

- WE CHOSE TO GET THE LITTLE MACHINE SHOP MODEL #5500.
- LOOKING AT THE SIEG SX2.7, THEY ARE IDENTICAL IN EVERY WAY.
- THIS KIT WILL FIT EITHER MACHINE.
- YOU WILL HAVE TO MAKE A FEW MODIFICATIONS TO THE TOP OF THE CASTING FOR THE Z AXIS.

First, take off all of the handles



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Remove all of the plates



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With the plates removed, slide the table off. You may need a rubber mallet for some help.



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Remove the cap screws from the lead nut, and the lead screw comes off



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Remove the cap screws in the saddle.
They hold the Y axis lead nut on.



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The easiest way to remove the Y lead screw is from underneath the machine



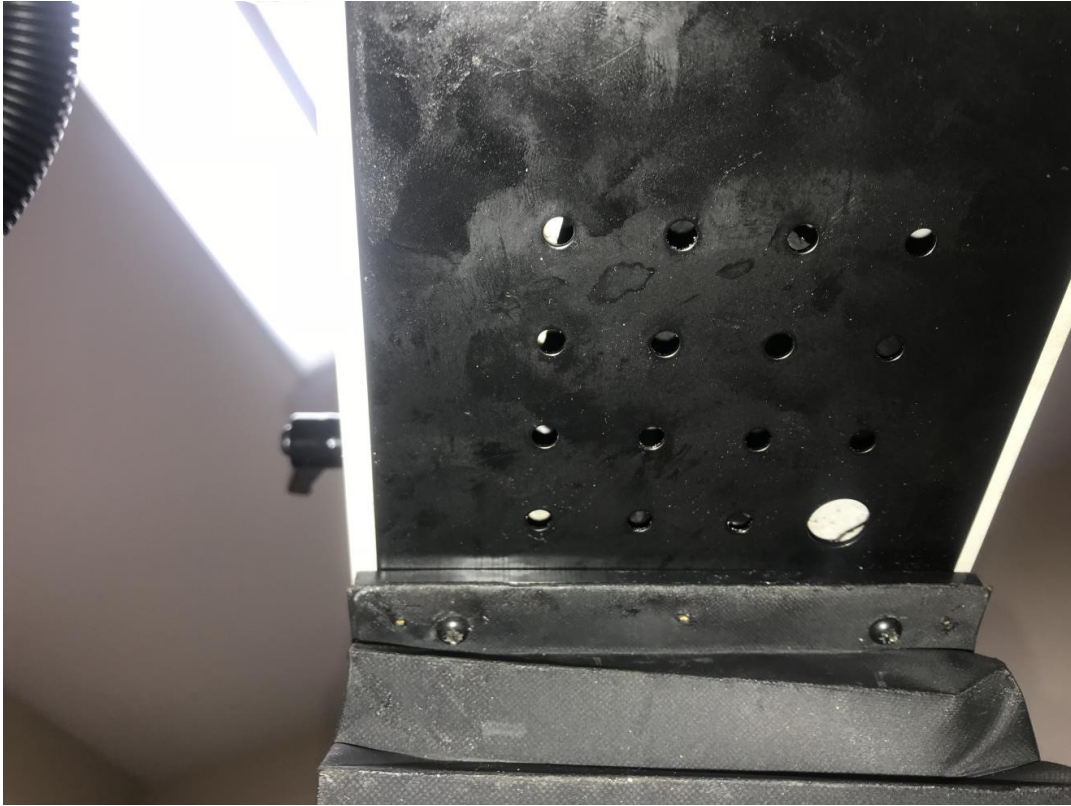
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Remove the sheet metal cover from the back of machine



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Remove the metal plate from underneath the machine head



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- Just make sure you have locked the head in place. Bring it all the way to the top.

It will expose these two bolts that hold the Z lead nut. Remove them.



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Remove the pins and cap screws from the bearing block



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Now remove the bearing block of the Z axis. You can now remove the Z screw.



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Now that we've torn it all apart, let's see if we can put it back together.

We will start with the Y axis



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These two covers need to go back on the machine.



