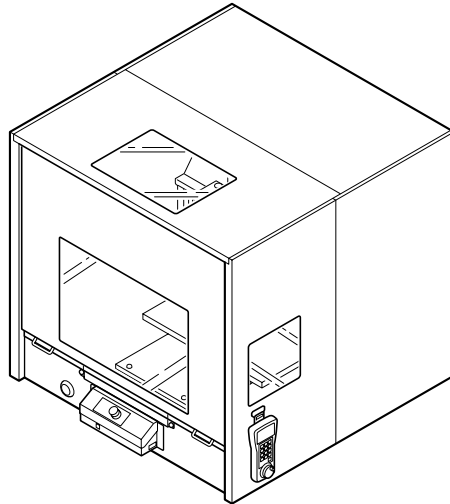


Assembly Instructions

This document provides instructions for service personnel. These procedures should not be performed by the end user.



Important Notes on Assembly Operations

⚠ WARNING Before attempting these operations, unplug the power cord for the modeling machine. Failure to do so may result in danger of electrical shock, electrocution, or entanglement.

⚠ WARNING After completing the operations, be sure to verify the operation of the interlock switch, and never use the machine if the switch does not operate correctly.

- Before attempting these operations, read through this manual and familiarize yourself with the installation location and orientation of each part.
- Assembly operations are to be performed by two or more persons.
- To prevent injury, wear gloves when performing these operations.
- Be sure to use some means to secure the emplacement base and safety cover.

Supported model

MODELA Pro II MDX-540

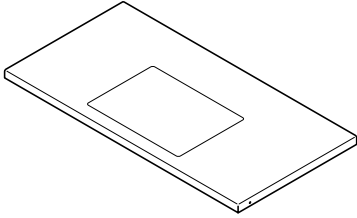
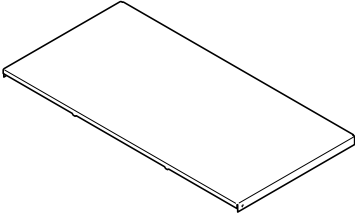
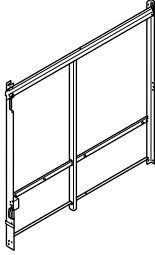
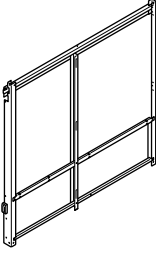
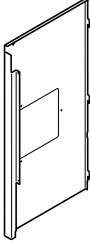
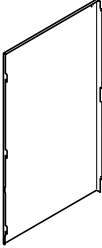
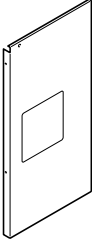
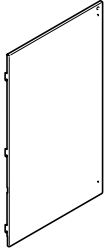
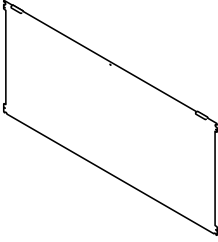
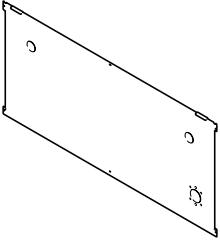
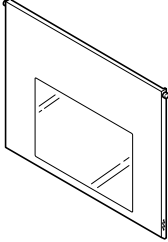
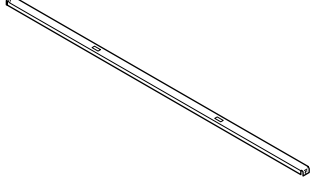
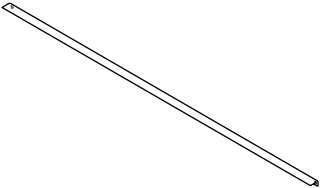
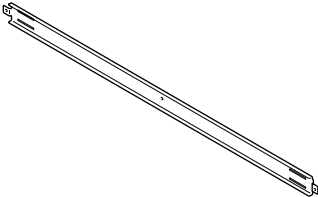
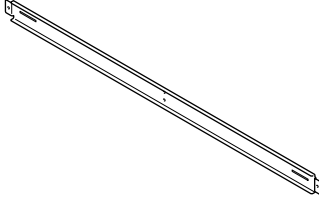
External dimensions

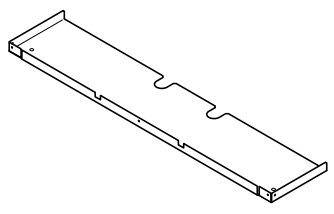
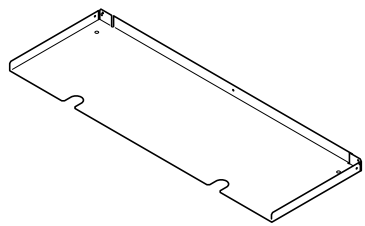
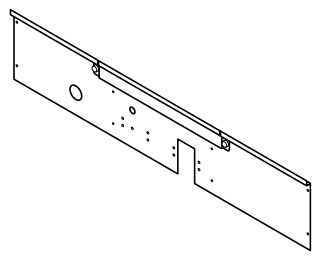
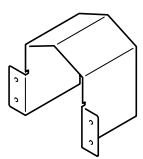
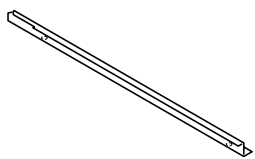
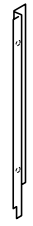
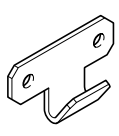
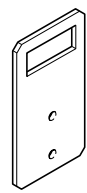
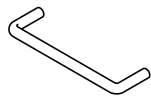
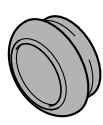





W x D x H: 1,042 x 1,030 x 978 mm (41 x 40.6 x 38.5 in.)

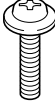



Weight

68 kg (150 lb.)

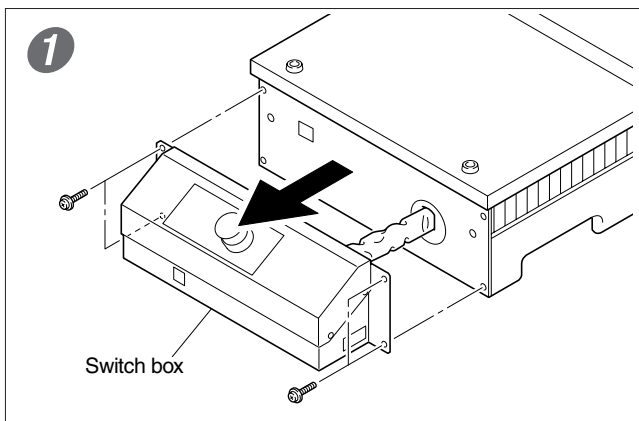
Part List

<p>Top panel A x 1</p> 	<p>Top panel B x 1</p> 	<p>Left side frame x 1</p> 
<p>Right side frame x 1</p> 	<p>Left side panel A x 1</p> 	<p>Left side panel B x 1</p> 
<p>Right side panel A x 1</p> 	<p>Right side panel B x 1</p> 	<p>Back panel A x 1</p> 
<p>Back panel B x 1</p> 	<p>Hatch panel x 1</p> 	<p>Top frame A x 1</p> 
<p>Top frame B x 1</p> 	<p>Back frame A x 1</p> 	<p>Back frame B x 1</p> 

