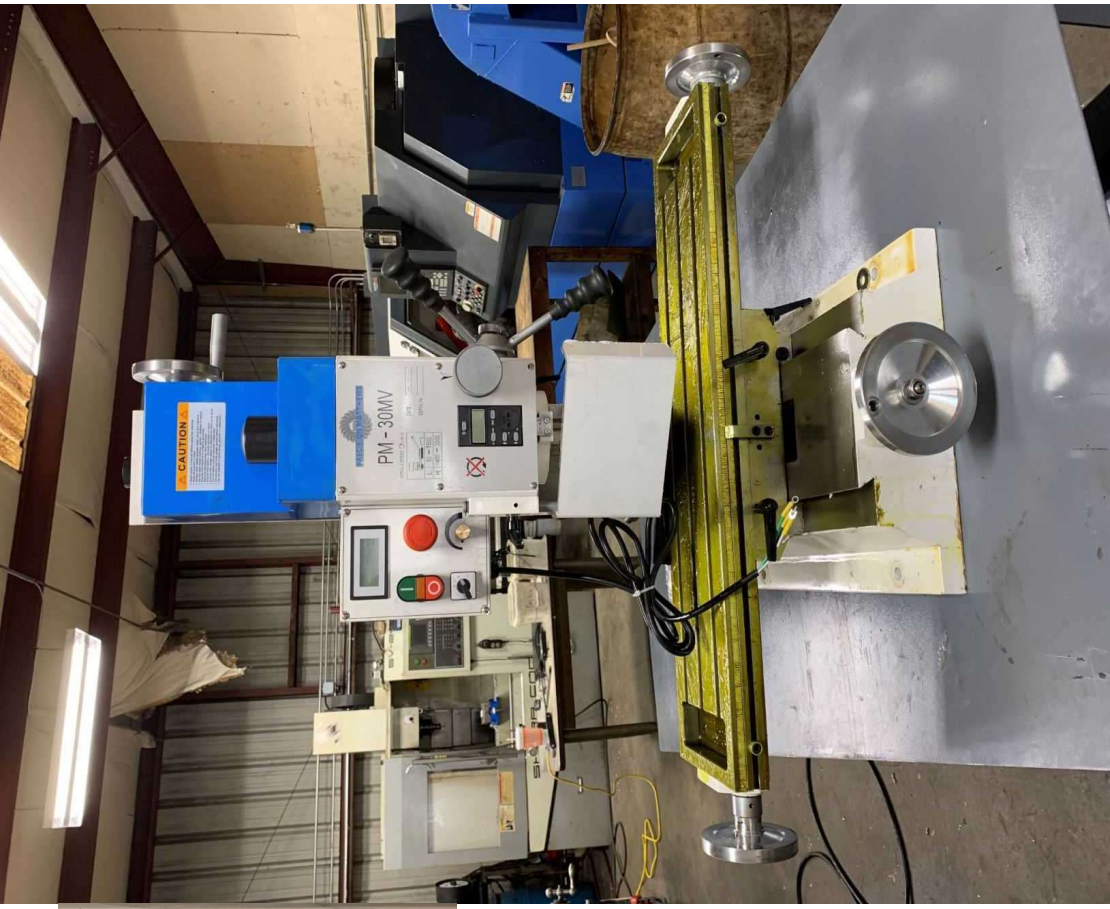


CE

BREESON MATHREYS

MODEL No.	PM-30WV	POWER	15KW
Serial No.	000915	VOLTAGE	230V
DATE	02.2019	FREQUENCY	60Hz
NET WEIGHT	20kg	AMPERE	60A



THESE ARE THE TOOLS YOU WILL NEED



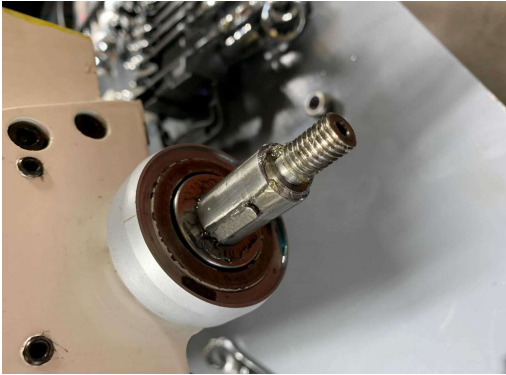
START WITH X. YOU NEED TO REMOVE THE TABLE.
TAKE THE HANDLES OFF EACH END OF THE TABLE.



THE EASIEST WAY TO GET THE PLATE OFF IS TO TIGHTEN DOWN THE BLACK HANDLE GIB SCREWS. GRAB THE HANDLE ON THE OTHER SIDE OF THE TABLE AND CRANK IT. IT WILL PUSH THE PLATE OFF THE TABLE. IT HAS PINS THAT ARE PRESSED IN



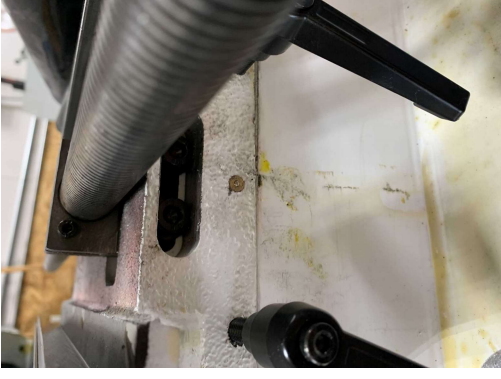
NOW DO THE SAME ON THE OTHER END OF THE TABLE.