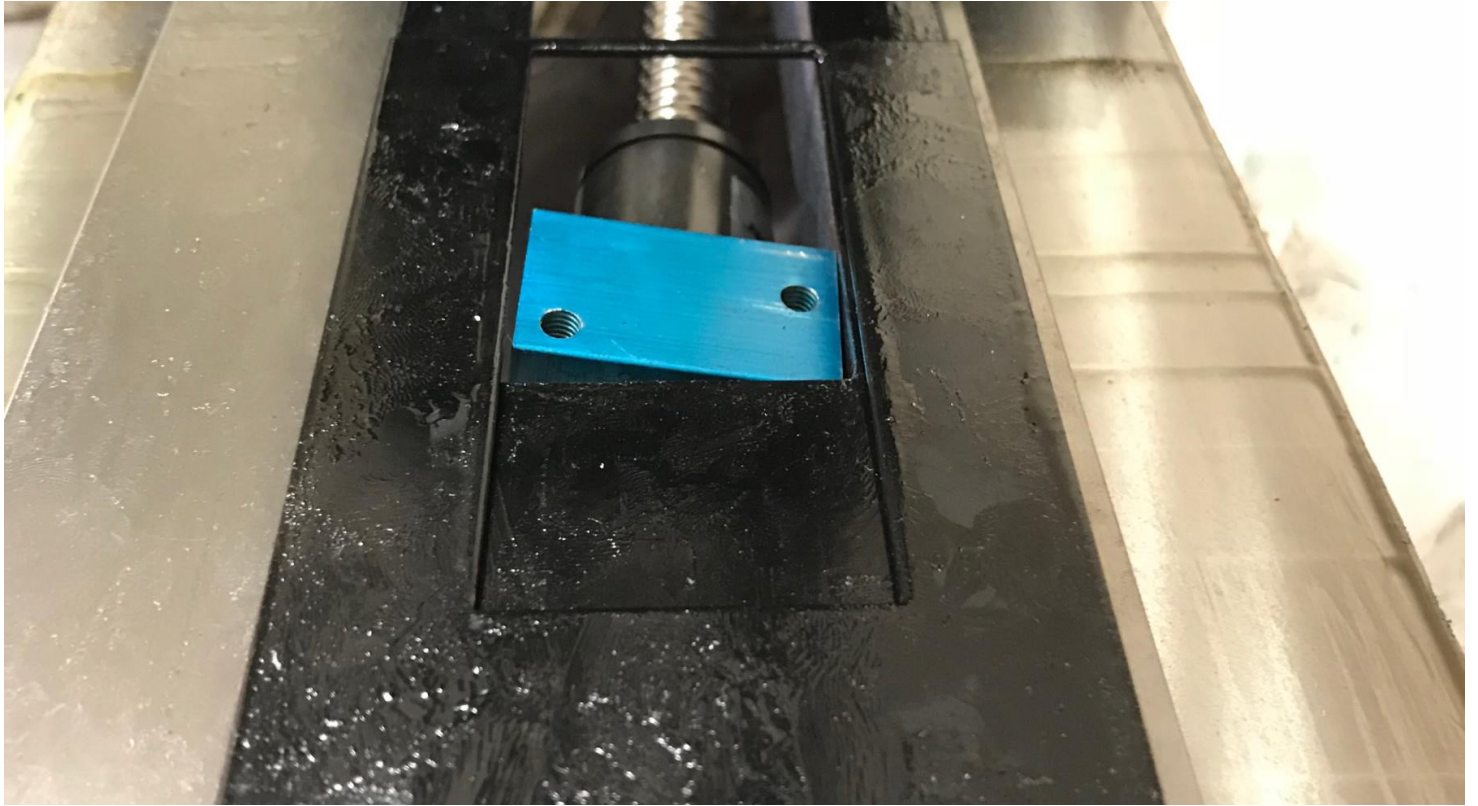
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You'll need to bring the Y ball screw assembly from underneath.



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The Y ball nut block will be in this position when bolted on.



