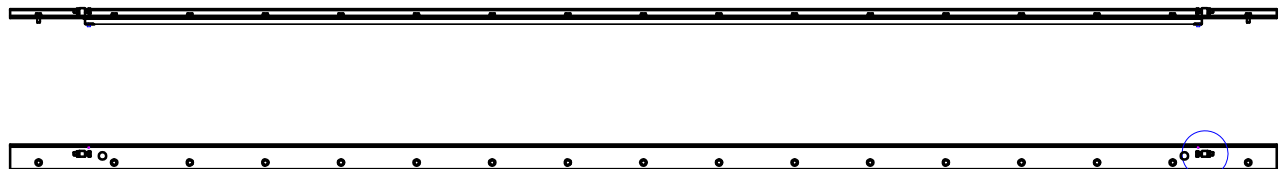
M6 WASHER (x2)

M6 x 25 SET
SCREW (x2)

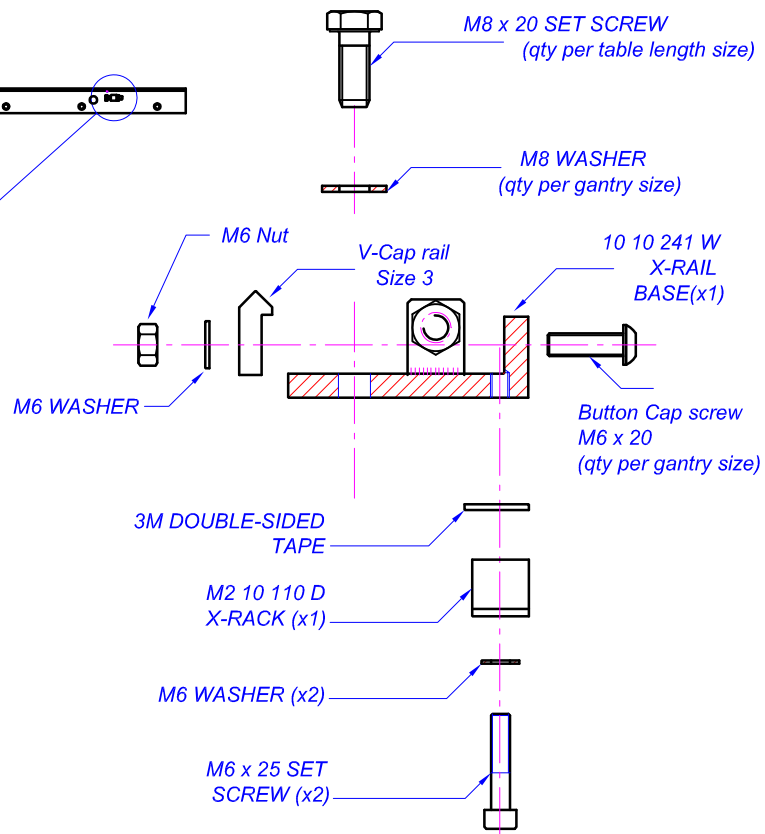
OPTION

Higher drawing/s:	10 10 000 A	1:20			
	2x assy's / table		First issue	15-11-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	ASSEMBLY		Title		
			X-RAIL ASSEMBLY		
	Drawing Number	Process	Revision		
	10 10 200	A	A		

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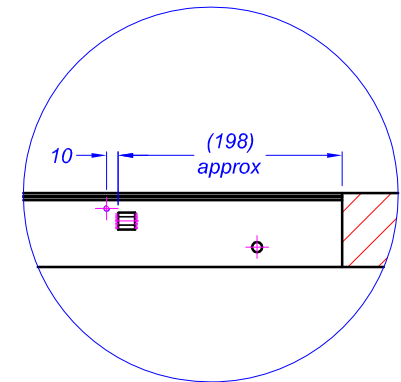
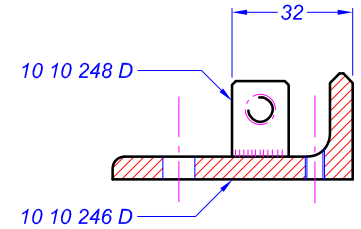
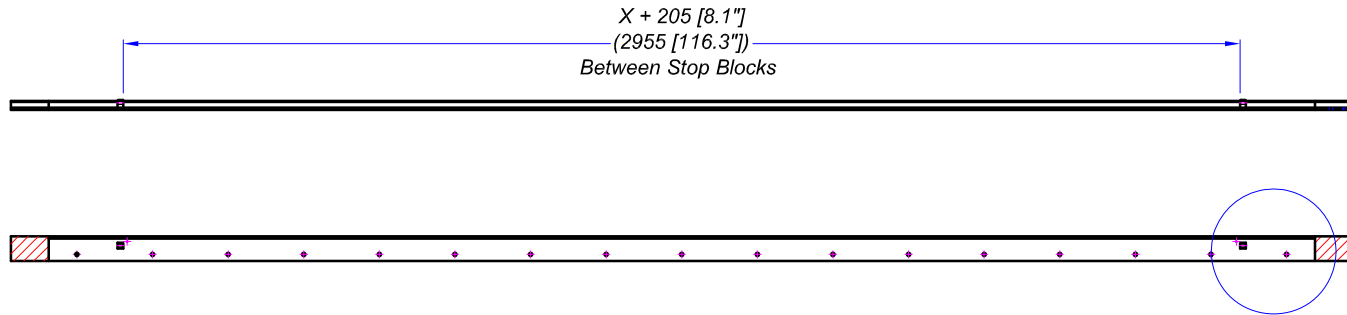
The Y-gantry stops against the screw head. The stopping position is finely adjustable to serve as a reference "square" of the y-axis to the x-axis. This determines the starting "lock-up" position of the twin x-motors to keep the gantry permanently square for a session.



OPTION

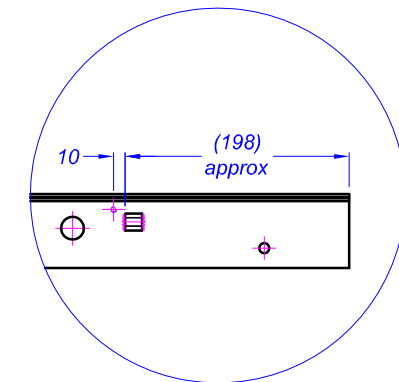
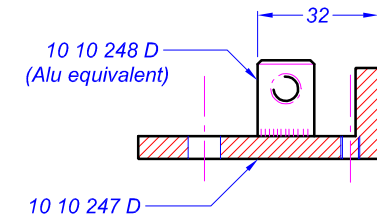
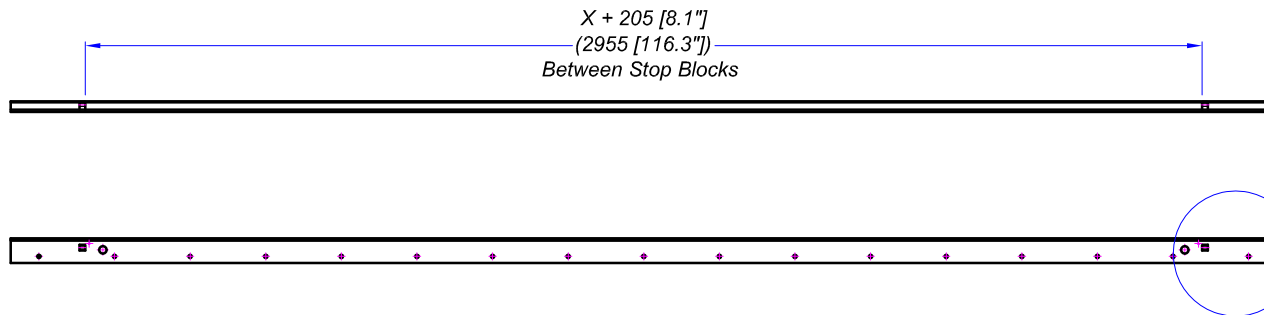
Higher drawing/s:	10 10 000 A	1:20			
	2x assy's / table		First issue	17-10-07	A
			Description of change	Date (d-m-y)	Rev.
Material:	ALU / STEEL		Title		
			ALU / V-CAP X-RAIL ASSEMBLY		
	Drawing Number	Process	Revision		
	10 10 220	A	A		