<p>Bottom stay A x 1</p> 	<p>Bottom stay B x 1</p> 	<p>Front cover x 1</p> 
<p>Wiring covers A x 2</p> 	<p>Wiring cover B x 1</p> 	<p>Wiring cover C x 1</p> 
<p>Handy-panel bracket x 1</p> 	<p>Handy-panel hanger x 1</p> 	<p>Handles x 2</p> 
<p>Rubber caps x 3</p> 	<p>Screws (M5 x 8 mm) x 4</p> 	<p>Screws (silver, M4 x 8 mm) x 52</p> 
<p>Screws (black, M4 x 8 mm) x 4</p> 	<p>Screws, with washer (M4 x 8 mm) x 2</p> 	<p>Screws, with washer (M4 x 6 mm) x 2</p> 

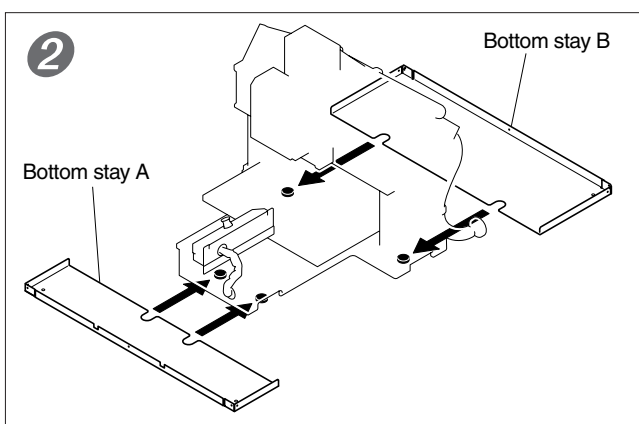
<p>Screws, with flange (M4 x 14 mm) x 4</p> 	<p>Tapping screws (M3 x 8 mm) x 2</p> 	<p>Nuts, with flange (M4 mm) x 2</p> 
<p>Cable retainer x 1</p> 		

Assembly



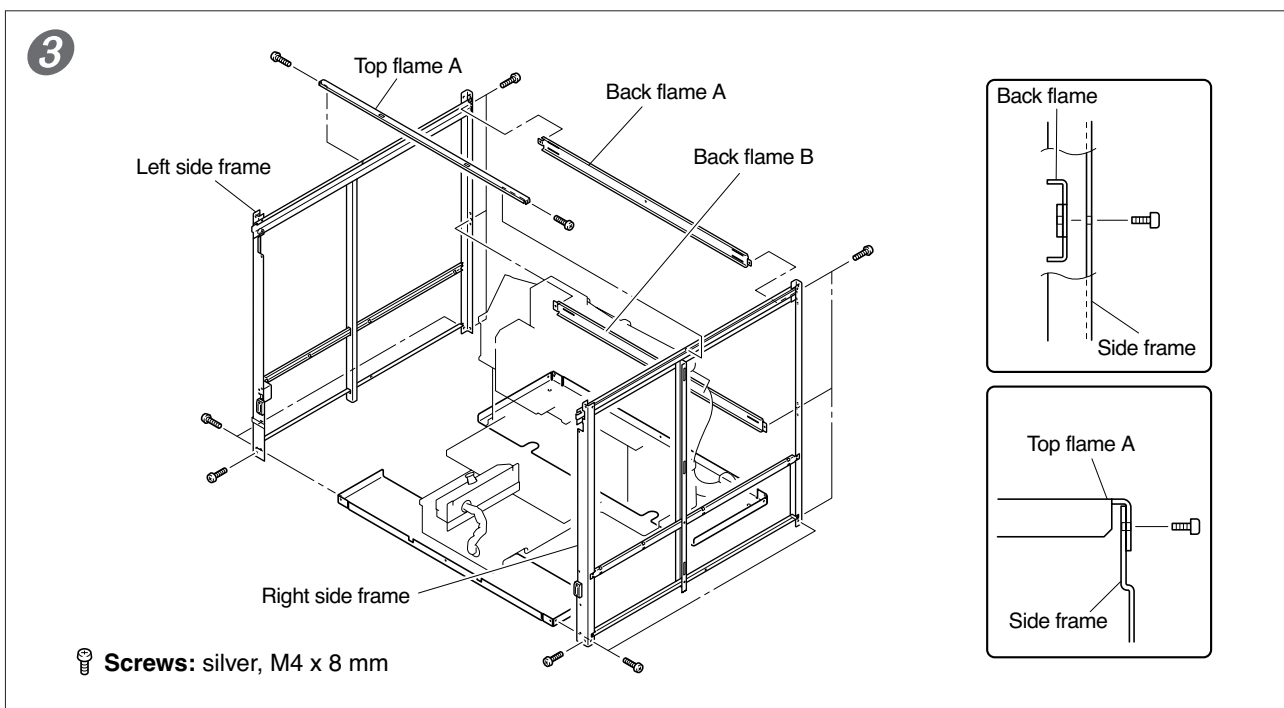
- ① Place the modeling machine at the installation location.
- ② Remove the switch box from the modeling machine (4 screws). Pull out the wiring from the switch box.

Note: Place the removed switch box on the modeling machine's table or base cover.