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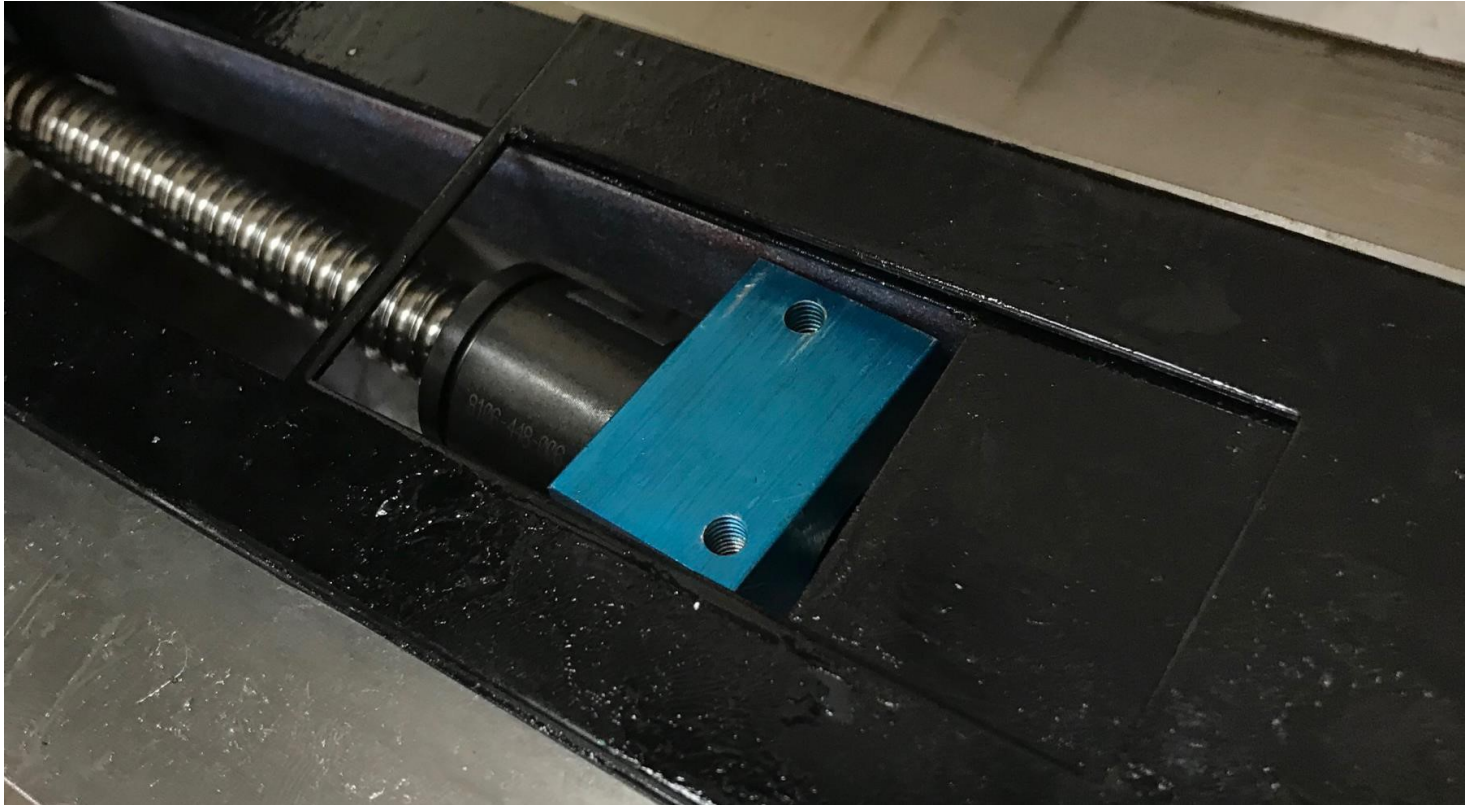
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There are two covers. The long one will be in back and the short one in front



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The block needs to be inside the window of the front plate



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The best way to put these covers back on is to slide them underneath the saddle from the front.



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They will want to get hung up on the machined flat where the y block bolts down. Slide the saddle on just a little.



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Then you can slide the covers underneath the saddle. This is a bit tricky, so be patient. Bolt in place.