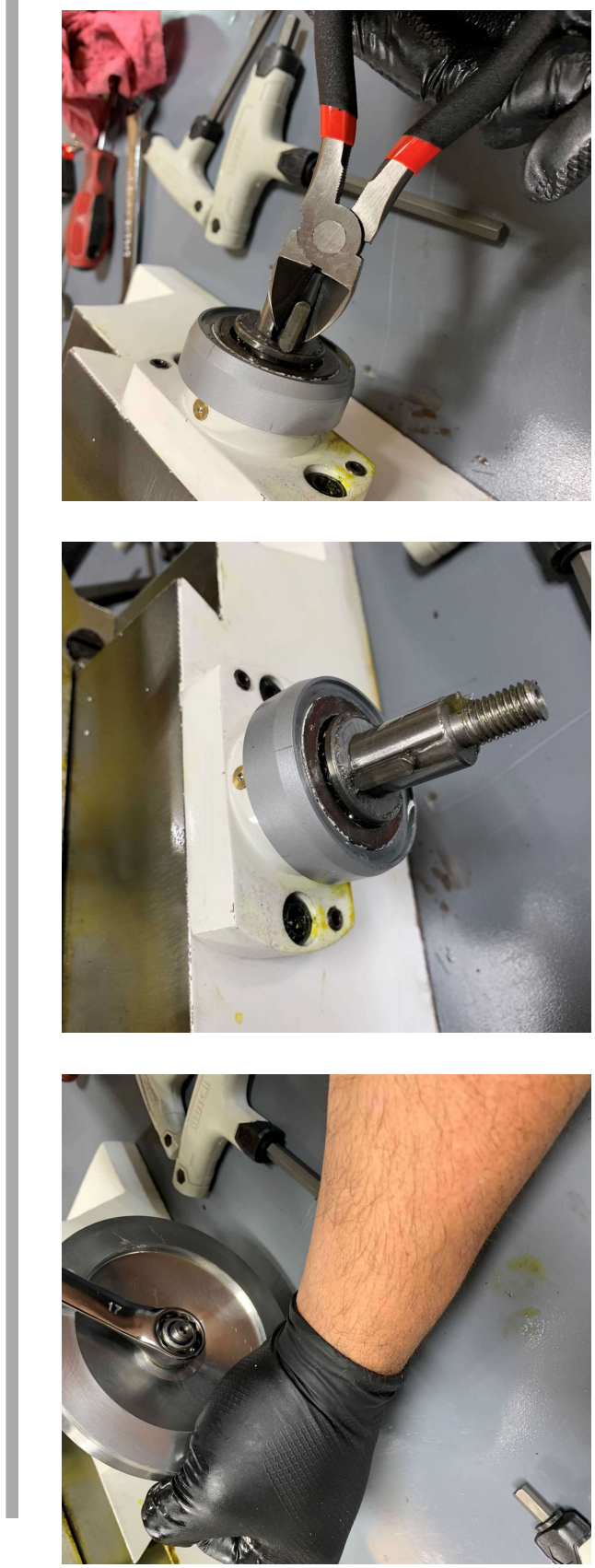
TAKE THE TABLE STOP OFF AND GRAB THE END OF
THE TABLE AND SLIDE IT OFF.



TAKE OFF THE LEAD SCREW AND NUT. THERE ARE TWO
CAP SCREWS BOLTED ON TO THE NUT. REMOVE THEM



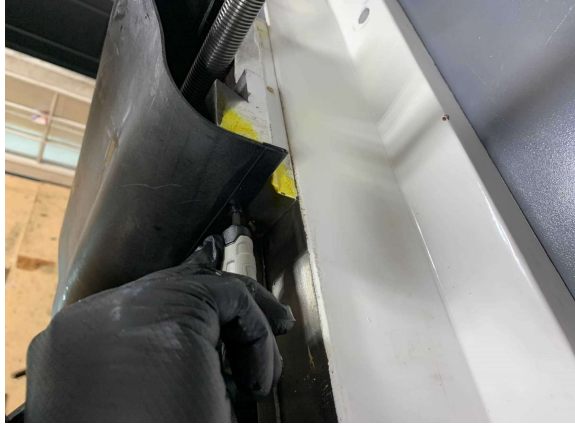
NOW MOVE TO Y. YOU NEED TO REMOVE THE
LEAD SCREW AND NUT. REMOVE THE HANDLE



REMOVE THE BOLTS FROM THE PLATE AND DO THE SAME THING YOU DID WITH X. TIGHTEN DOWN THE GIB SCREWS AND TURN THE LEAD SCREW TO PUSH THE PLATE OFF THE BASE



REMOVE THE WAY COVERS.