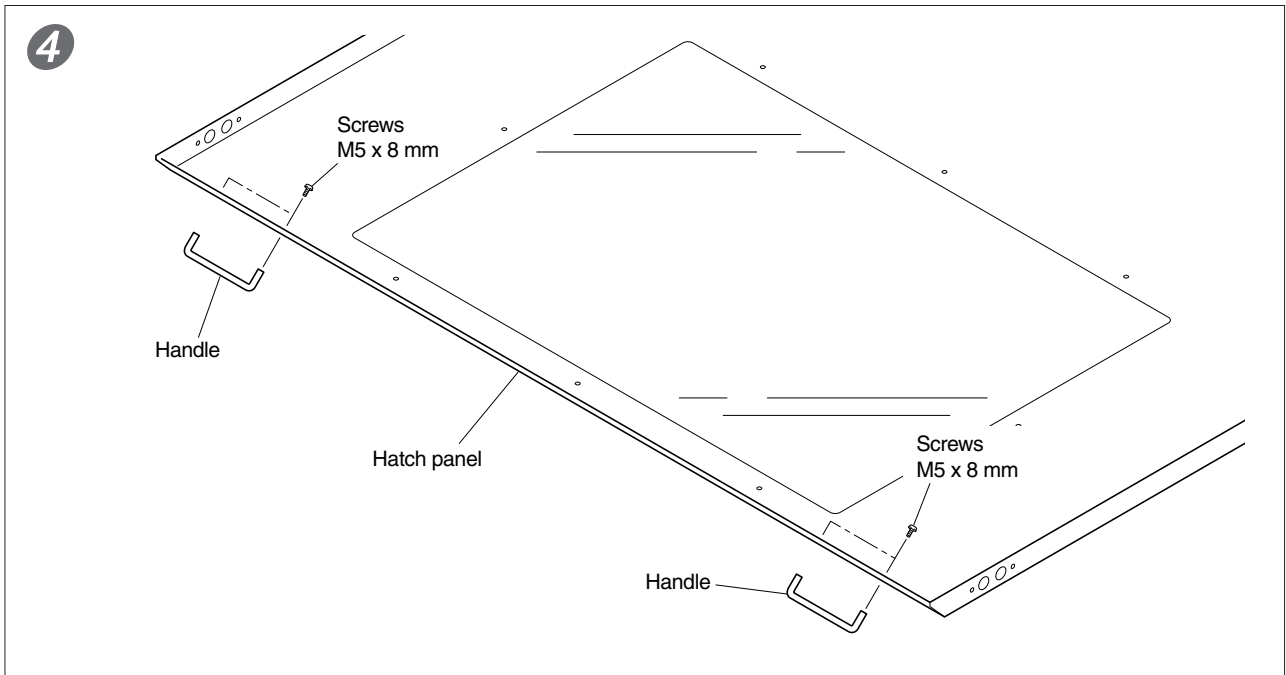
- ① Line up bottom stays A and B with the modeling machine's rubber feet and perform positioning of the safety cover.

Note: After the safety cover has been installed, the modeling machine cannot be relocated. Be sure to perform emplacement of the modeling machine before attaching the safety cover.

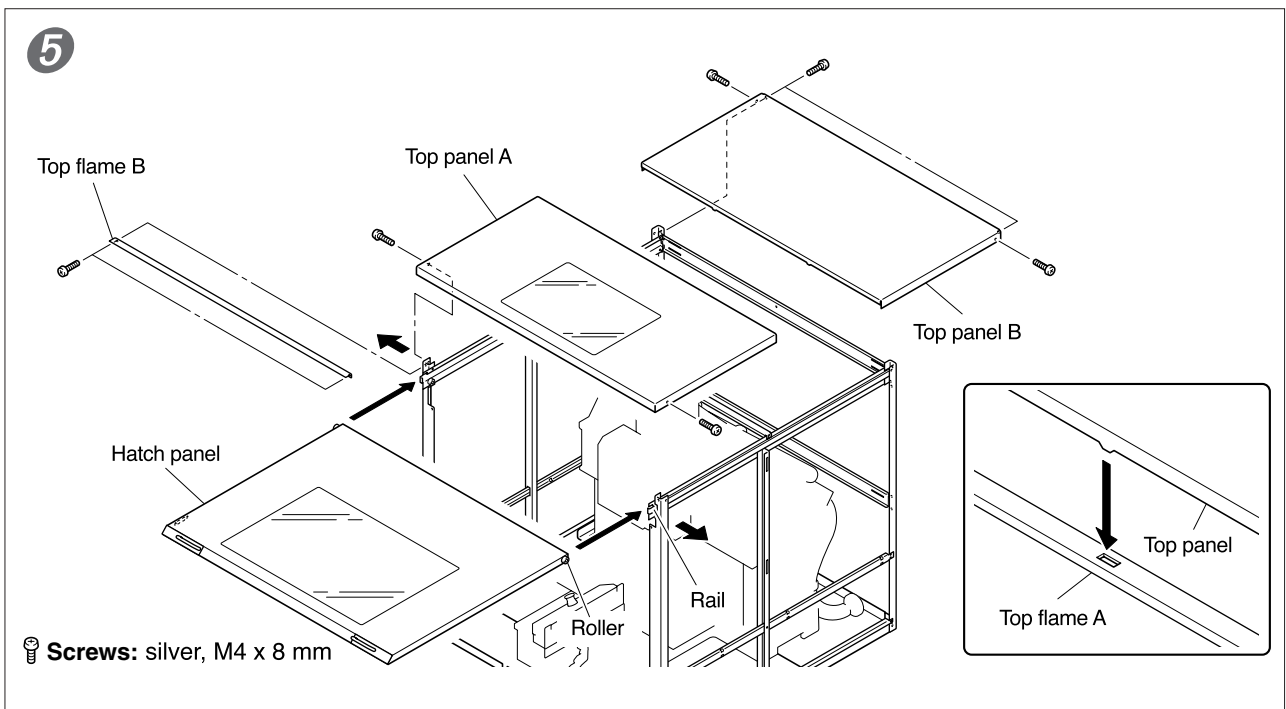


 **Screws:** silver, M4 x 8 mm

- ① Attach the left side frame.
- ② Attach the right side frame.
- ③ Attach the top frame A.
- ④ Attach the back frames A and B.