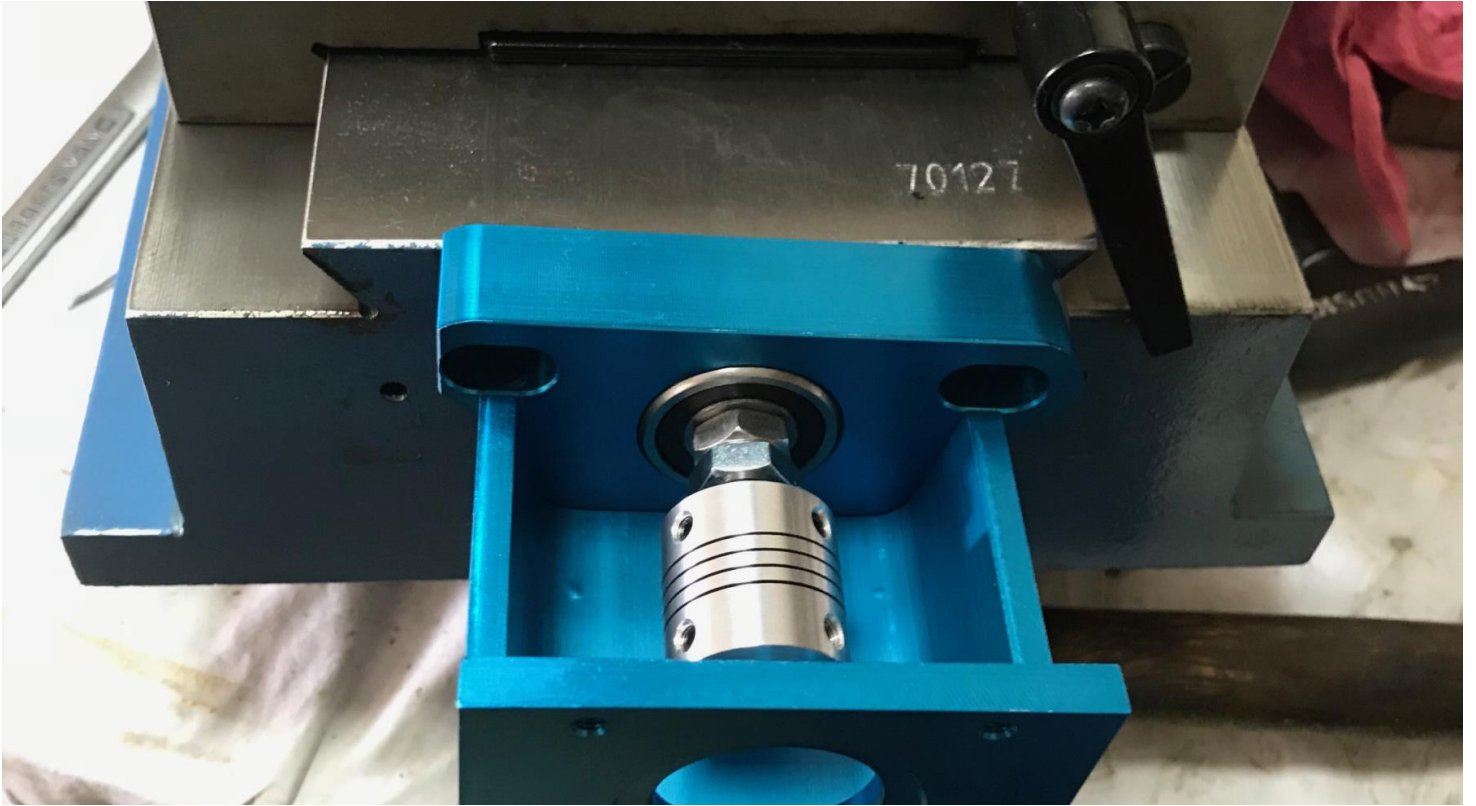


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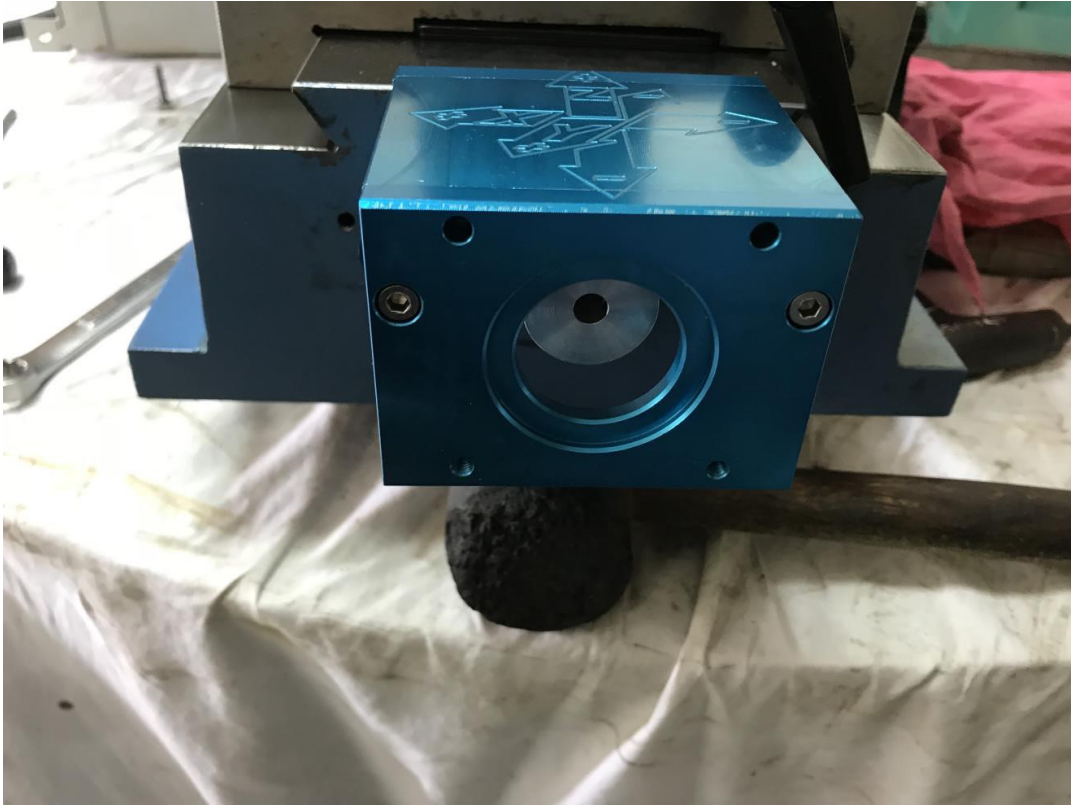