THERE ARE TWO CAP SCREWS HOLDING THE Y LEAD
NUT IN PLACE. REMOVE THEM



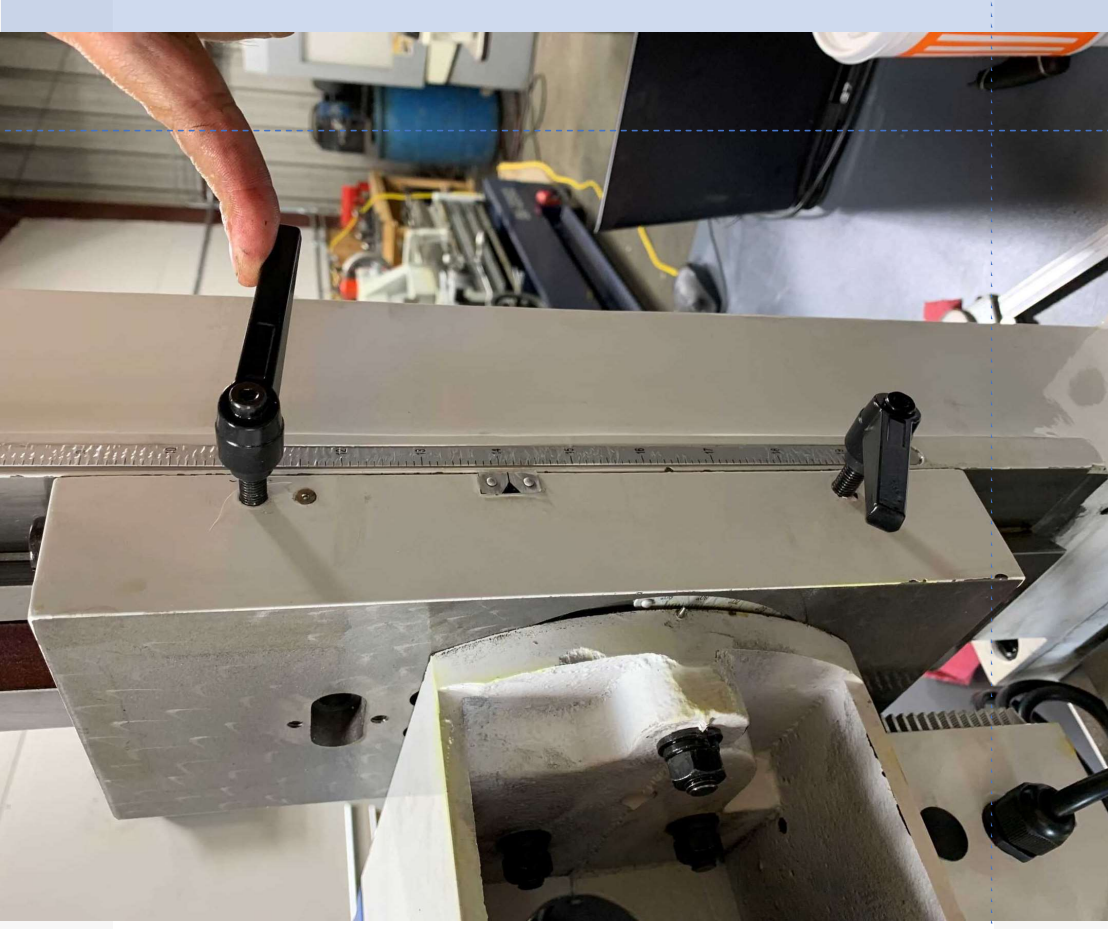
SLIDE THE SADDLE OFF THE BASE



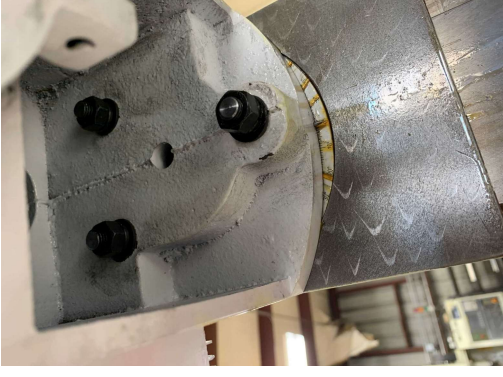
TILT THE MACHINE UP AND REMOVE THE Y LEAD
SCREW AND NUT.



BE SURE TO TIGHTEN DOWN
THE GIBS WITH THE LOCKING
LEVERS TO KEEP THE HEAD
FROM DROPPING WHEN
REMOVING THE LEAD SCREW



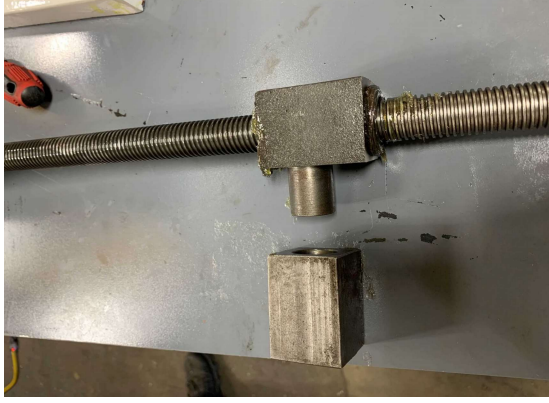
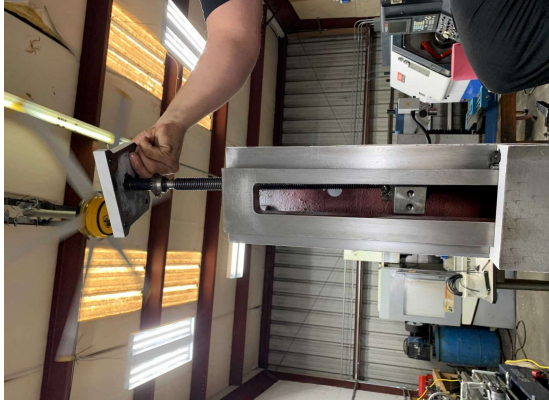
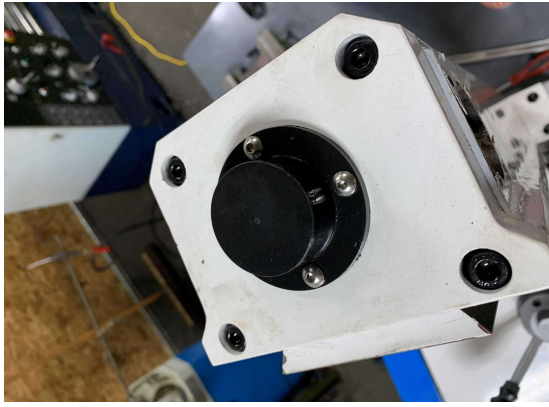
MOVING TO Z AXIS. TILT THE HEAD 90 DEGREES TO EXPOSE THE CAP SCREWS ATTACHING THE LEAD SCREW TO THE HEAD. GO AHEAD AND REMOVE THEM.



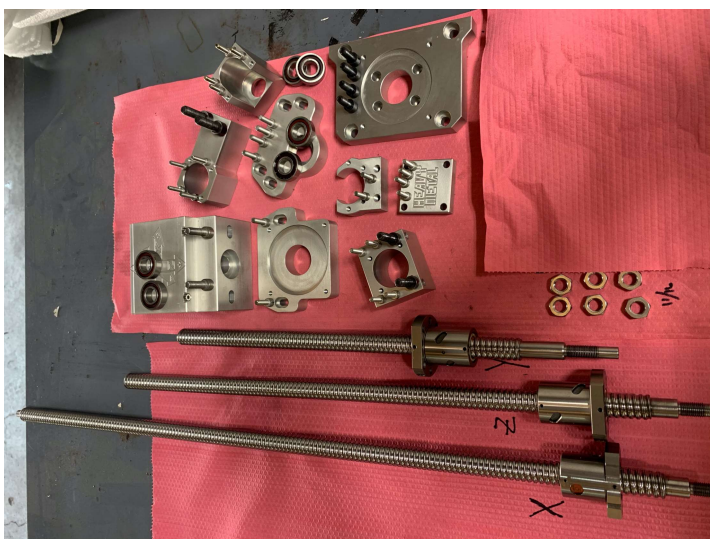
REMOVE THE Z HANDLE. REMOVE THE 4 CAP SCREWS AND PRY OFF THE PLATE WITH A SCREWDRIVER.



REMOVE THE CAP ON TOP OF THE COLUMN. THE LEAD SCREW NUT IS TWO PIECES. TAKE IT APART AND REMOVE THE RECTANGULAR BLOCK BEFORE TRYING TO PULL IT UP AND OUT OF THE COLUMN