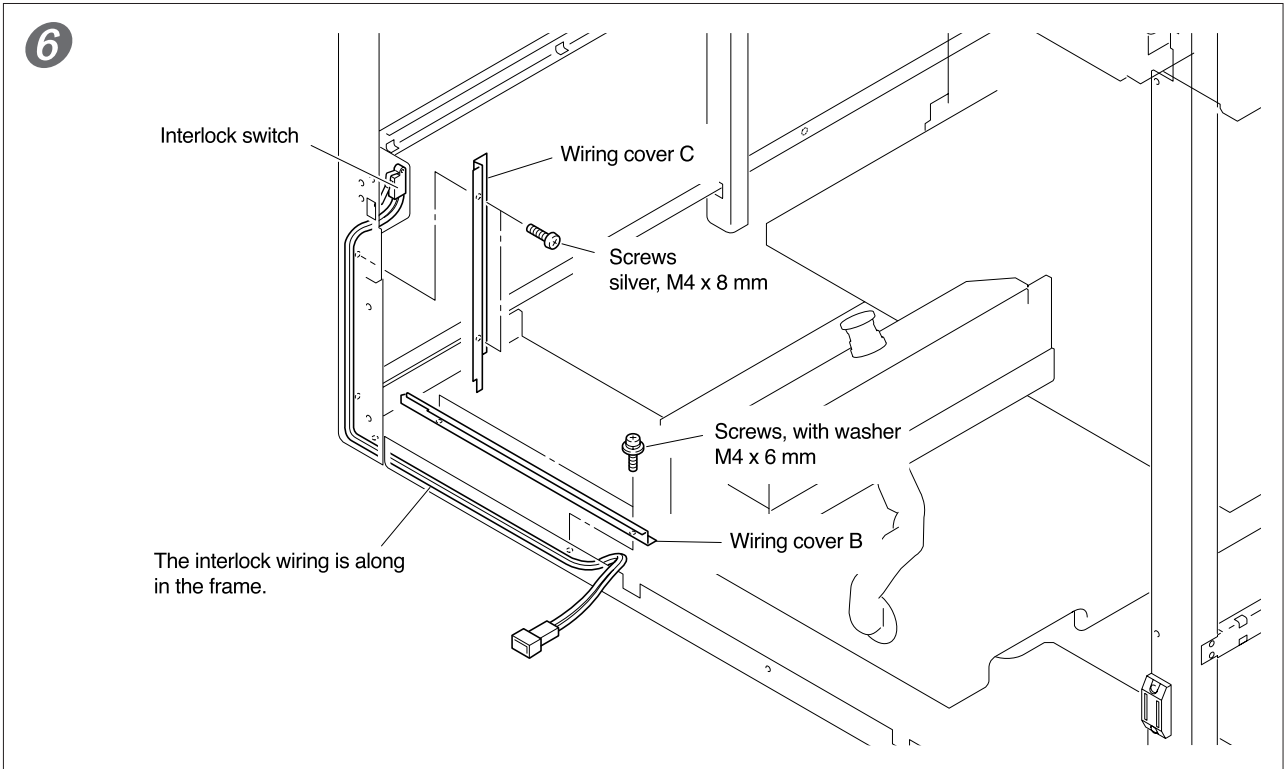


① Attach the handles to the hatch panel.



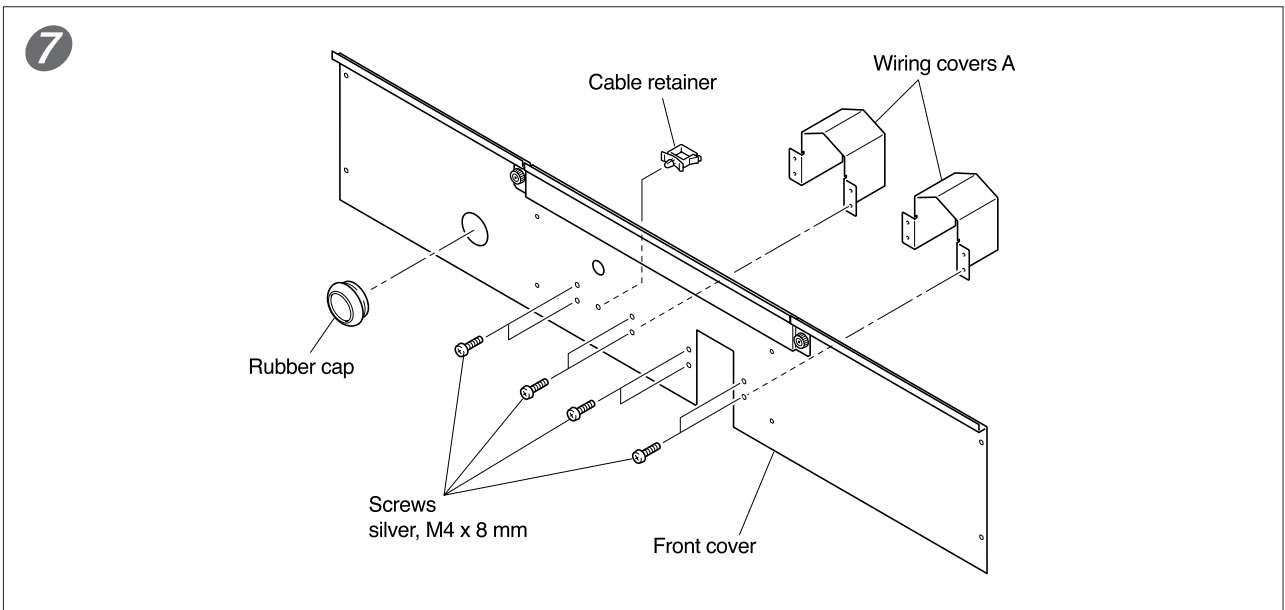
Screws: silver, M4 x 8 mm

- ① Attach the hatch panel. Spread the side frames open slightly and fit the rollers onto the rails.
- ② Attach the top frame B.
- ③ Attach the top panels A and B.



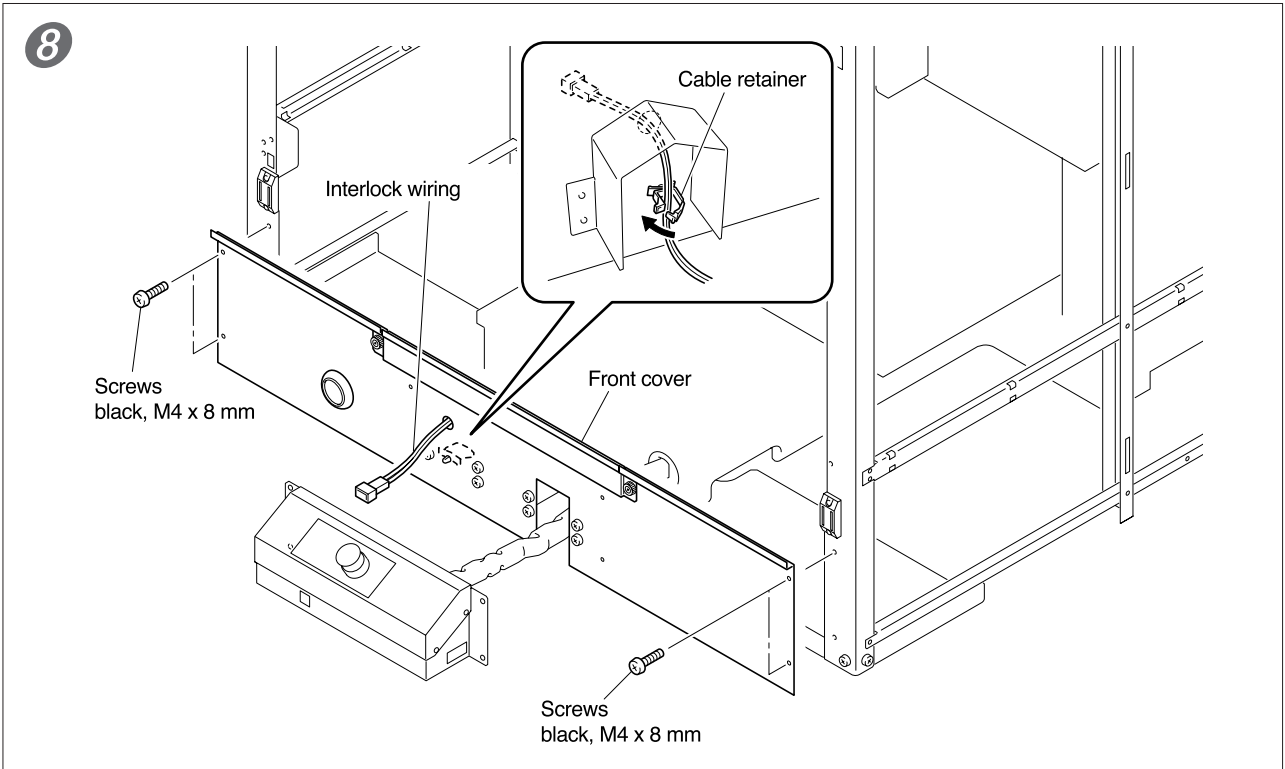
① Attach the wiring covers B and C.