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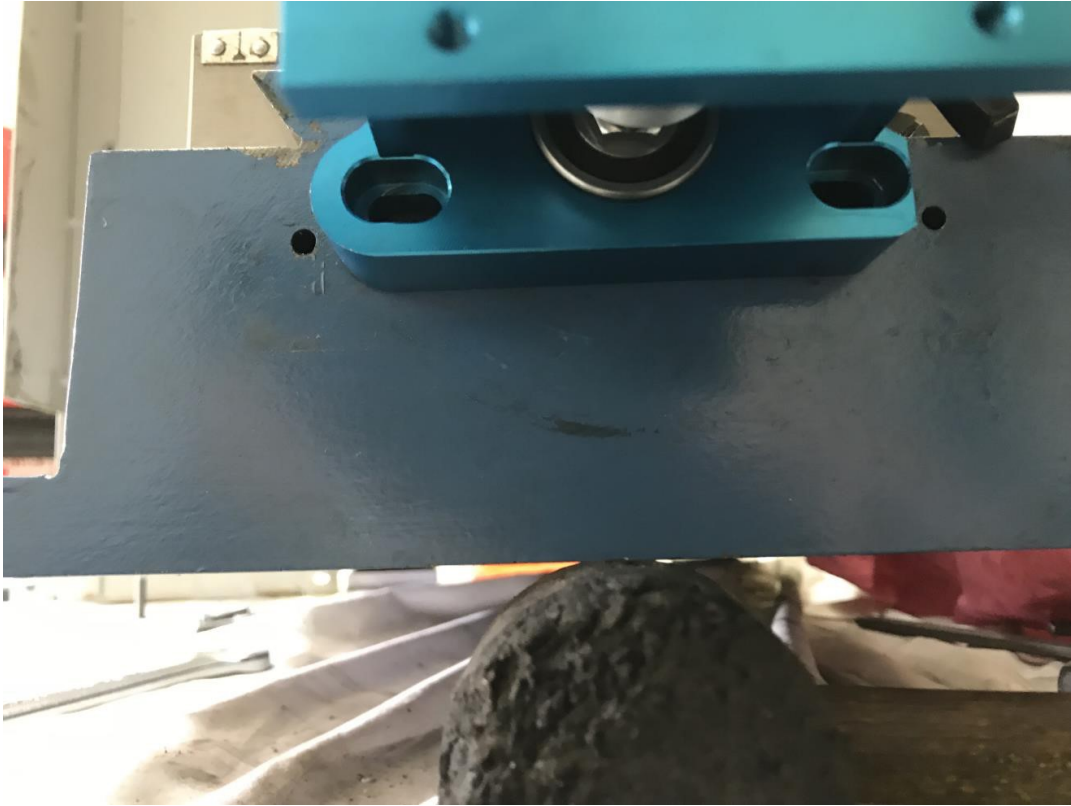
Now you can attach the Y motor
mount assembly



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Bolt down the X ball nut block



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Slide the table back on and install the bearing block on the right side of the table