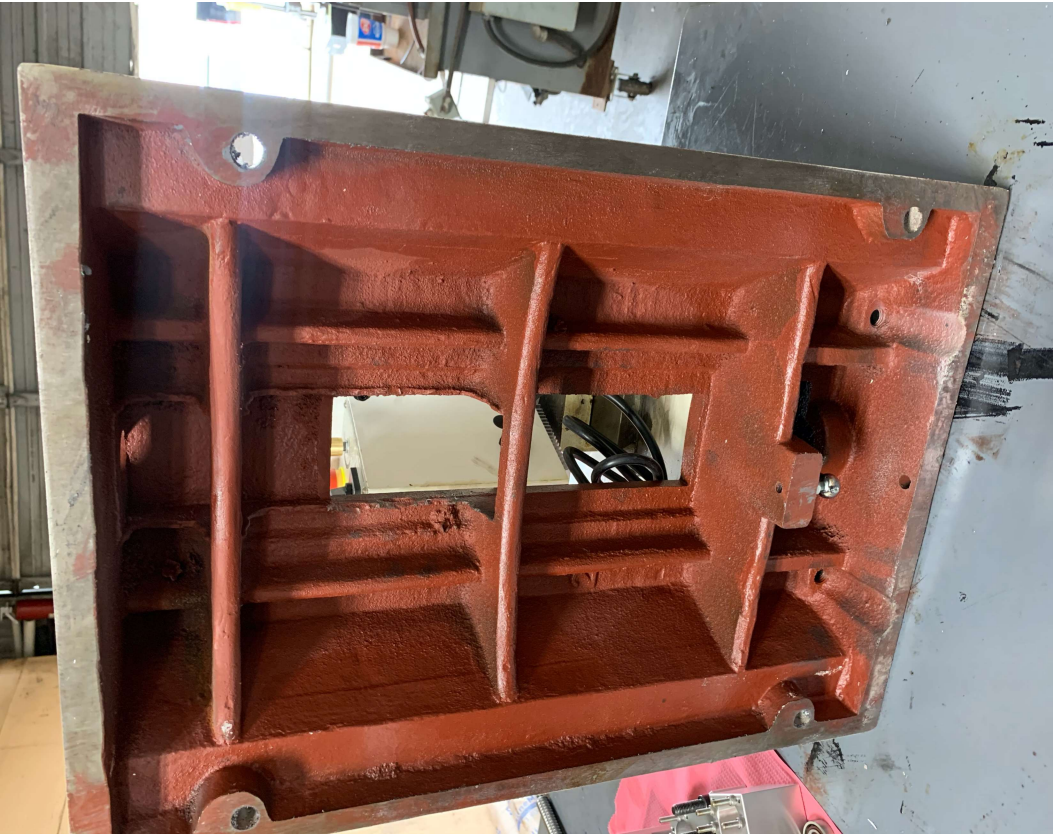


THE KIT

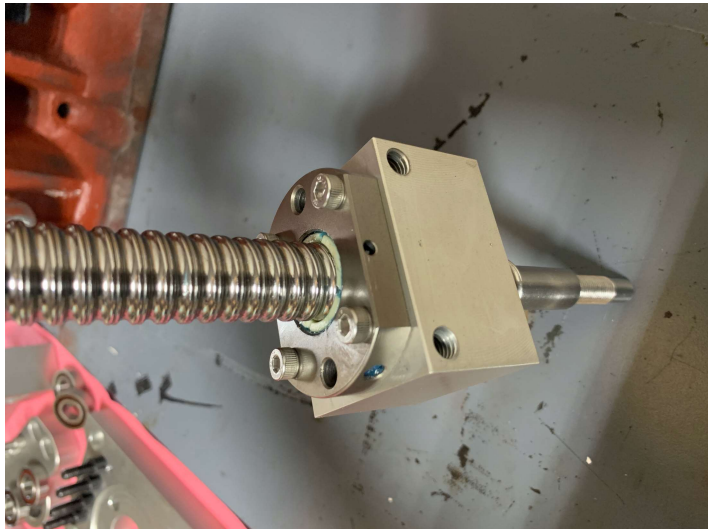


START WITH Y AXIS. LAY THE MACHINE BACK
ON THE COLUMN





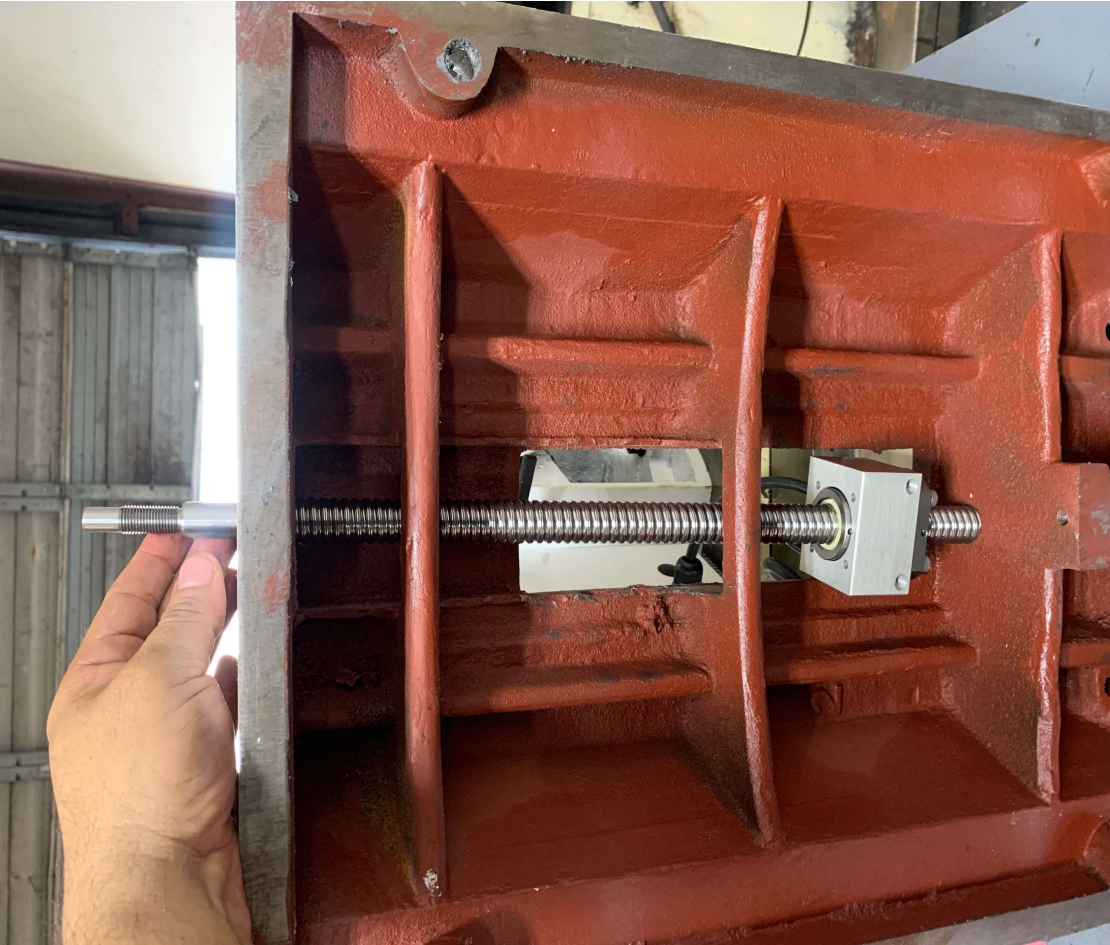
THE Y BALL NUT BLOCK ASSEMBLED



THE BALL NUT ASSEMBLY HAS TO BE TOWARDS THE END OF THE BALL SCREW. SLIDE THE BALL SCREW UP AND THROUGH THE ORIGINAL HOLE THE LEAD SCREW CAME OUT OF.