Note: When installing the wiring covers B and C and the switch box, be especially careful to keep the interlock wiring from being pinched.

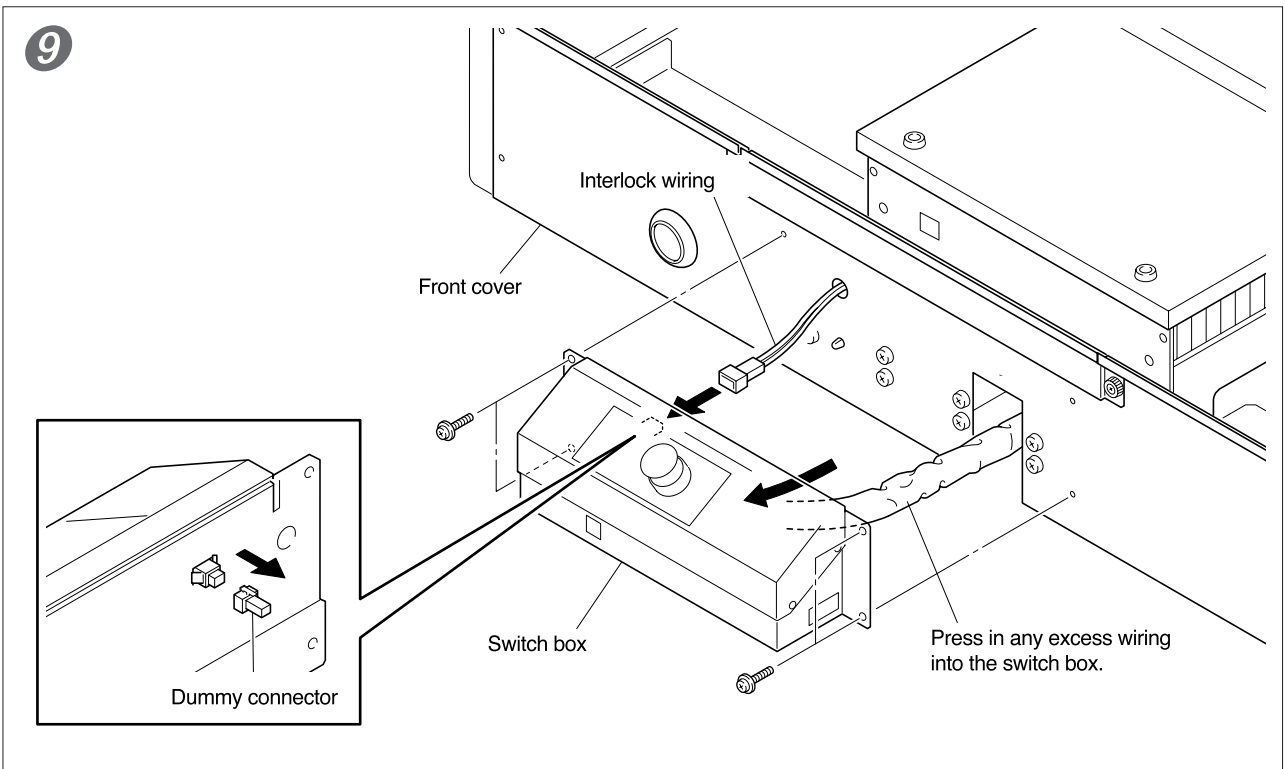


- ① Attach the wiring covers A to the front cover.
- ② Attach the cable retainer.
- ③ Attach the rubber cap.

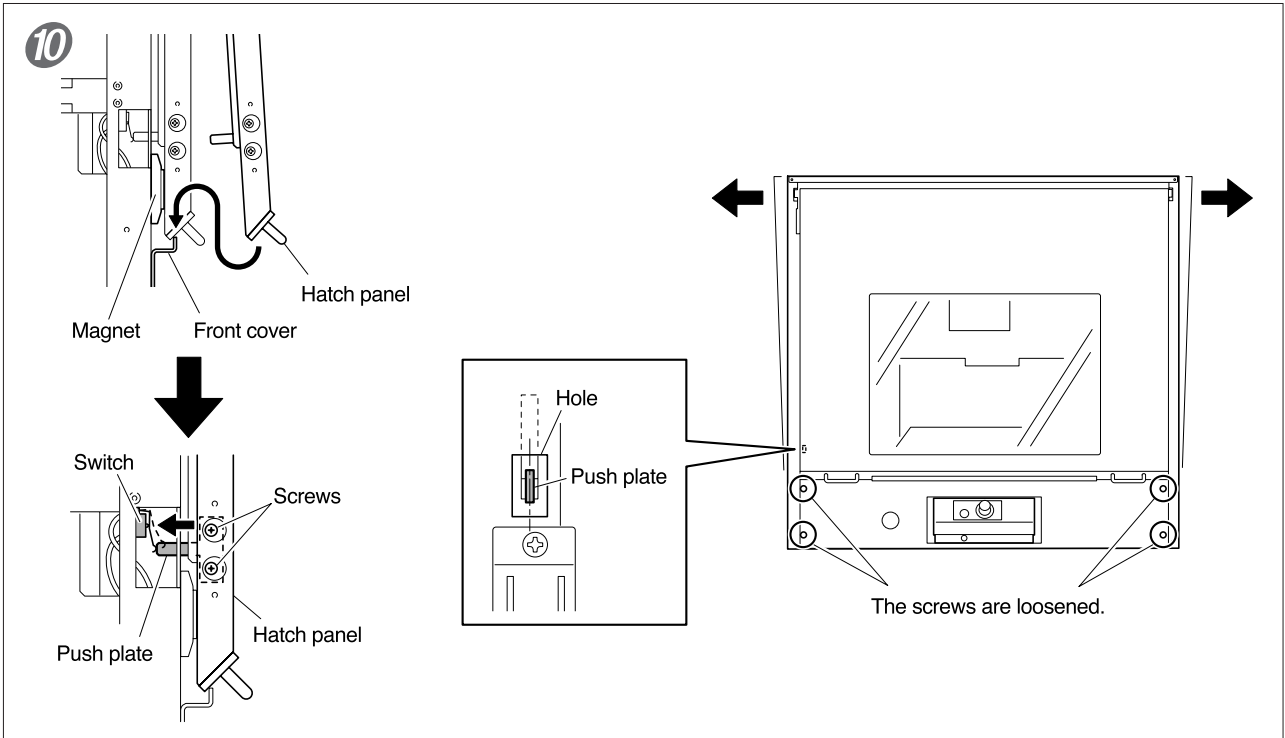
Note: Using a cutter, make a cross-shaped cut in the center of the rubber cap for the front cover as required. This cut is used when you want to pass the sensor cable or the like through.