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OPTION

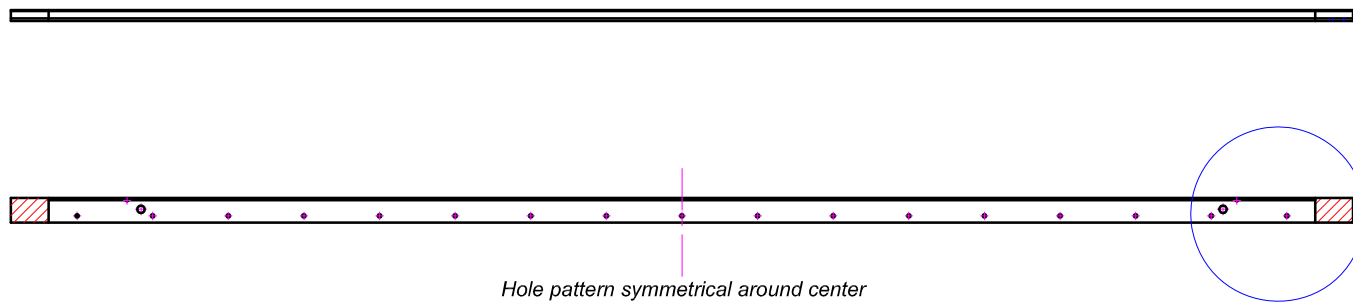
Higher drawing/s:	10 10 200 A	1:20			
			First issue	20-10-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	ANGLE IRON/STEEL		Title		
	MechMate		STEEL X-RAIL - Welded		
	Drawing Number	Process	Revision		
	10 10 240	W	A		



OPTION

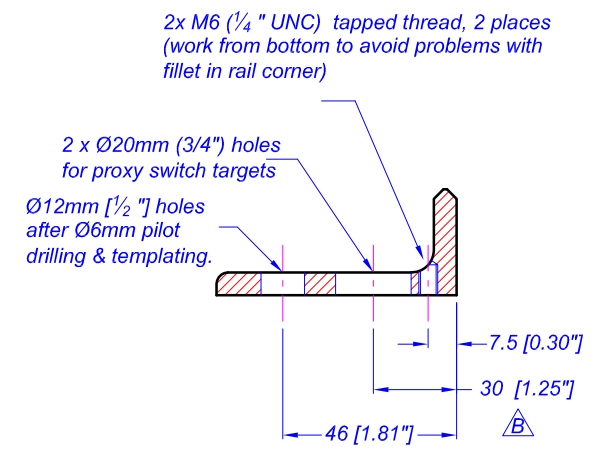
Higher drawing/s:	10 10 200 A	1: 20			
			First issue	17-10-07	A
			Description of change	Date (d-m-y)	Rev.
Material:	ALUMINIUM		Title		
			ALU X-RAIL BASE - Welded		
	Drawing Number		Process	Revision	
	10 10 241		W	A	

MechMate
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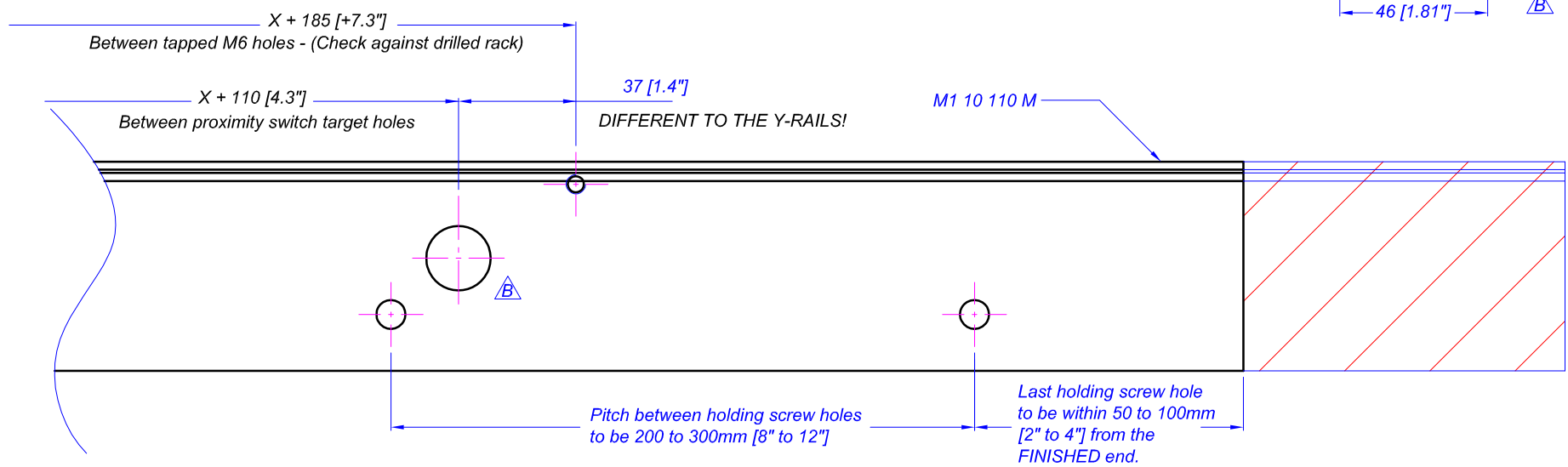
Hole pattern symmetrical around center

Enlarged below



2x M6 (1/4" UNC) tapped thread, 2 places (work from bottom to avoid problems with fillet in rail corner)

2 x Ø20mm (3/4") holes for proxy switch targets
 Ø12mm [1/2"] holes after Ø6mm pilot drilling & templating.

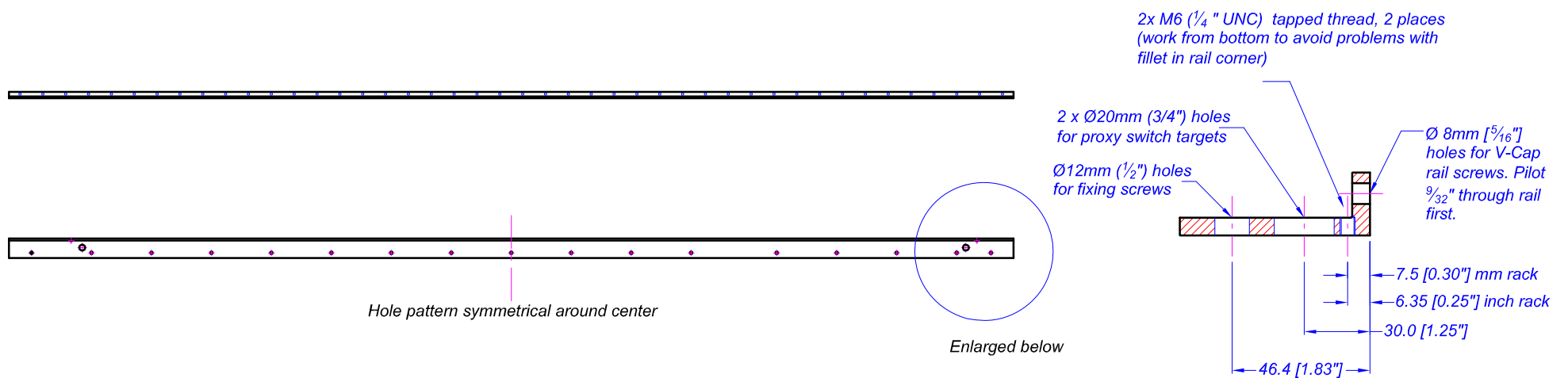


Notes:

1. Scribe line 46mm [1.81"] from reference edge.
2. Determine a suitable hole pattern, center punch and drill Ø6.8mm [1/4"]
3. Clamp rails to Table weldment 10 10 300 W and do preliminary alignment.
4. Drill Ø6.8mm [1/4"] holes through table's long beams for 10 10 300 D
5. Mark rail locations and un-clamp rails from table.
6. Enlarge holes in rails to Ø12mm [1/2"].