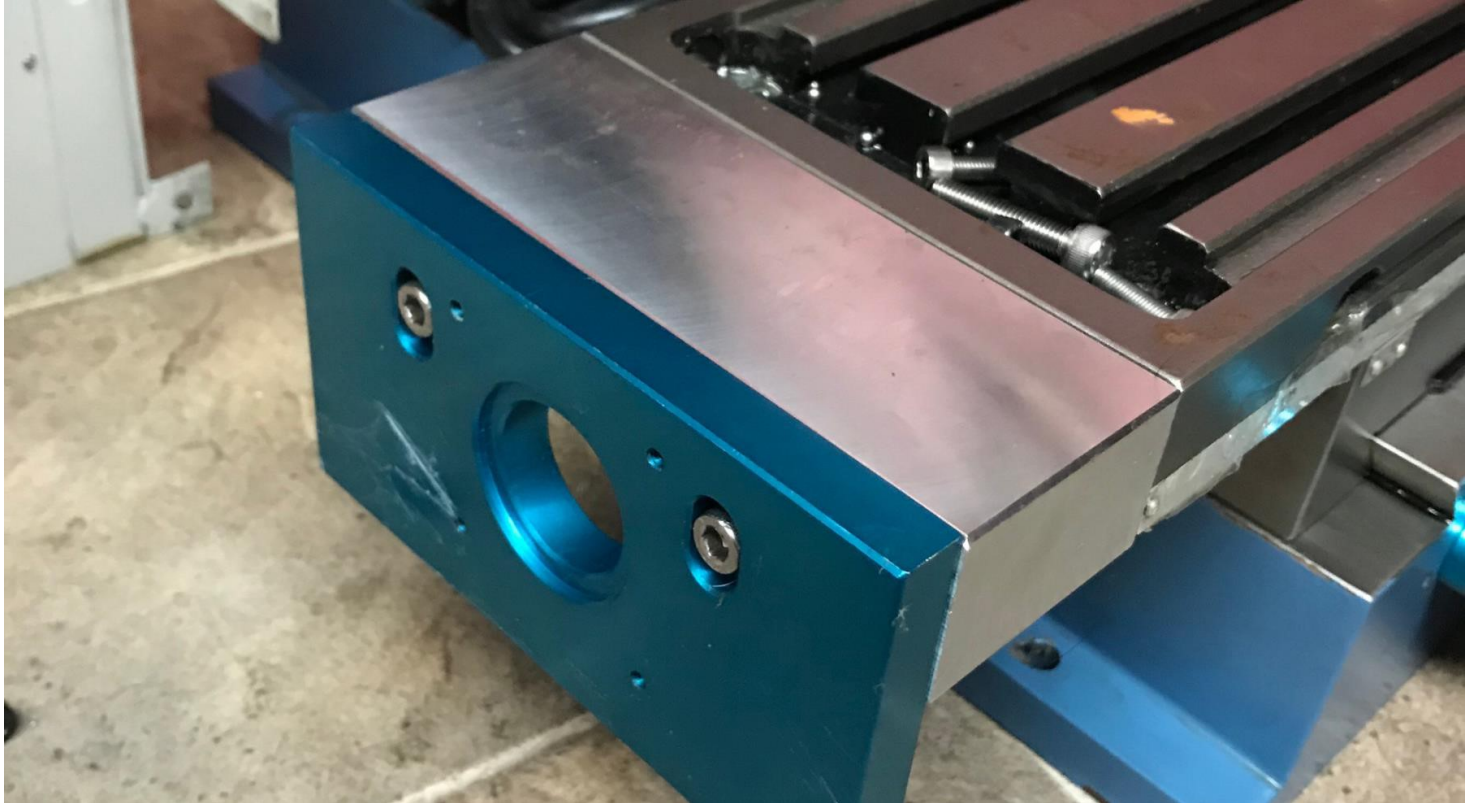
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The motor mount goes on the left side
of the table



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There is an extension with the X axis motor mount. Use the long bolts that came with the kit to attach both



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This will keep from losing any travel in
the X axis

Now you'll need to do some work on
the top of the casting



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A spacer goes with the bearing block for the Z axis



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Bolt that on.