- ① Pass the interlock wiring through the cable retainer and the hole in the front cover.
- ② Attach the front cover.



- ① Remove the dummy connector from the switch box.
- ② Connect the interlock wiring to the switch box and attach the switch box to the front cover. When doing this, press in any excess wiring into the switch box.



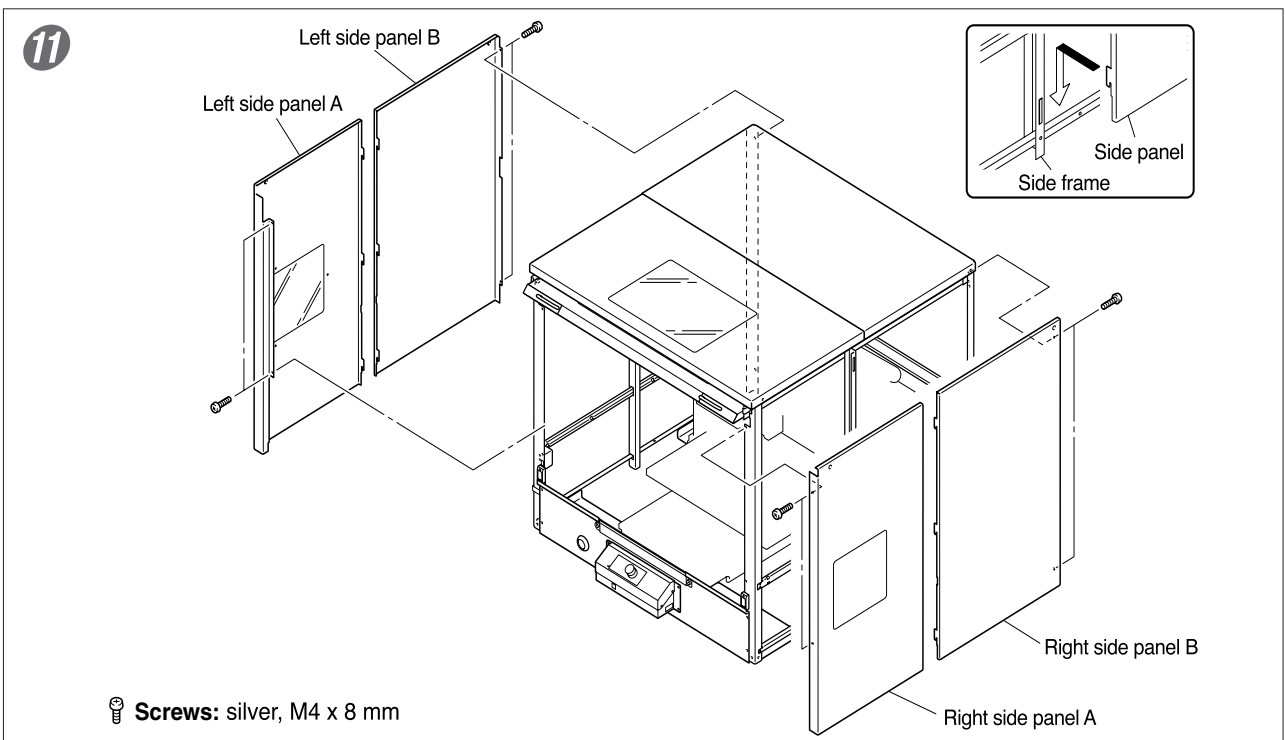
Adjusting the Interlock Switch

Make sure the push plate is positioned at the center of the hole for the interlock switch when the hatch panel is closed. If it is misaligned, then it must be adjusted by loosening the screws for the front cover and tilting the side frames slightly to the left or right, with the hatch panel kept closed. Make sure the interlock switch is pressed down fully when

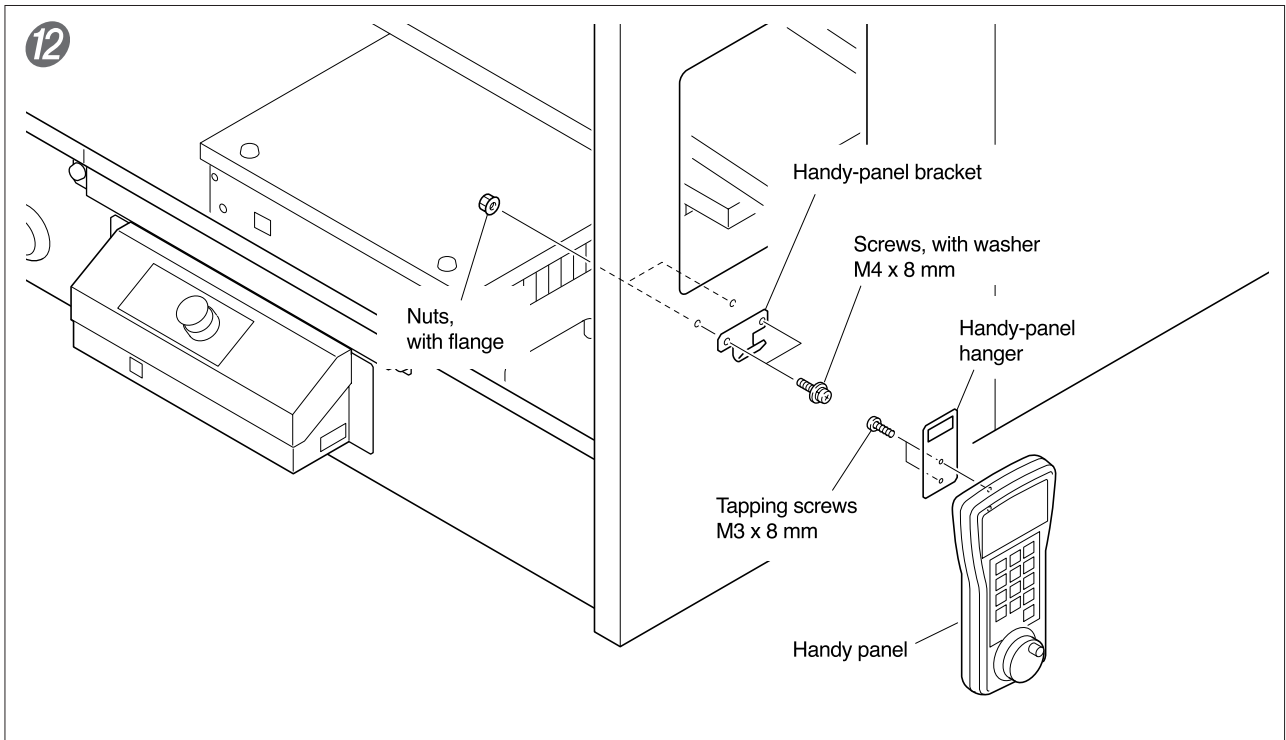
the hatch panel is closed. If the switch is not pressed, loosen the screws for the push plate and adjust the positioning.