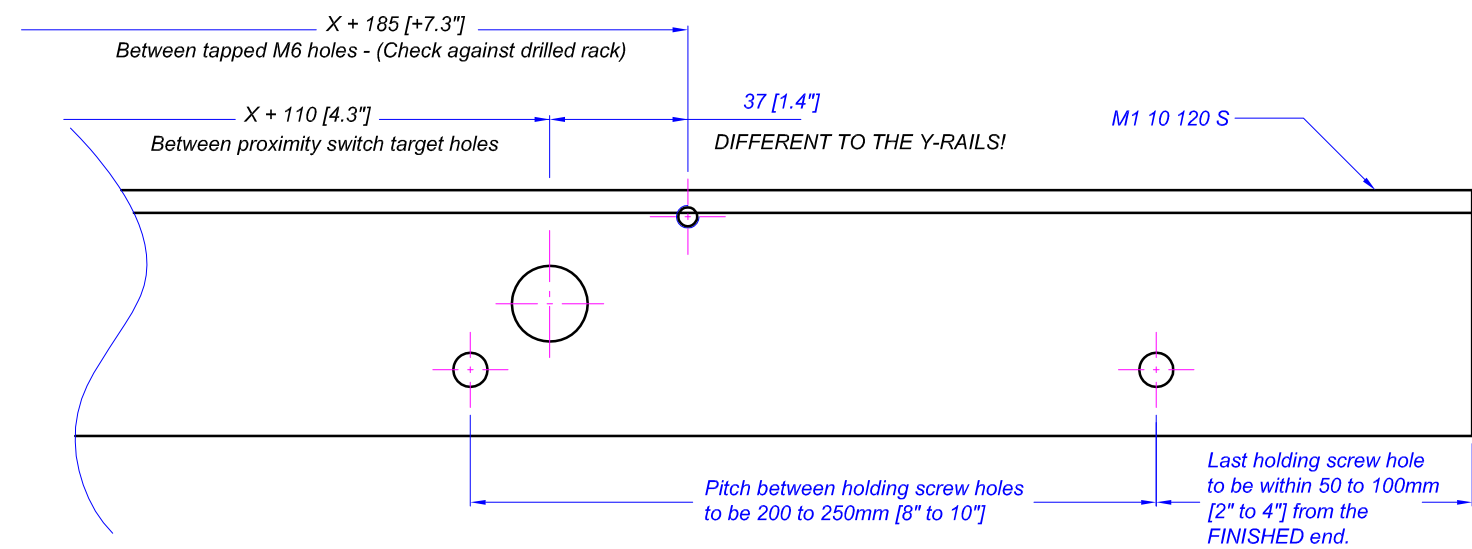
OPTION

Higher drawing/s:	10 10 240 W	1:20	Move proxy target hole inboard	06-09-07	B
			First issue	20-10-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	ANGLE IRON/STEEL		Title		
			X-RAIL - Drilled & Tapped		
	Drawing Number		Process	Revision	
	10 10 246		D	B	
	www.mechmate.com				



Hole pattern symmetrical around center


Enlarged below



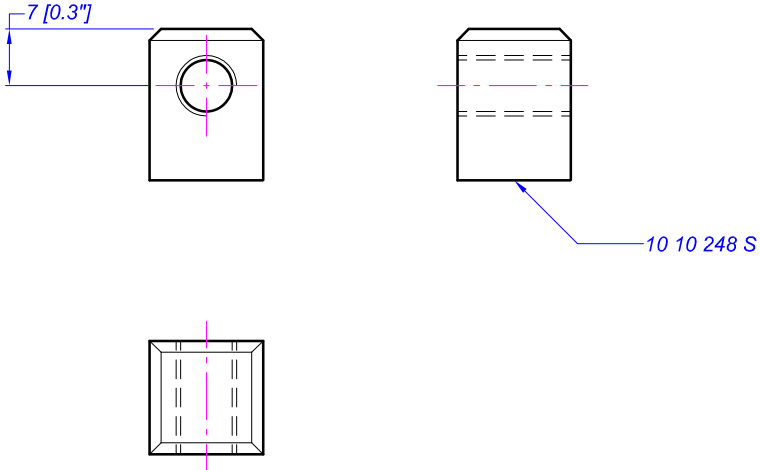
Notes:

1. Scribe line 46mm [1.81"] from reference edge.
2. Determine a suitable hole pattern, center punch and drill Ø6.8mm [1/4"]
3. Clamp rails to Table weldment 10 10 300 W and do preliminary alignment.
4. Drill Ø6.8mm [1/4"] holes through table's long beams for 10 10 300 D
5. Mark rail locations and un-clamp rails from table.
6. Enlarge holes in rails to Ø12mm [1/2"].

OPTION

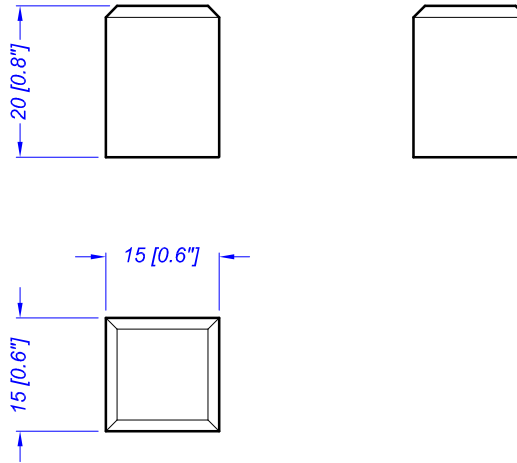
Higher drawing/s:	10 10 241 W	1:20		
			First issue	17-10-07 A
			Description of change	Date (d-m-y) Rev.
Material:	ALUMINIUM		Title	
 www.mechmate.com			X-RAIL SUPPORT ALU - Drilled & Tapped	
			Drawing Number	Process Revision
10 10 247			D	A