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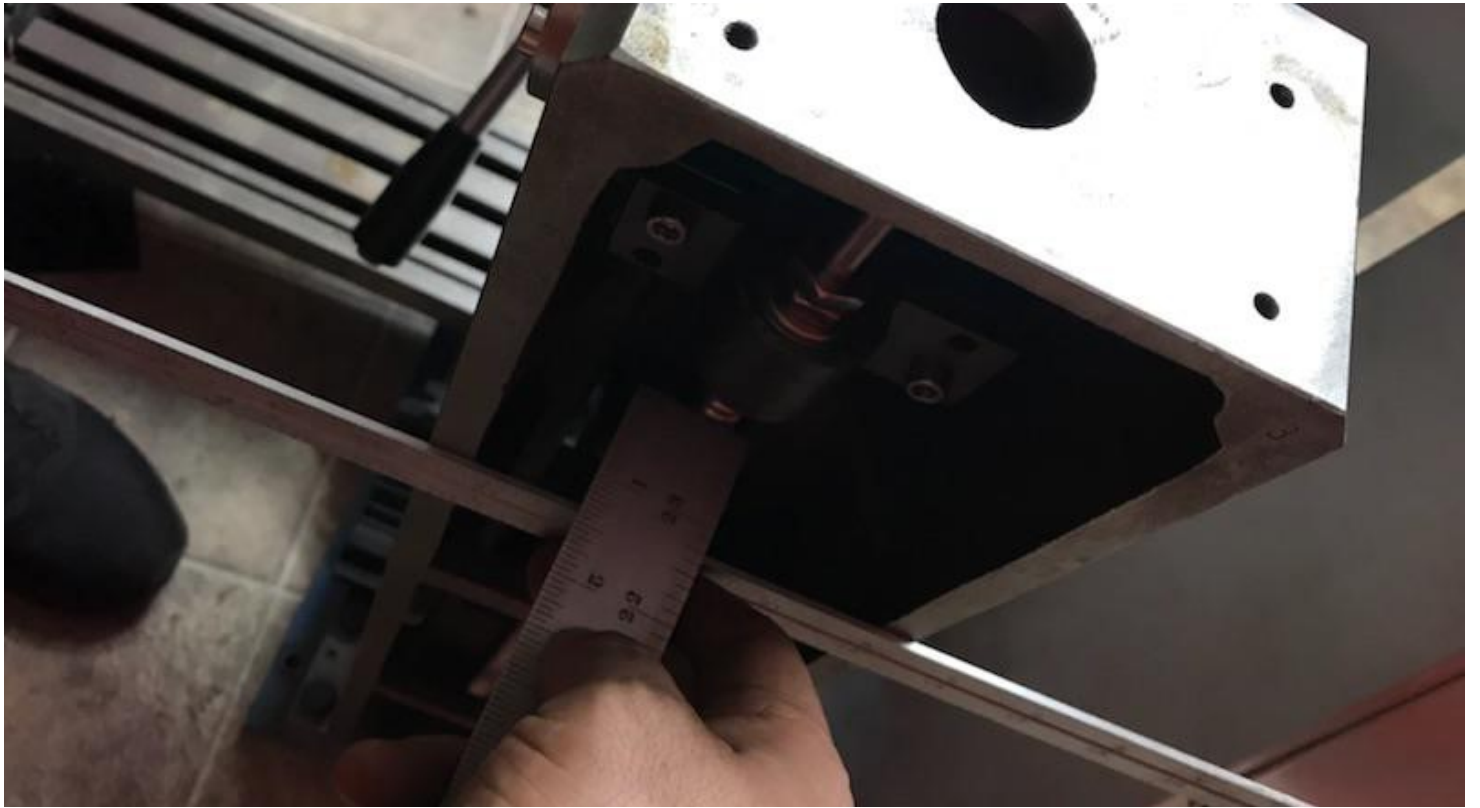
Put the ball screw in and use the two nuts to tighten it just a bit



Now you can take a measurement from the back of the machine to the ball screw. Add $\frac{1}{2}$ of the diameter of the ball screw to that measurement and transfer to the top of the casting. This is where you will drill the hole for the motor shaft.



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Drill a hole for the motor shaft. You will want it to be 1-1/4" in diameter. A standard hole saw from the big box hardware store will do the trick. The cast iron is very soft. A hole saw made for wood will work just fine.