How to Close the Hatch Panel

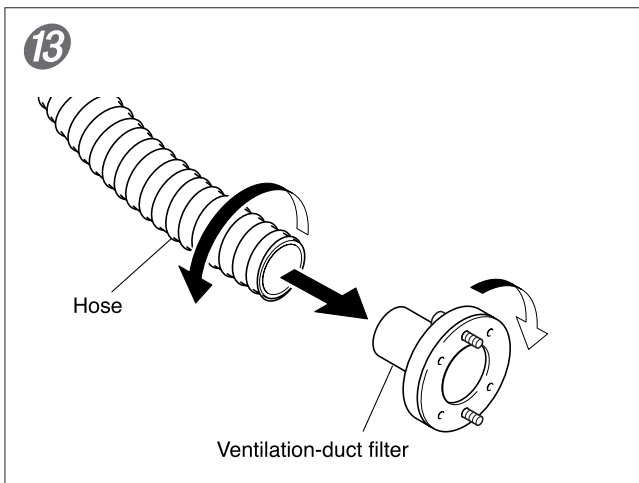
Lower the hatch panel, lift the handles slightly, and position so that the bottom edge of the hatch panel straddles the protrusion at the top of the front panel.



- ① Attach the left side panels A and B.
- ② Attach the right side panels A and B.

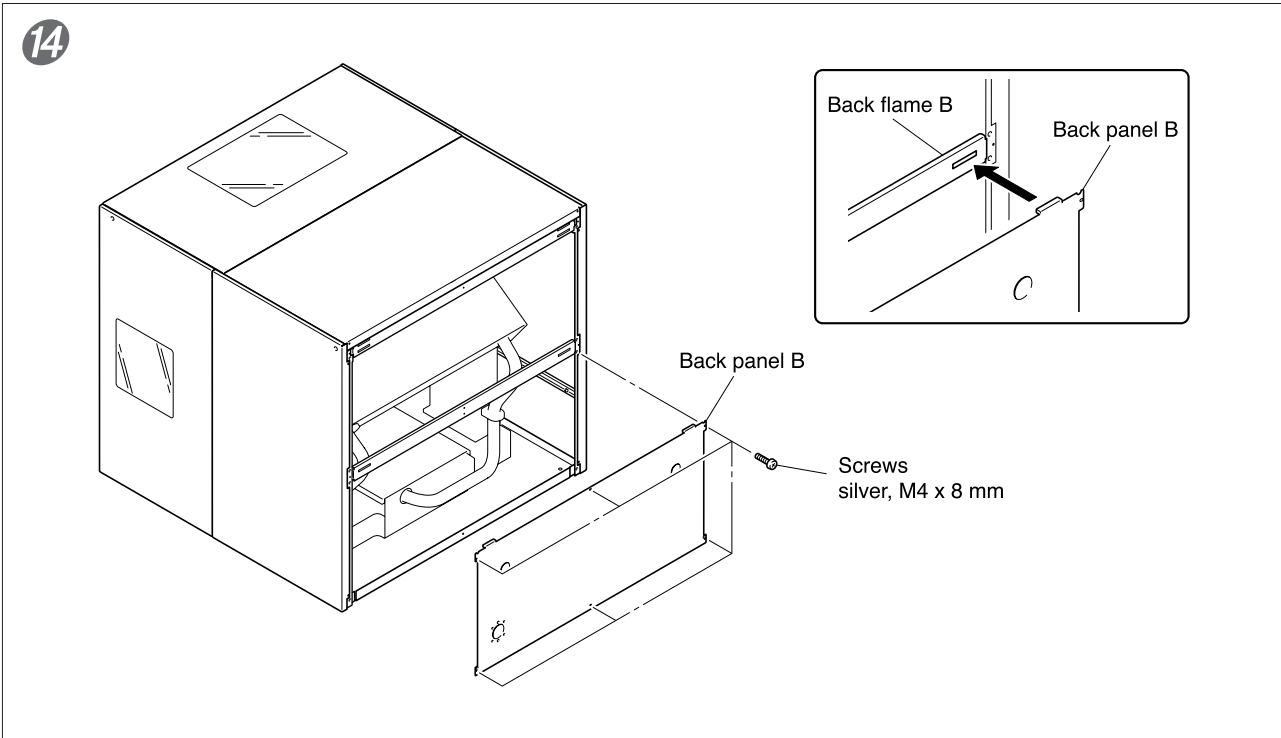


- ① Attach the handy-panel bracket.
- ② Mount the handy-panel hanger on the handy panel.

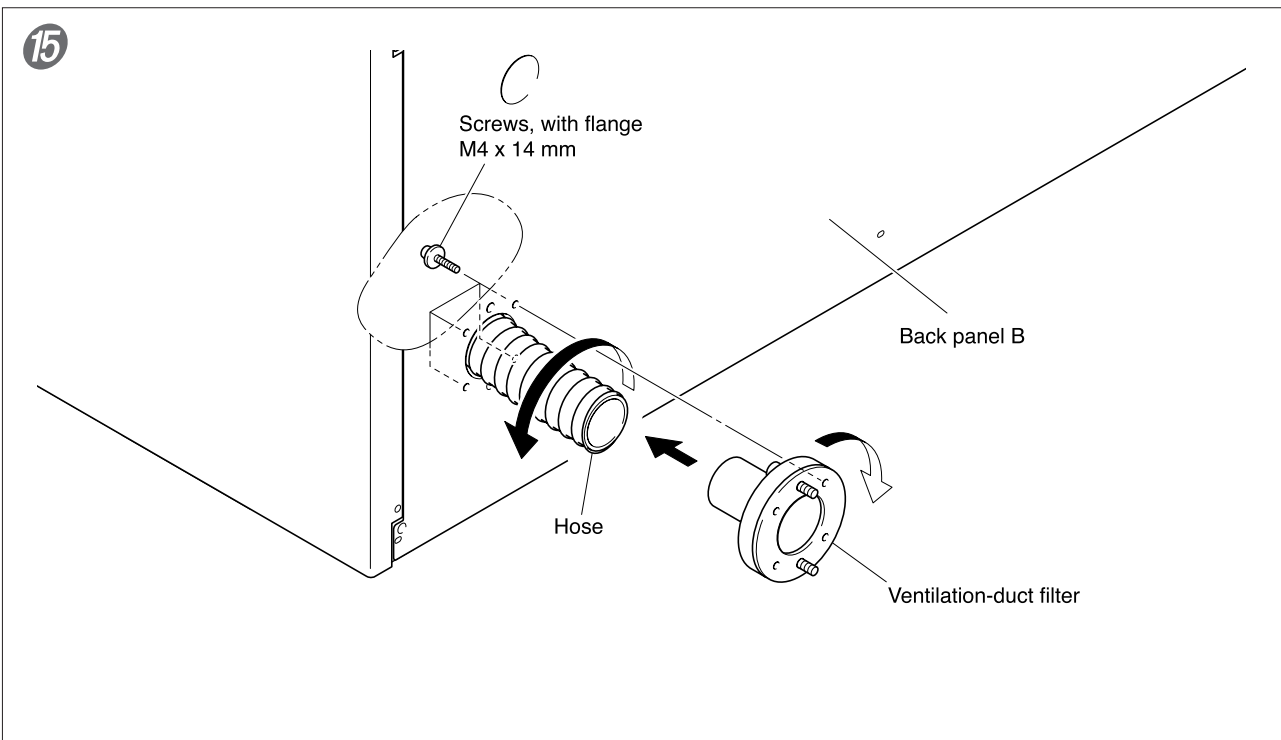


- ① Remove the ventilation-duct filter.