Drill 6.8mm and tap M8x1.25 thread
right through




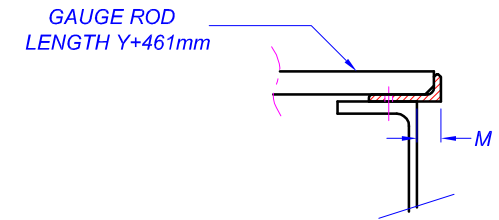
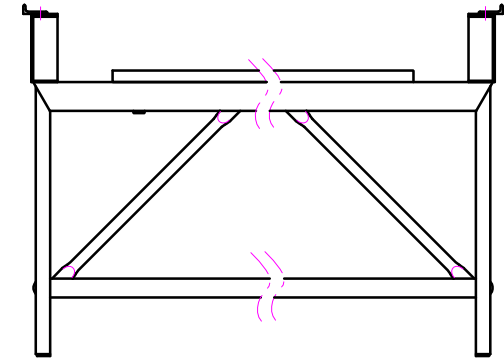
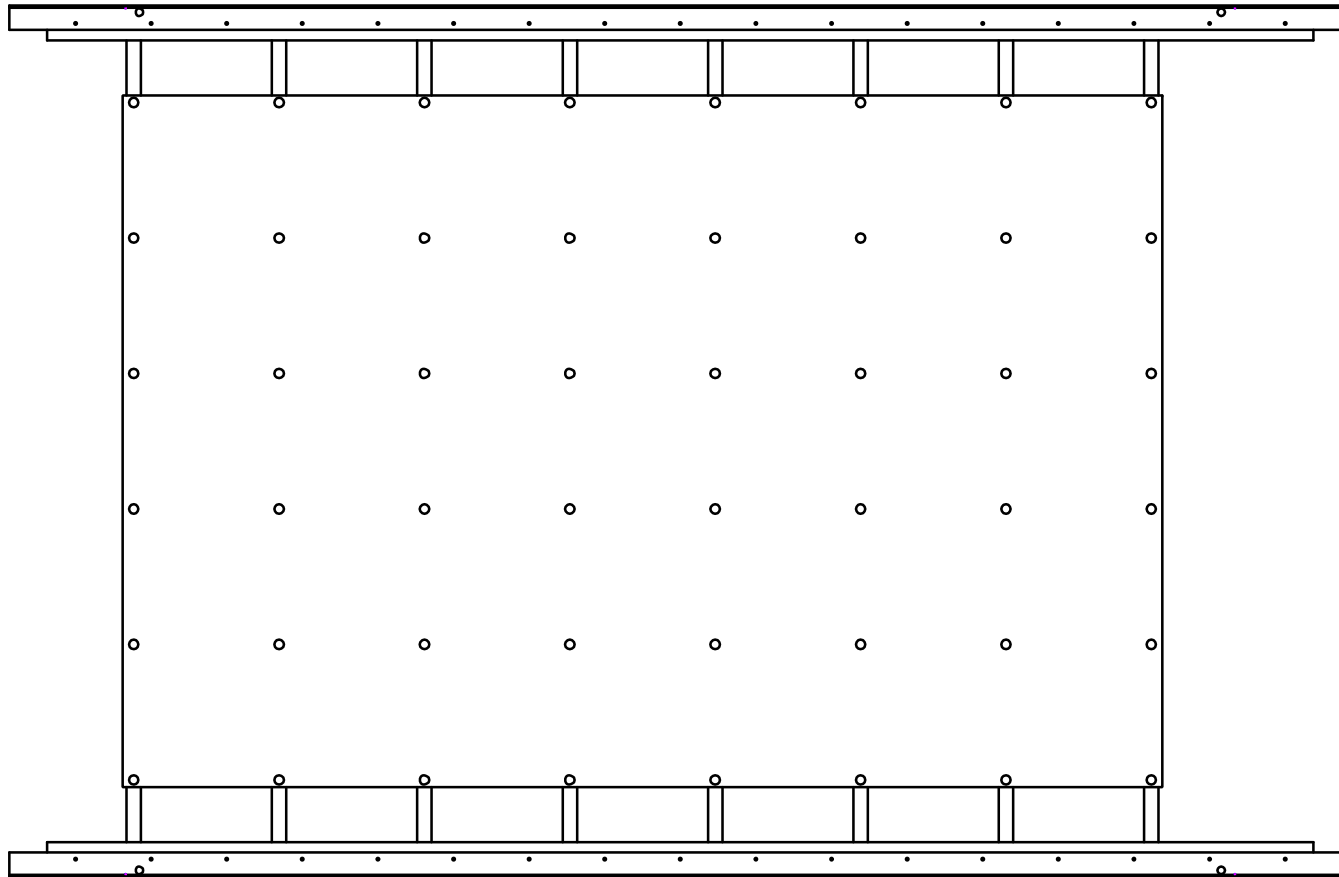
OPTION

Higher drawing/s:	10 10 240 W	1:1		
			First issue	20-10-06 A
			Description of change	Date (d-m-y) Rev.
Material:	15mm STEEL SQ BAR		Title X-RAIL STOPPER BLOCK - DRILLED & TAPPED	
			Drawing Number	Process Revision
	www.mechmate.com		10 10 248	D A




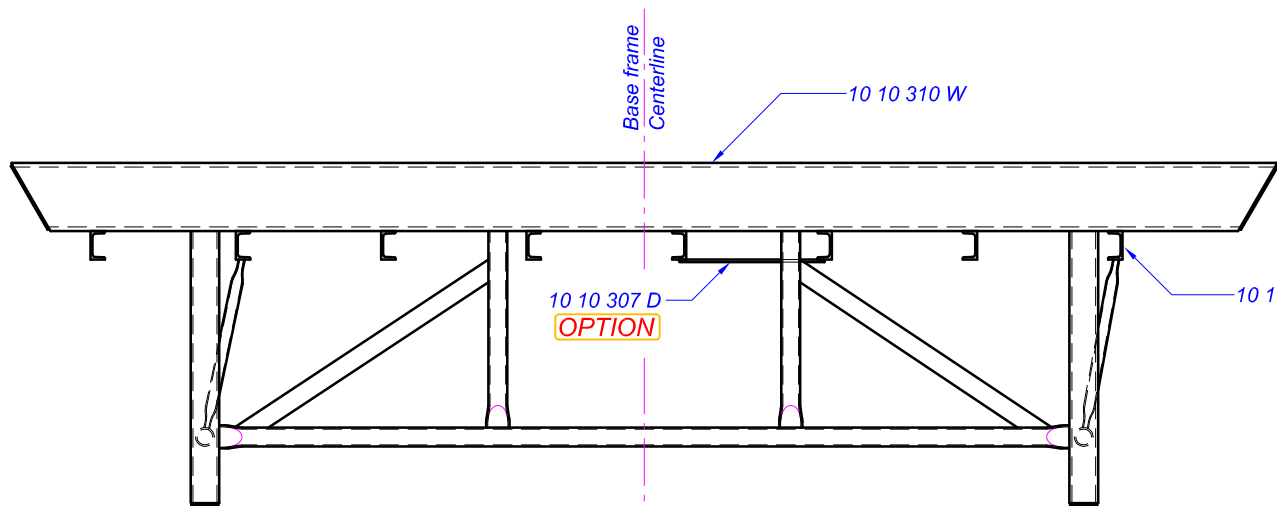
OPTION

Higher drawing/s:	10 10 248 D	1:1		
			First issue	20-10-06 A
			Description of change	Date (d-m-y) Rev.
Material:	15mm STEEL SQ BAR		Title	
			X-RAIL STOPPER BLOCK -SAWN	
	Drawing Number		Process	Revision
	10 10 248		S	A
	www.mechmate.com			

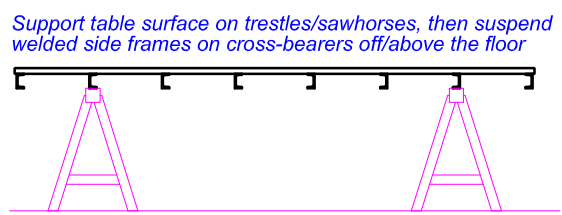
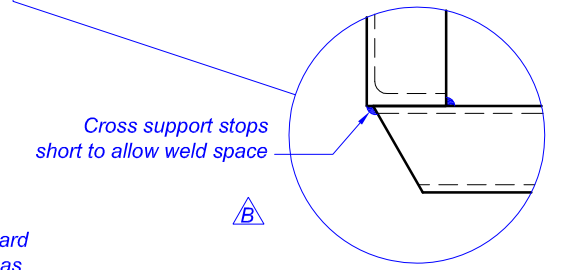
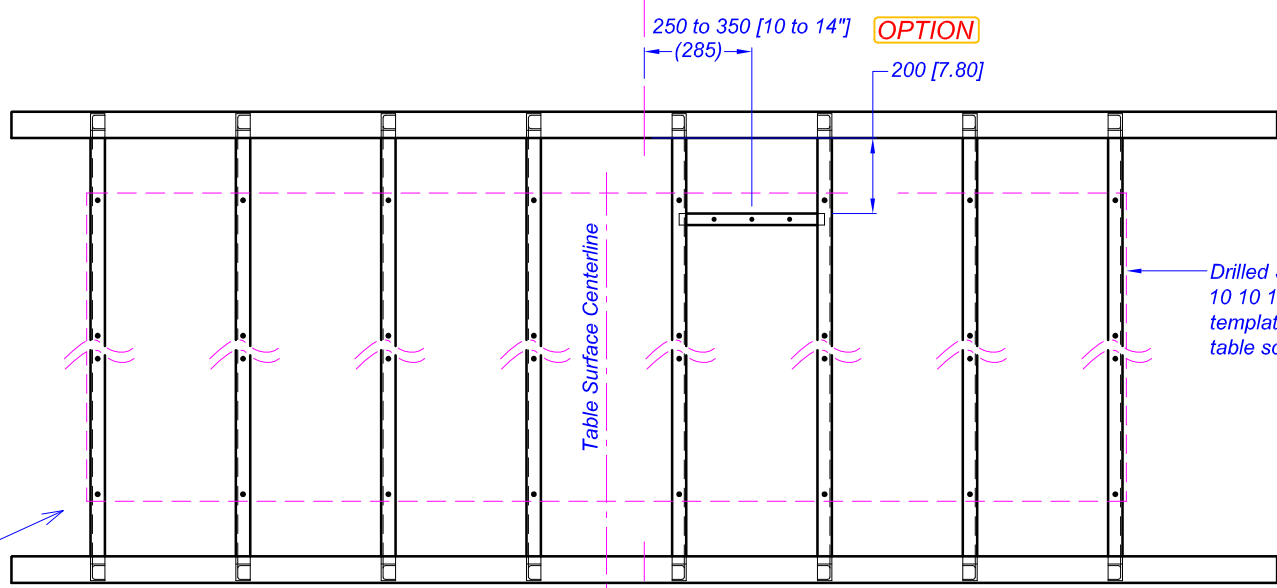
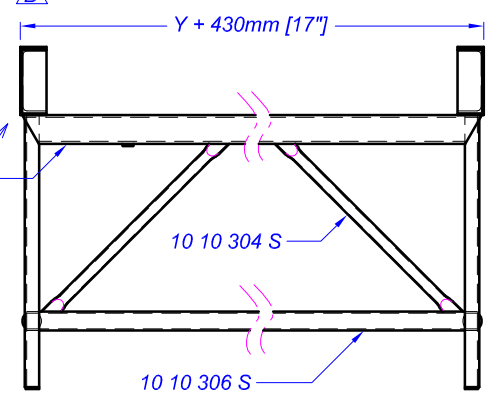