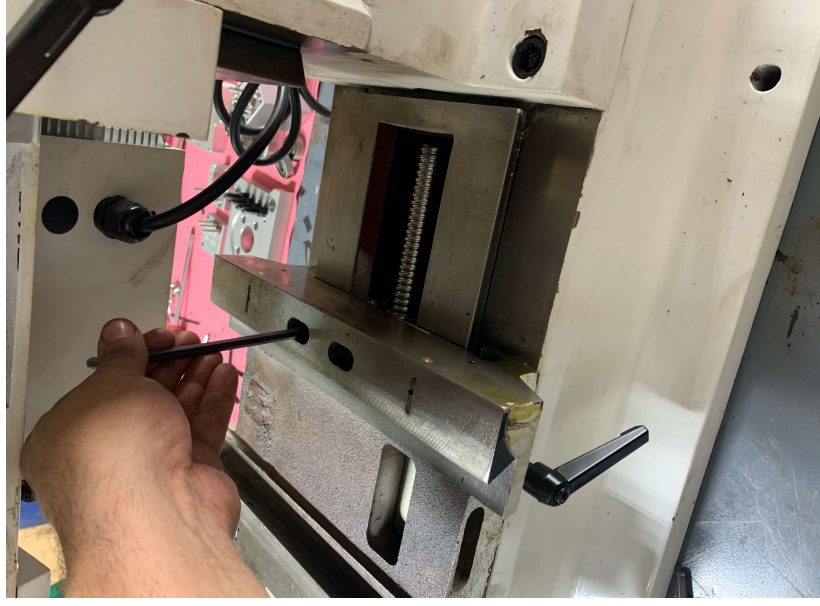
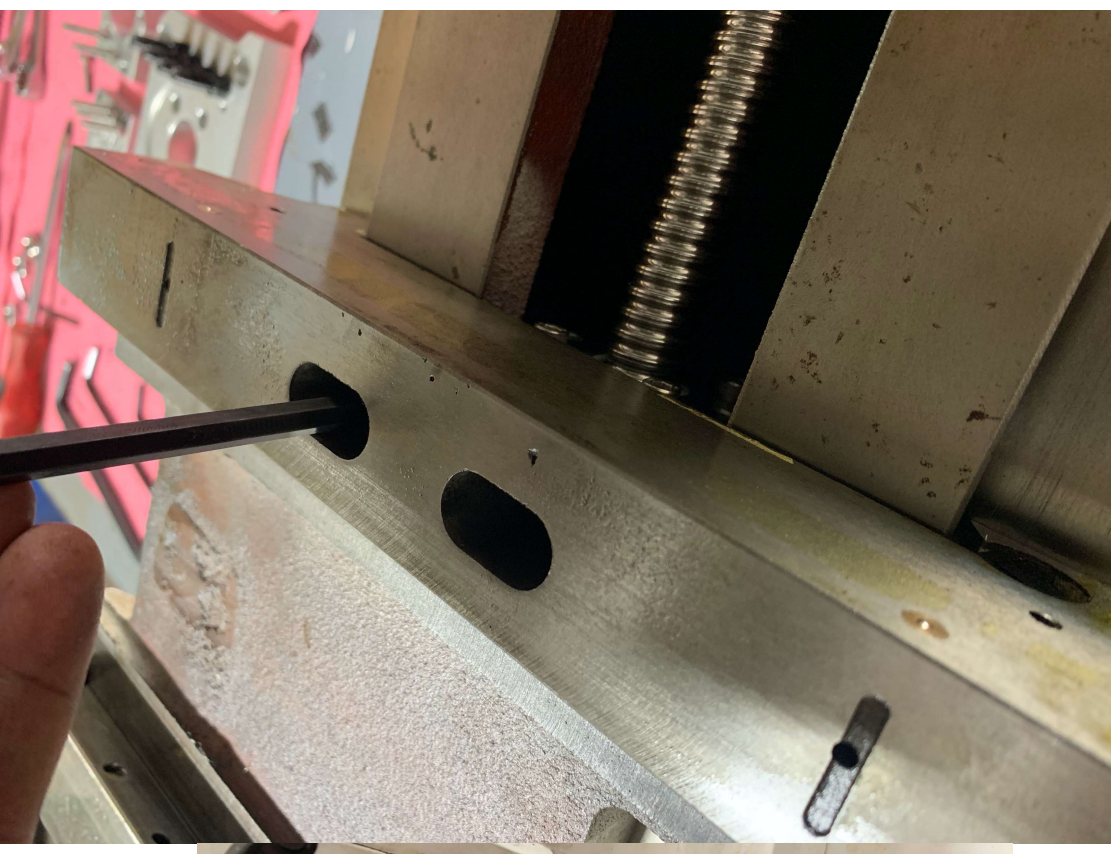


NOW YOU CAN MOVE
IT ABOVE THE CROSS
BRACE AND SLIDE IT
DOWN AND IN.