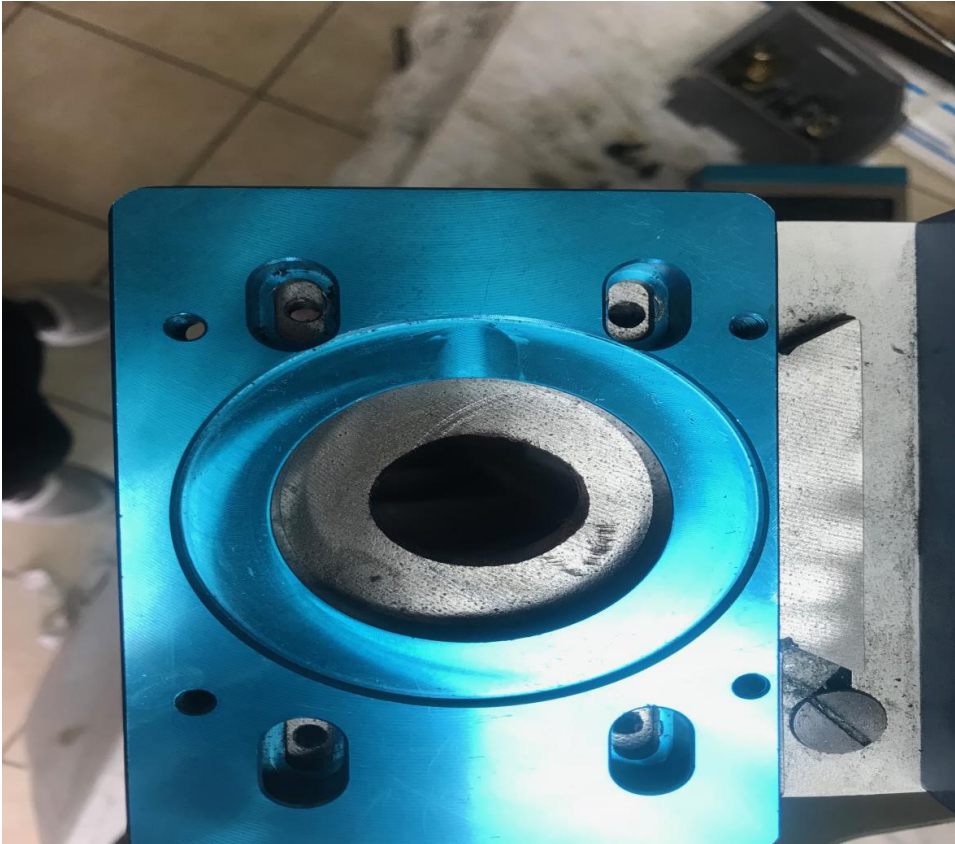


Put the Z axis mount on top, and attach the motor to the ball screw with the coupling.



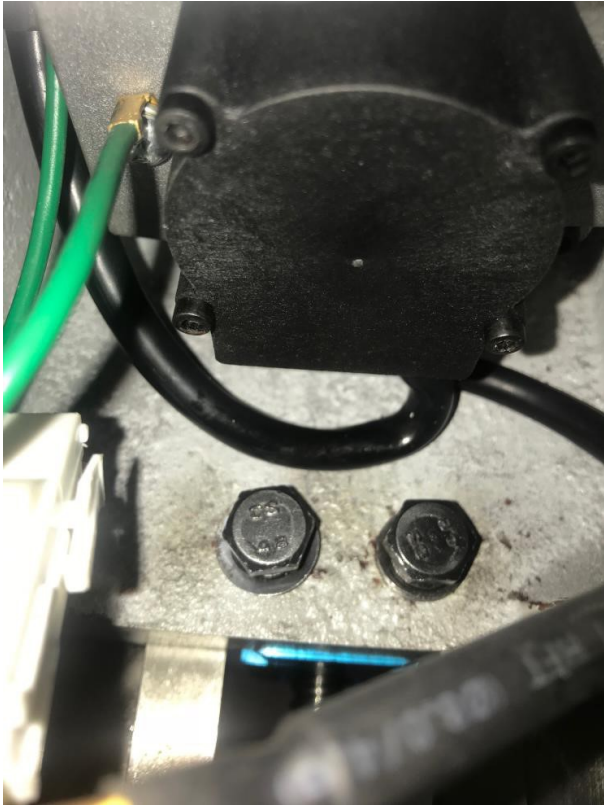
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Mark the four mounting holes and drill
and tap 4 holes to 5mm

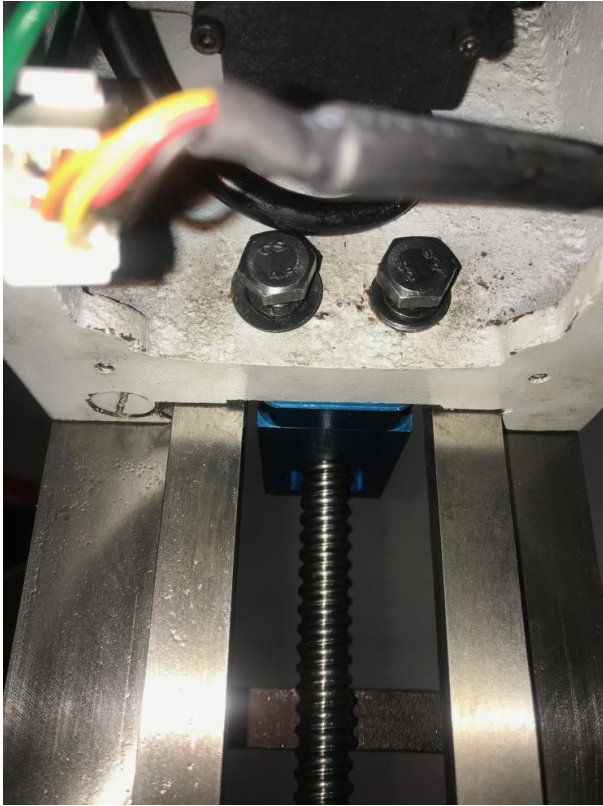


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Use the existing bolts to bolt the Z ball nut block in place.



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You will also need to make holes in the sheet metal for the Z Motor Mount



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When you put the Z motor mount on,
you can make any adjustments
through the hole where the other
handle was.



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Attach the coupling to the motor. Then drop the motor in. You can tighten down the coupling from this side hole



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Put the cap on to cover the hole where the Z axis handle was.



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Re attach the way covers



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Now you are in business!



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You can work on the electronics



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