1. Use G-clamps to clamp the pilot drilled rails 10 246 D to the table.
2. Mark the locations/pairs on the rails and table.
3. Use a gauge rod to get the rails parallel to each other
4. With a tolerance of better than 1mm, align and straighten the rails, keeping dimension "M" equal at the 4 corners of the table.
5. Diagonal dimensions across the table, for squareness, is NOT important. A variance of 5 to 10mm is acceptable.
6. Drill the pilot holes through the table.
7. Remove the rails.
8. Drill pilots to $\text{Ø}7\text{mm}$ and tap M8 threads

Higher drawing/s:	10 00 000 A	1: 20			
			First issue	15-11-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	ASSEMBLY		Title		
			TABLE DRILLED & TAPPED FOR X-RAILS		
 www.mechmate.com		Drawing Number		Process	Revision
		10 10 300		D	A



This dimension tightly controlled during welding
(it is NOT the length of the cross support)

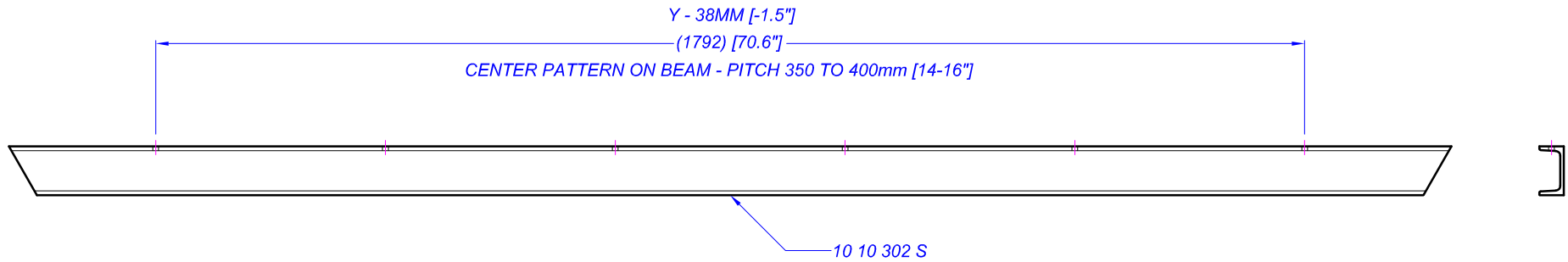


0,0 CORNER

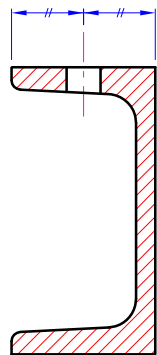


Table surface and cross-supports are offset toward 0,0 corner

Higher drawing/s:	10 10 300 D	1: 20	Added clarifying notes	27-06-08	B
			First issue	14-09-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	STEEL		Title		
 www.mechmate.com			TABLE STRUCTURAL WELDMENT		
			Drawing Number	Process	Revision
			10 10 300	W	B

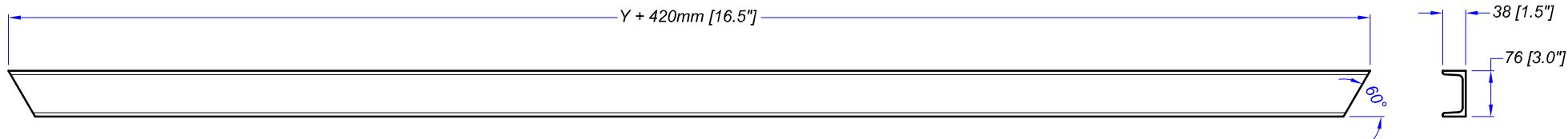


DRILL Ø9mm [3/8"] HOLES IN CENTER OF FLANGE



Higher drawing/s:	10 10 300 W	1:10			
			First issue	23-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	76 X 38 X 7kg/m CHANNEL		Title		
 www.mechmate.com			CROSS BEARER - DRILLED		
			Drawing Number	Process	Revision
			10 10 302	D	A

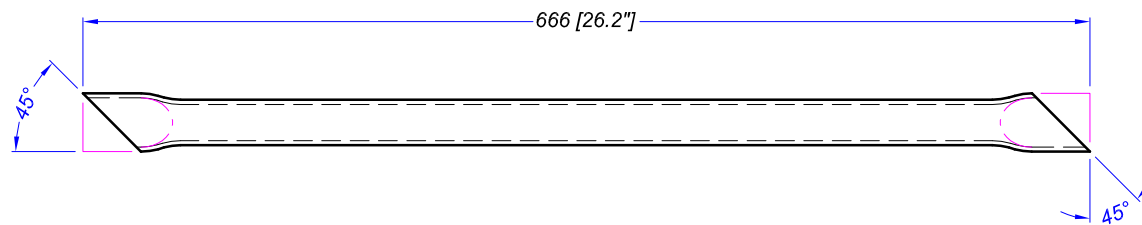
B THIS IS NOT THE FINISHED TABLE WIDTH!





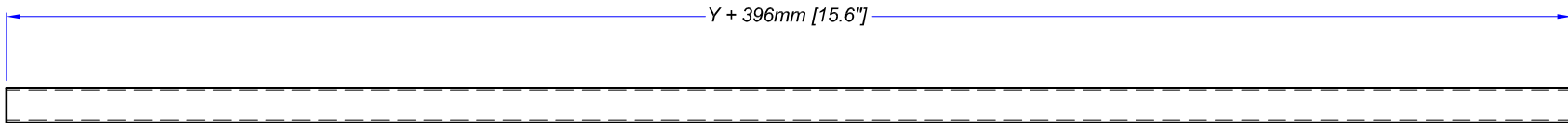
Note:



1. The 60° cut end is for aesthetics only - it is not functional.

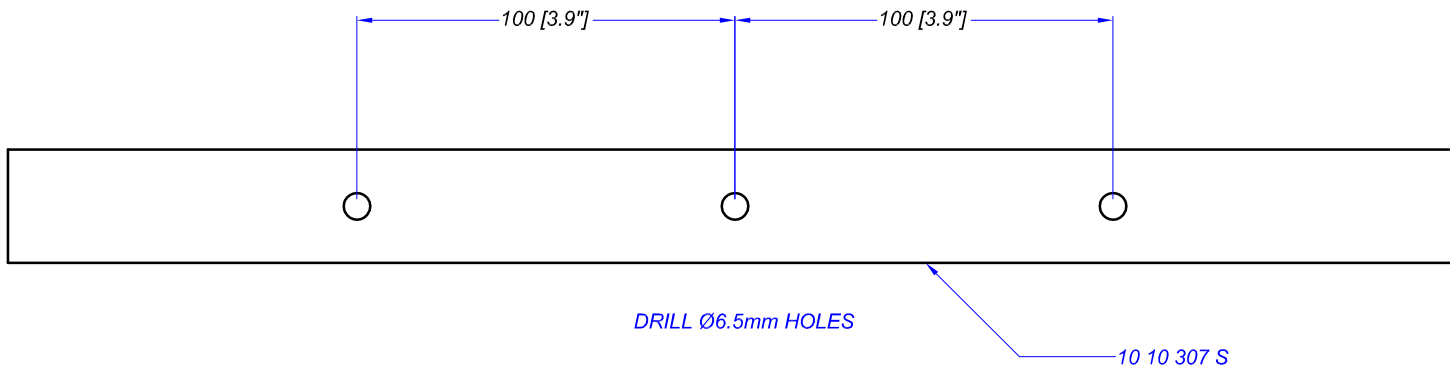
Higher drawing/s:	10 10 302 D	1:10	Caution on table width	27-06-08	B
			First issue	23-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	76 X 38 X 7kg/m CHANNEL		Title CROSS BEARER - CUT		
 www.mechmate.com		Drawing Number	Process	Revision	
		10 10 302	S	B	



Higher drawing/s:	10 10 300 W	1:5		
			First issue	3-09-06 A
			Description of change	Date (d-m-y) Rev.
Material:	30mm OD X 3mm WT PIPE		Title	
			CROSS ANGLE BRACE - CUT	
 www.mechmate.com		Drawing Number		Process Revision
		10 10 304		S A



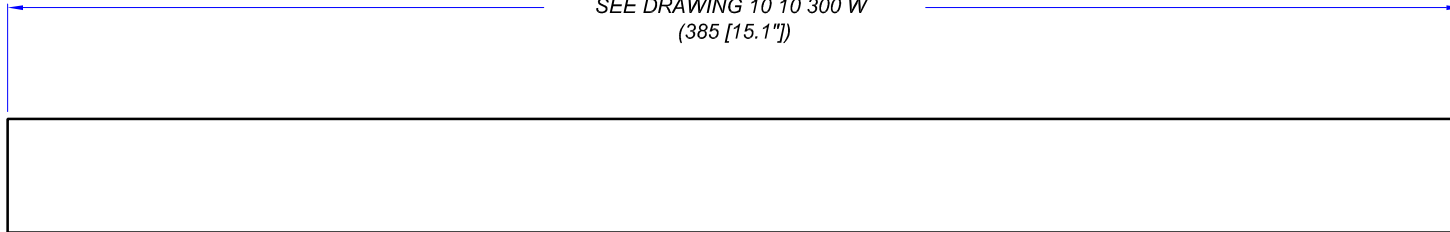
Higher drawing/s:	10 10 300 W	1:10			
			First issue	3-09-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	50mm OD X 4mm WT PIPE		Title		
			LOWER CROSS BRACE - CUT		
 www.mechmate.com			Drawing Number	Process	Revision
			10 10 306	S	A




OPTION

Higher drawing/s:	10 10 300 W	1:2		
			First issue	16-09-06 A
			Description of change	Date (d-m-y) Rev.
Material:	6mm STEEL FLAT BAR		Title	
			UMBILICAL PLATE - DRILLED	
	Drawing Number		Process	Revision
	10 10 307		D	A
	www.mechmate.com			

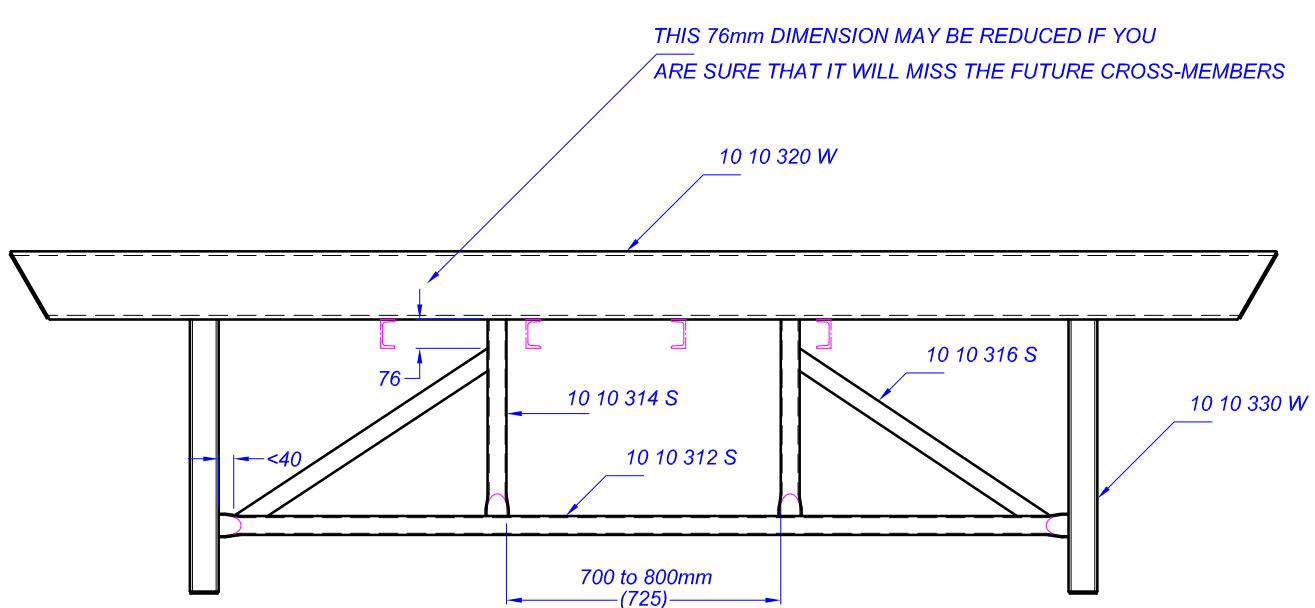
TO SUIT PITCH OF CROSS-BEARERS
 SEE DRAWING 10 10 300 W
 (385 [15.1"])



OPTION

Higher drawing/s:	10 10 307 D	1:2			
			First issue	14-09-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	30 x 6mm FLAT BAR		Title		
			UMBILICAL PLATE - SAWN		
	Drawing Number		Process	Revision	
	10 10 307		S	A	

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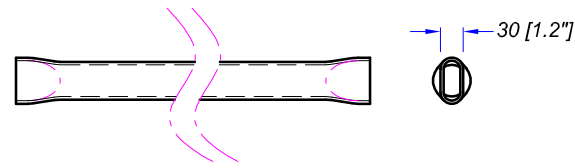
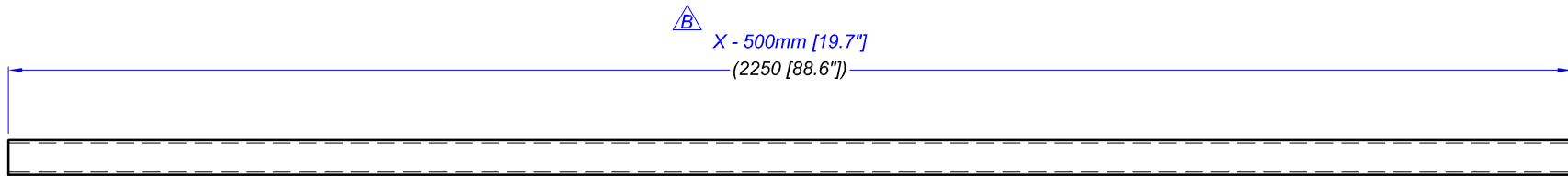
THIS 76mm DIMENSION MAY BE REDUCED IF YOU ARE SURE THAT IT WILL MISS THE FUTURE CROSS-MEMBERS