SLIDE THE
SADDLE
ON. USE
THE CAP
SCREWS
THAT
CAME
WITH THE
MACHINE
TO ATTACH
IT. LEAVE
IT LOOSE
FOR NOW





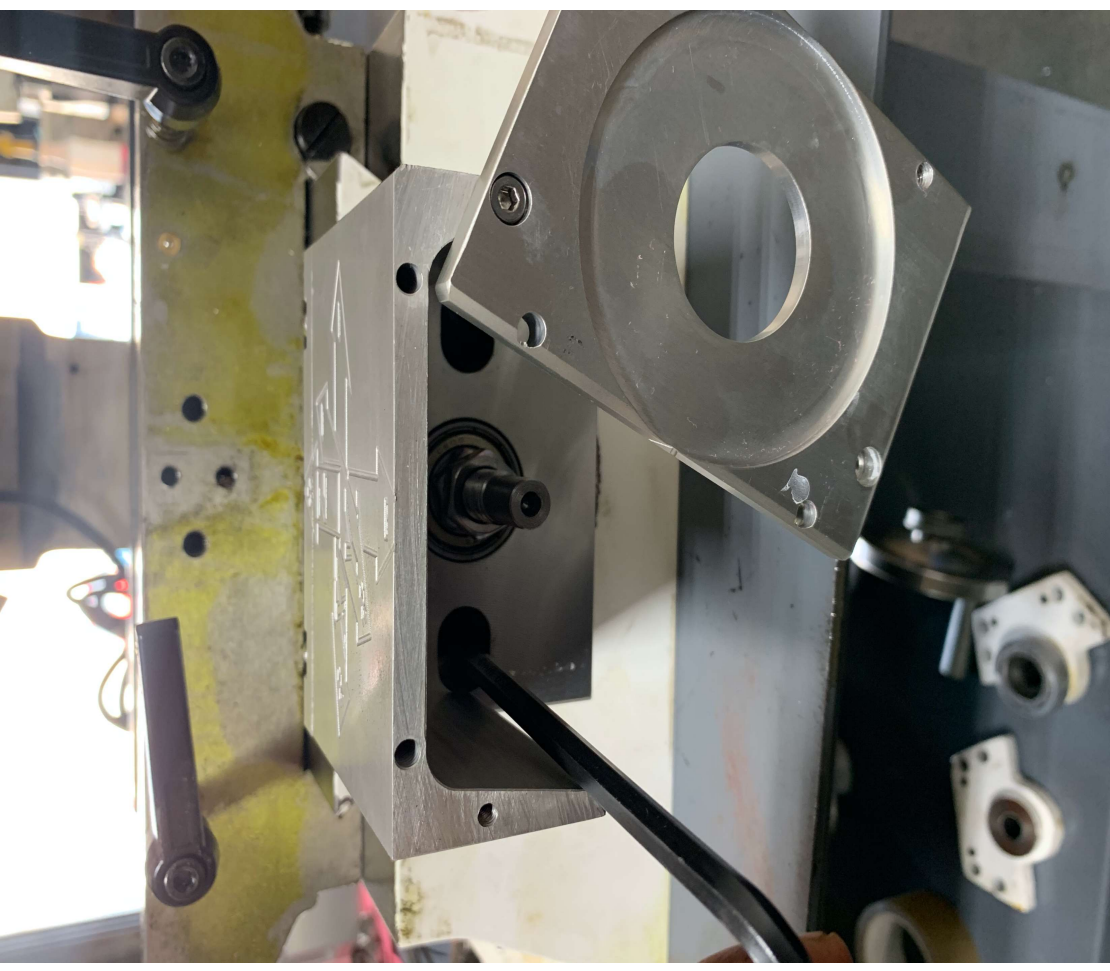
SLIDE
THE GIB
BACK IN
AND
TIGHTEN
IT UP

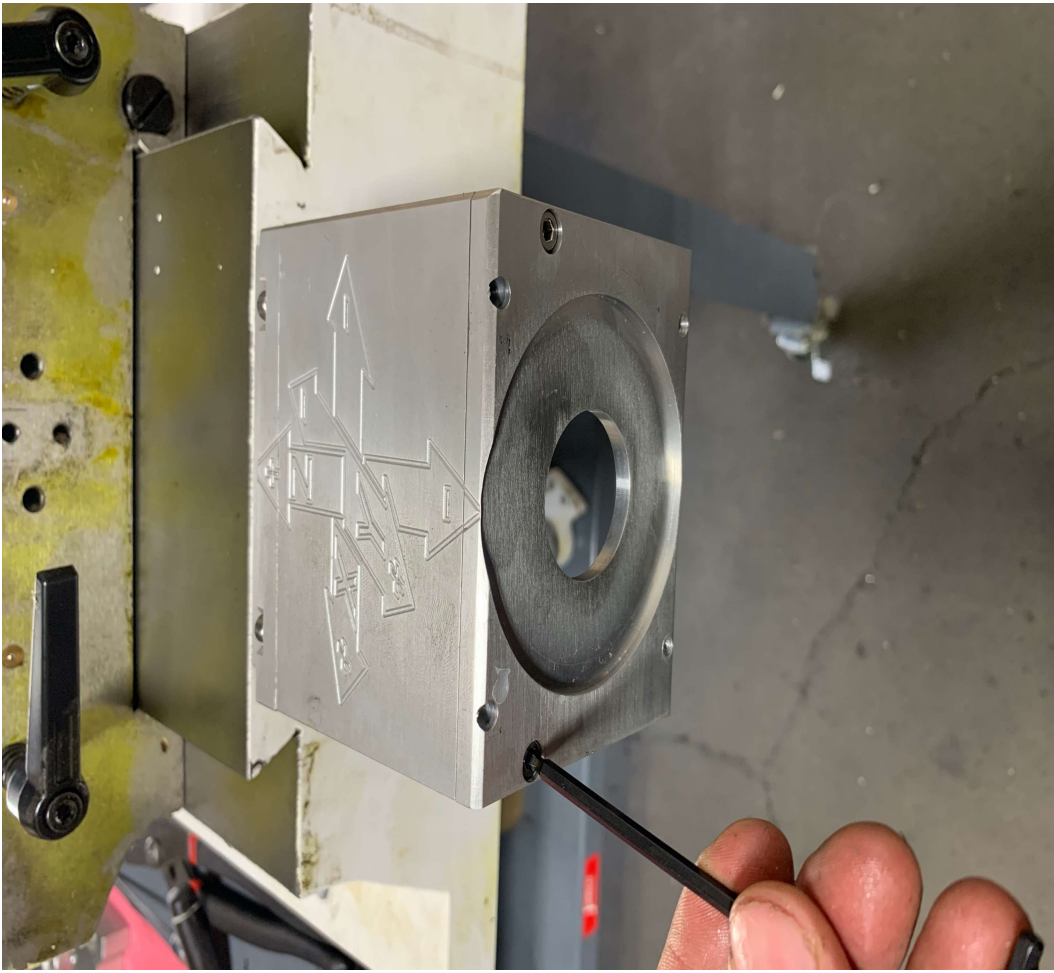


REMOVE THE 1/4" PLATE FROM THE Y ASSEMBLY. THEN PUT ON THE JAM NUTS. THEY NEED TO BE TIGHT AGAINST THE BEARING. JUST TIGHT ENOUGH TO GET RID OF ANY BACKLASH. USING THE DOUBLE NUT METHOD WILL KEEP THEM FROM COMING UNDONE



NOW BOLT IT ON TO THE
BASE. LEAVE THIS LOOSE AS
WELL. NOW I SUGGEST YOU
ATTACH A MOTOR TO THE
BALL SCREW SO YOU CAN
RUN IT BACK AND FORTH AS
YOU TIGHTEN IT UP. THE
BALL NUT BLOCK AND
MOTOR MOUNT HAVE SIDE
TO SIDE ADJUSTMENT TO
MAKE SURE THERE IS NO
BINDING