Miss the cross-bearers that may be off-center (this space needed for free movement of optional umbilical cable to the gantry)

OPTION

Higher drawing/s:	10 10 300 W	1: 20		
			First issue	01-09-06 A
			Description of change	Date (d-m-y) Rev.
Material:	STEEL		Title	
			SIDE FRAME - WELDMENT	
Drawing Number		Process	Revision	
10 10 310		W	A	

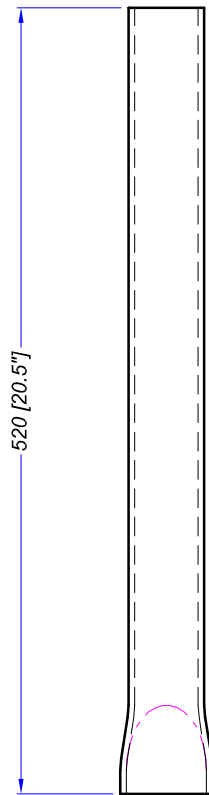
MechMate
www.mechmate.com



FLATTEN ENDS

Higher drawing/s:	10 10 310 W	1:10	Correct error	25-11-06	B
			First issue	23-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	50mm OD X 4mm WT PIPE		Title		
			LOW LONGITUDNAL - CUT		
Drawing Number		Process	Revision		
10 10 312		S	B		

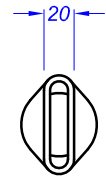
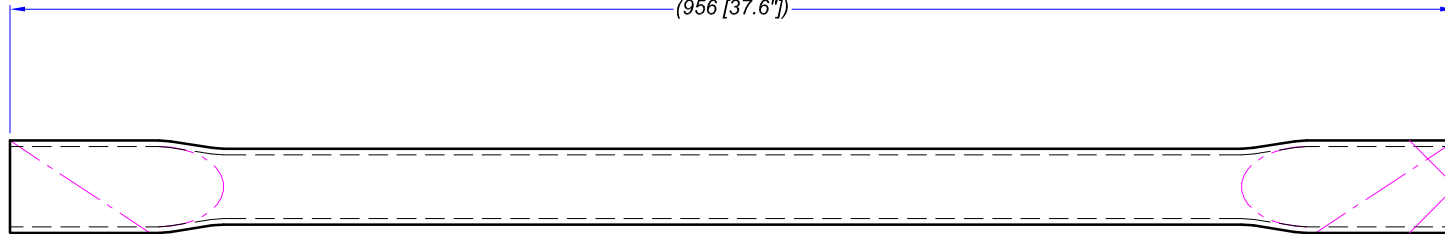
MechMate
www.mechmate.com



Higher drawing/s:	10 10 310 W	1:5		
			First issue	3-09-06 A
			Description of change	Date (d-m-y) Rev.
Material:	50mm OD X 4mm WT PIPE	Title		
 www.mechmate.com		VERTICAL BEARER - CUT		
		Drawing Number	Process	Revision
		10 10 314	S	A

DETERMINE THIS DIMENSION DURING
THE CONSTRUCTION OF THE SIDE FRAME
10 10 310 W

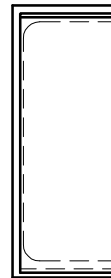
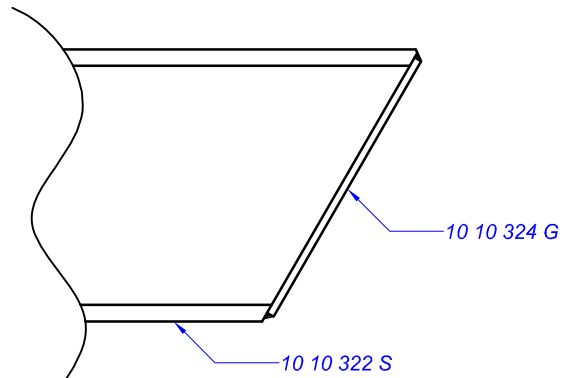
(956 [37.6"])



DETERMINE THE FINAL END SHAPE DURING
THE CONSTRUCTION OF THE SIDE FRAME
10 10 310 W


DETERMINE THE FINAL END SHAPE DURING
THE CONSTRUCTION OF THE SIDE FRAME
10 10 310 W

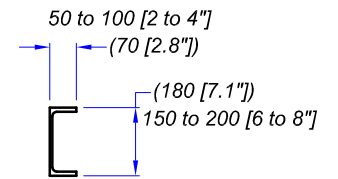
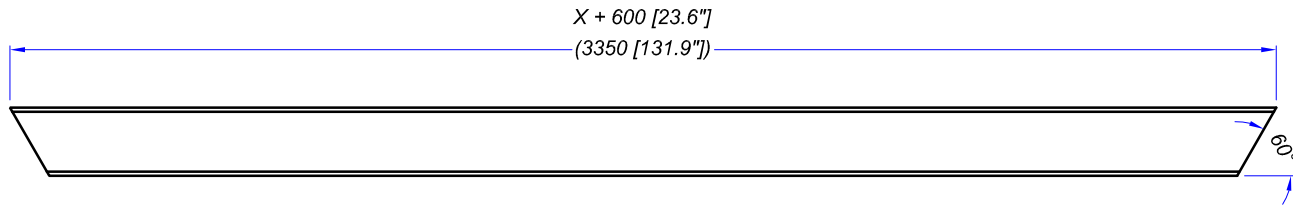
Higher drawing/s:	10 10 310 W	1:5			
			First issue	3-09-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	50mm OD X 4mm WT PIPE	Title			
 www.mechmate.com		LONG. ANGLE BRACE - CUT			
		Drawing Number	10 10 316	Process	Revision
			S	A	



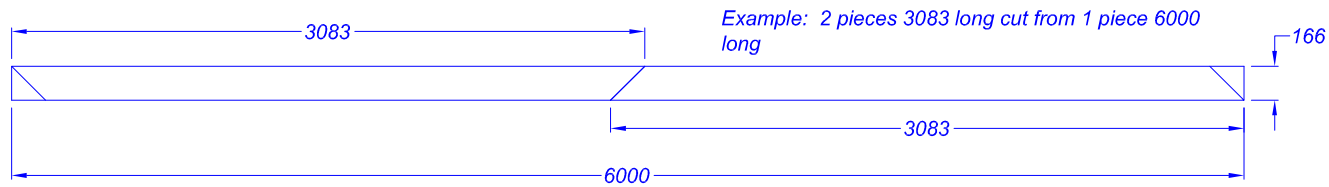
1. This welding is not structural. Only put small welds on the corners of the closing plate.
2. After welding, grind off all sharp edges/corners - you will often walk into these points. They are at groin height!