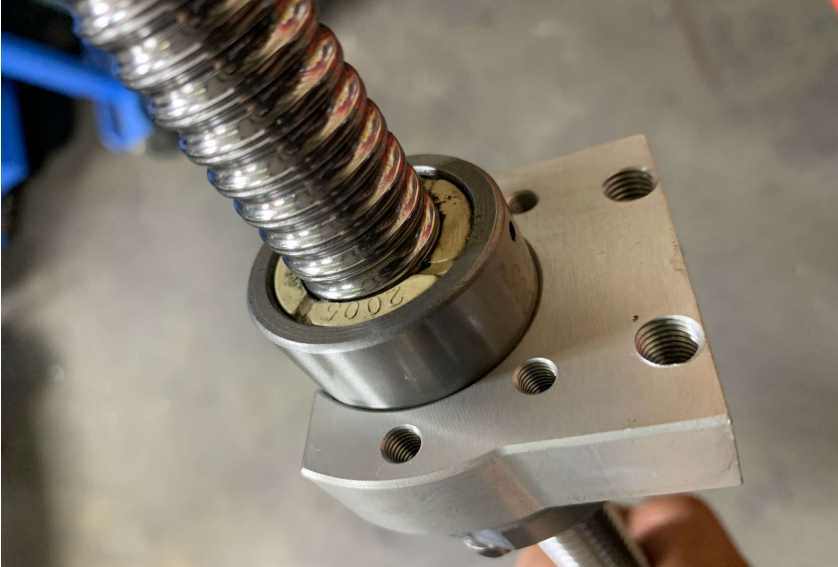




FOR X AXIS.
TO KEEP
FROM
MILLING INTO
THE SADDLE,
WE WERE
ABLE TO JUST
TAKE .100"
OFF THE
BOTTOM OF
THE TABLE.



THIS IS THE X BALL NUT AND BALL SCREW ASSEMBLY. WE REMOVED SOME OF THE FLANGE OF THE BALL NUT FOR CLEARANCE



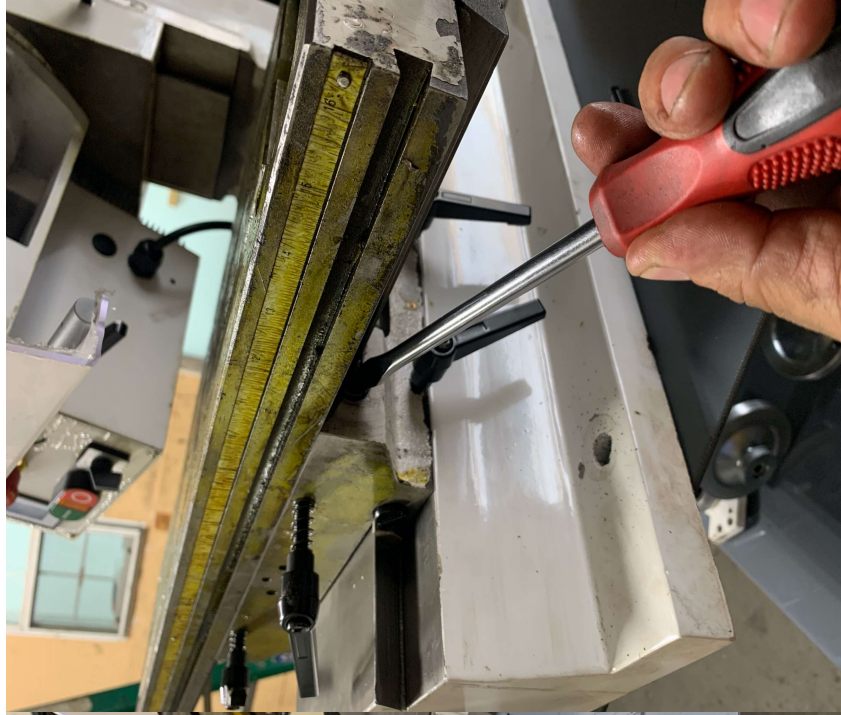
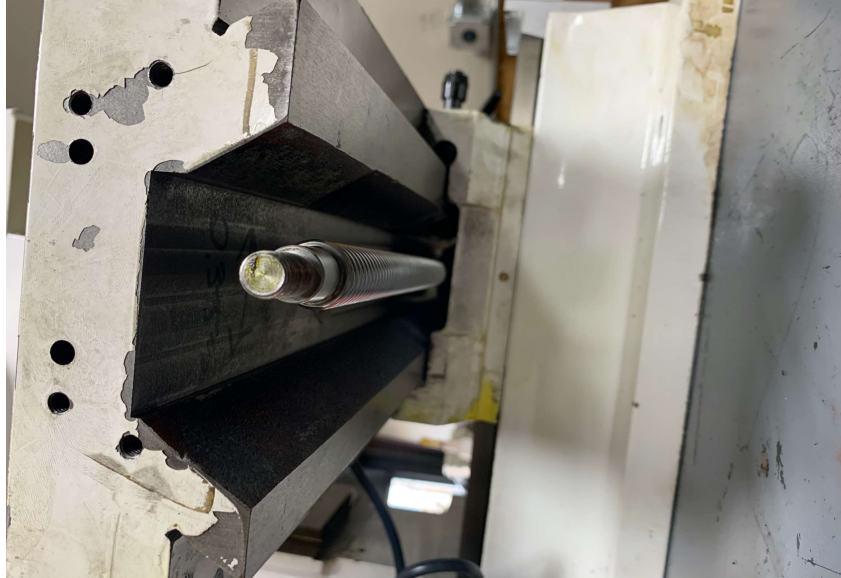
DROP THE ASSEMBLY INTO THE SLOT ON THE SADDLE



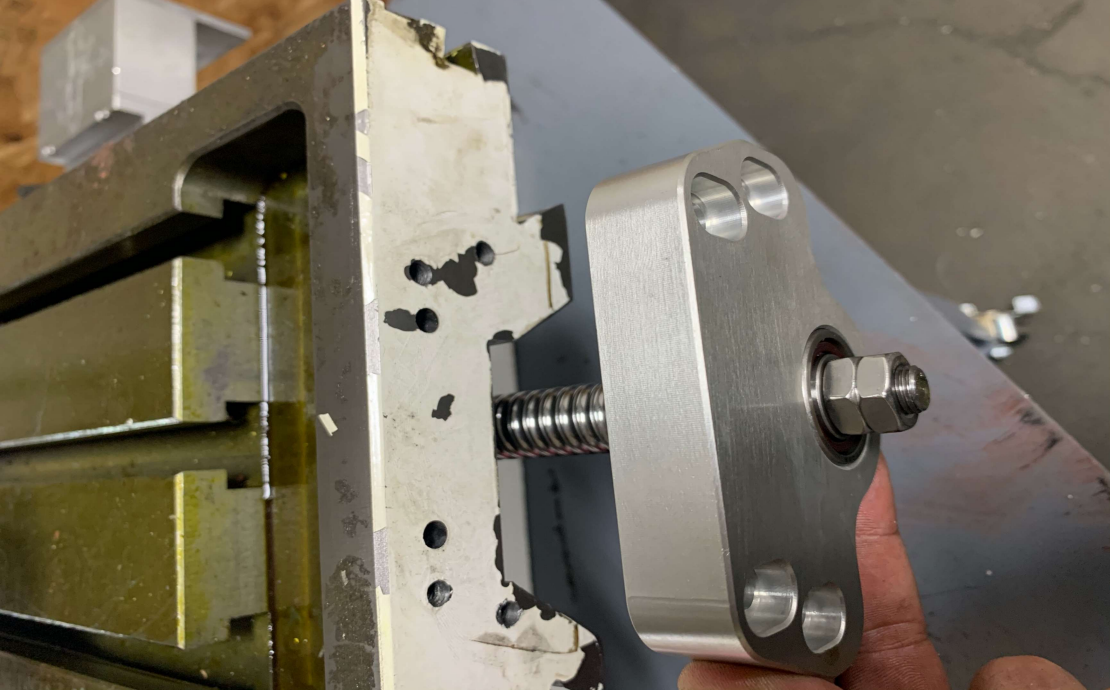
PUT THE CAP SCREWS IN. DON'T TIGHTEN THEM ALL THE WAY



SLIDE THE TABLE BACK ON AND PUT THE GIB
IN PLACE



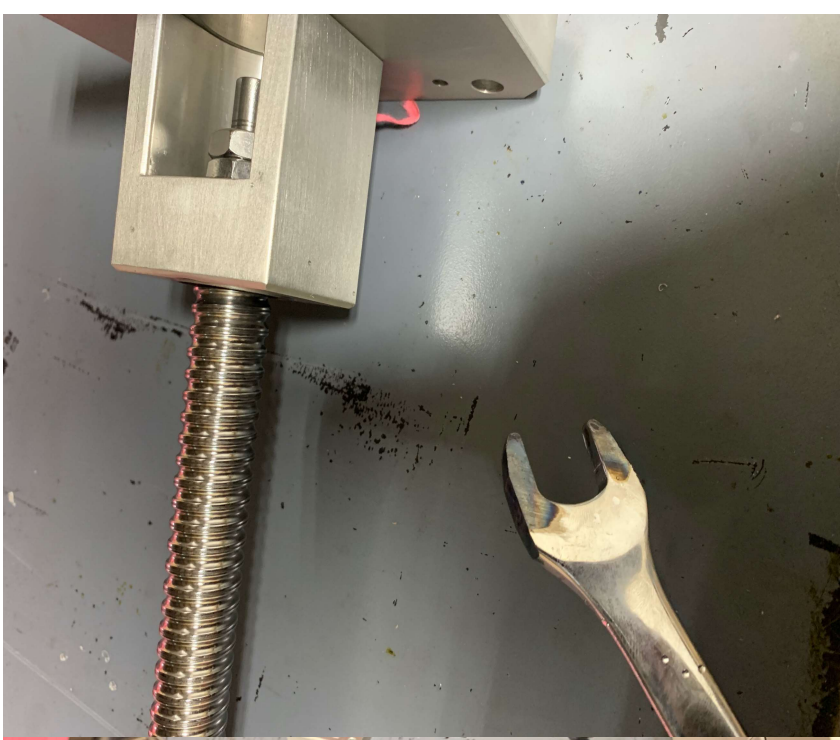
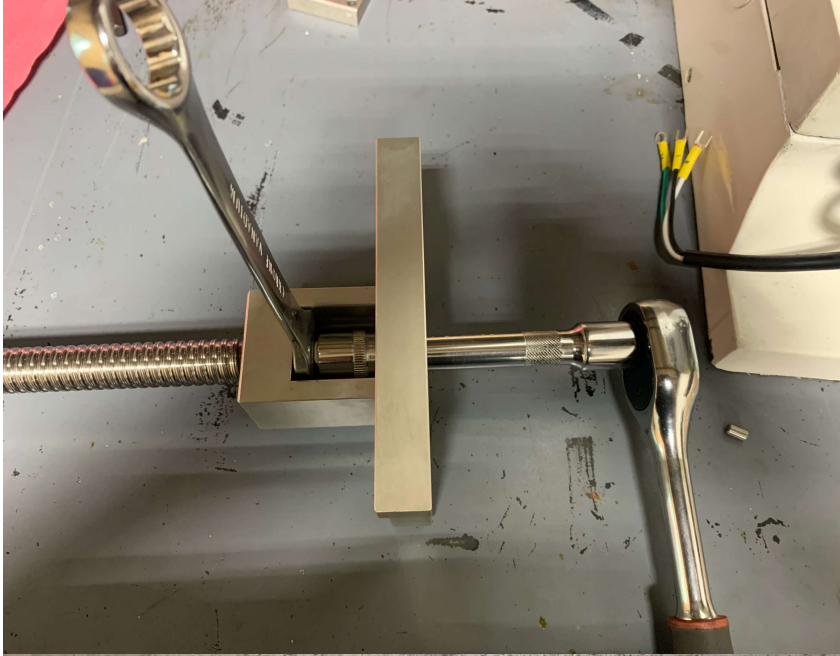
PUT THE BEARING BLOCK ON THE BALL SCEW ON THE LEFT END OF THE TABLE. LOCK DOWN THE JAM NUTS, THEN ATTACH IT TO THE TABLE



ATTACH THE
MOTOR
MOUNT TO
THE RIGHT
SIDE OF THE
TABLE. AGAIN
PUT A
MOTOR ON
AND RUN
THE TABLE
BACK AND
FOURTH
WHILE
TIGHTENING
THE BOLTS



MOVING TO Z. TIGHTEN THE JAM NUTS



NOW YOU DROP THE Z ASSEMBLY INTO THE COLUMN





THE HEAD HAS TO BE TILTED TO EXPOSE THE
SLOT YOU BOLT THE BALL NUT BLOCK ON



BOLT ON THE MOTOR MOUNT TO TOP OF THE
COLUMN. AND THE CAP WHERE THE Z HANDLE
WAS



YOU ARE READY
TO START
HOOKING UP THE
ELECTRONICS