Higher drawing/s:	10 10 310 W	1: 20		
			First issue	22-07-21 A
			Description of change	Date (d-m-y) Rev.
Material:	CHANNEL IRON 180X70		Title	
			MAIN LONGITUDNAL BEAM ENDS WELDED WITH CLOSING PLATES	
 www.mechmate.com		Drawing Number	Process	Revision
		10 10 320	W	A



The angled ends are intended for aesthetics only,
 but they can help to cut longer beams out of standard lengths.
 (the beams can be up to 100mm shorter than the proposed dimension-
 the bolted-on rails may overhang by 50mm at the end)

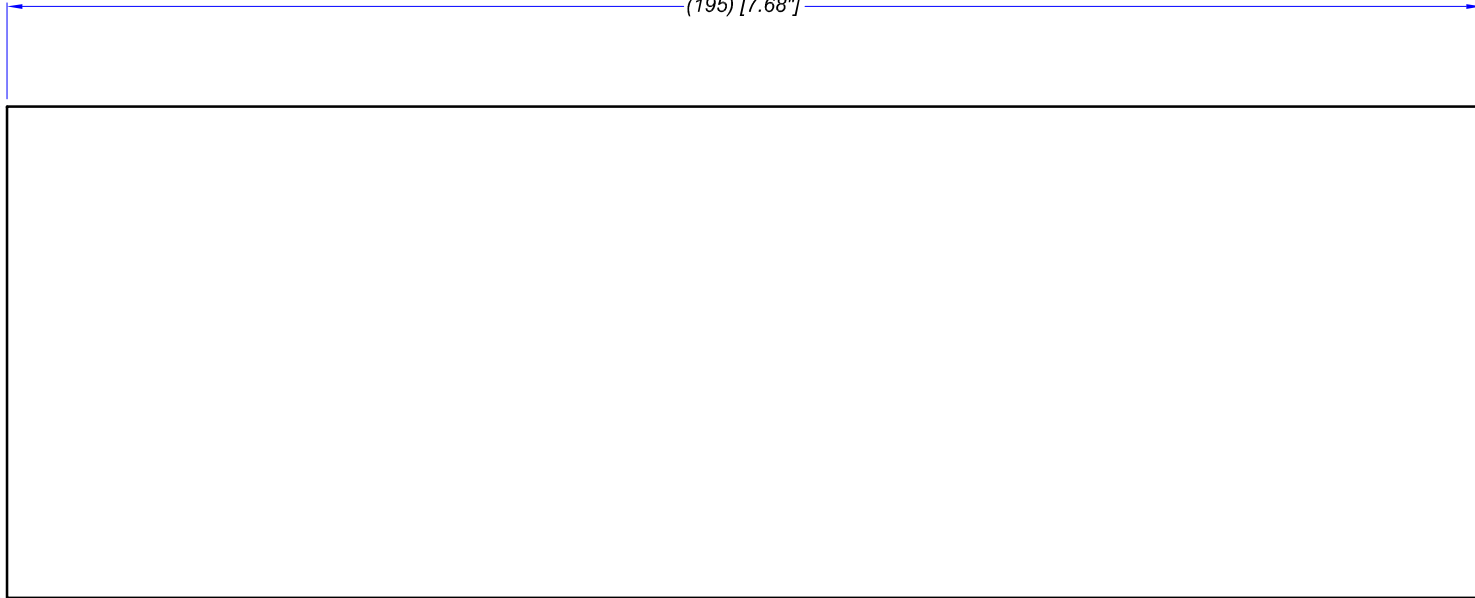




Higher drawing/s:	10 10 320 W	1: 20			
			First issue	22-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	180x70x21kg/m CHANNEL		Title		
 www.mechmate.com			MAIN LONGITUDNAL BEAM - CUT		
			Drawing Number	Process	Revision
			10 10 322	S	A

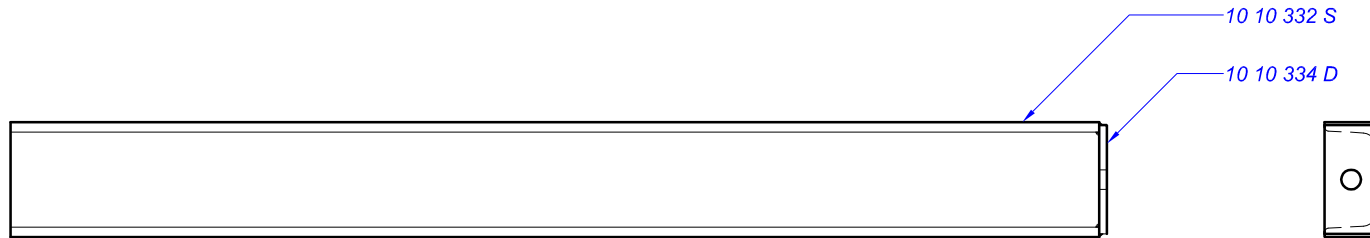
5mm narrower than main beam 10.10.322.S
(65) [2.56"]



To suit angled end of main beam 10.10.322.S

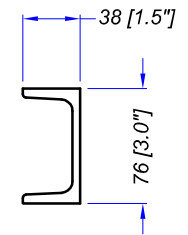
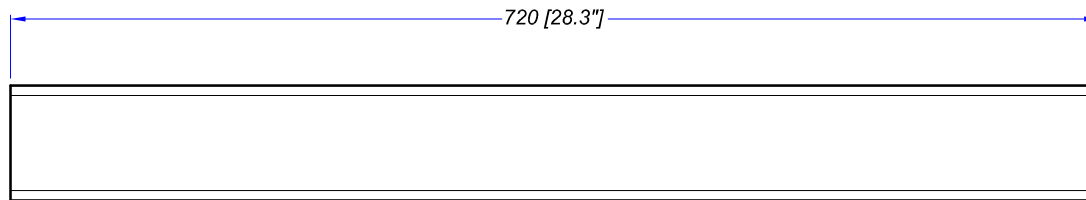
(195) [7.68"]



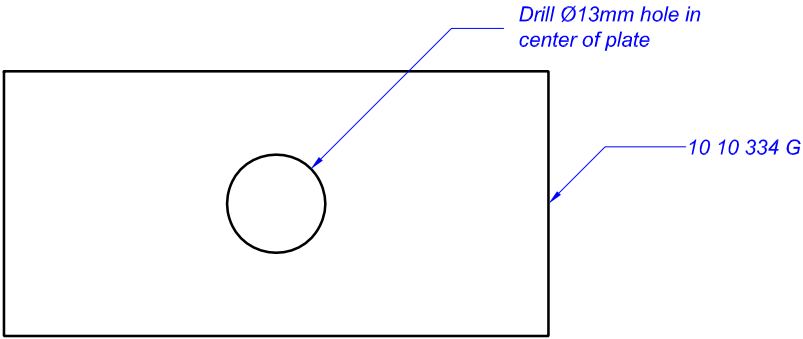
Higher drawing/s:	10 10 320 W	1:1			
			First issue	21-07-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	5mm MILD STEEL PLATE		Title		
			END-CLOSING PLATE		
	 www.mechmate.com		Drawing Number	Process	Revision
			10 10 324	G	A



Higher drawing/s:	10 10 310 W	1:5			
			First issue	24-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	STEEL - WELDED		Title		
			LEG & FOOTPLATE - WELDMENT		
 www.mechmate.com		Drawing Number		Process	Revision
		10 10 330		W	A



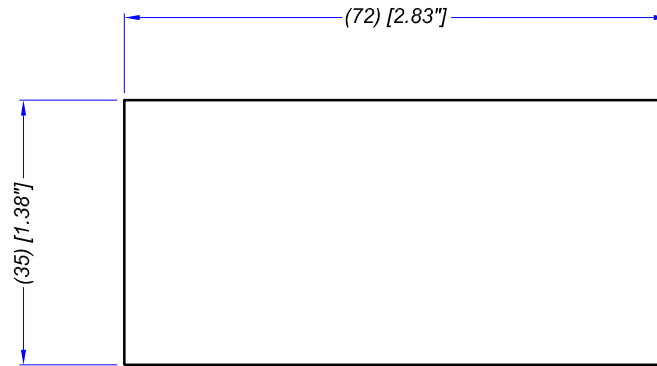
Higher drawing/s:	10 10 330 W	1:5			
			First issue	24-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	76 X 38 X 7kg/m CHANNEL		Title		
			TABLE LEG - CUT		
 www.mechmate.com		Drawing Number		Process	Revision
		10 10 332		S	A





NOTE:

- 1. The hole is for a future levelling foot if necessary.

Higher drawing/s:	10 10 330 W	1:1			
			First issue	21-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	5mm MILD STEEL PLATE		Title		
			FOOT CLOSING PLATE		
 www.mechmate.com		Drawing Number		Process	Revision
		10 10 334		D	A



Higher drawing/s:	10 10 334 D	1:1			
			First issue	21-08-06	A
			Description of change	Date (d-m-y)	Rev.
Material:	5mm MILD STEEL PLATE		Title		
			FOOT CLOSING PLATE		
 www.mechmate.com		Drawing Number		Process	Revision
		10 10 334		G	A