Note: Perform attachment and detachment of the ventilation-duct filter while turning it clockwise. When doing this, grasp the hose at a location a short distance away from its end.



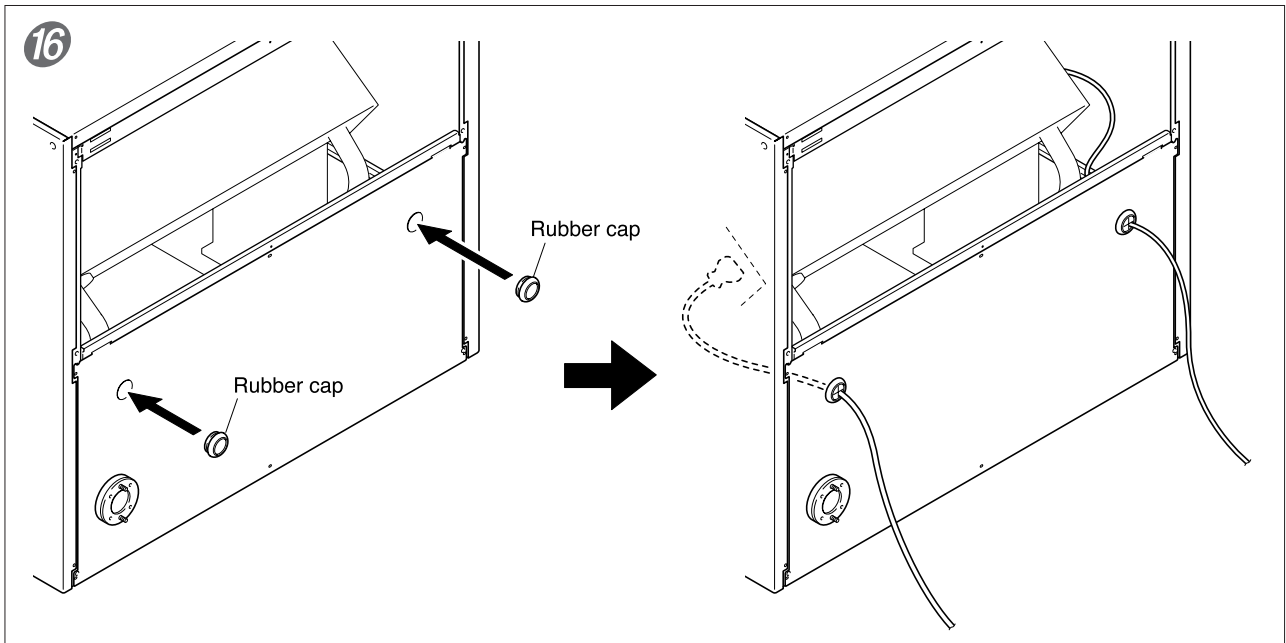
① Attach the back panel B.



① Connect the ventilation-duct filter to the hose and attach it to the back panel B.

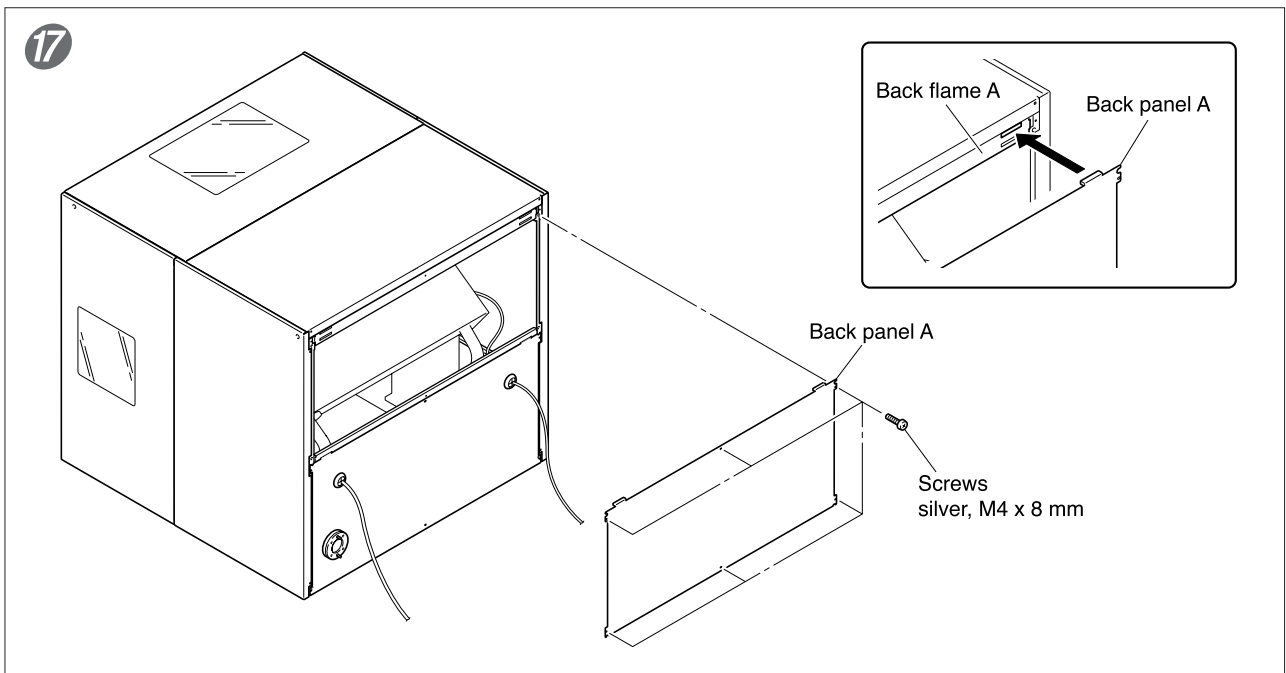
Note: Perform attachment and detachment of the ventilation-duct filter while turning it clockwise. When doing this, grasp the hose at a location a short distance away from its end.

Note: Insert the hose securely, as far as it will go. If it is difficult to insert, apply a small amount of water or alcohol to the inside of the hose.



- ① Attach the rubber caps.
- ② Pass the power cord and other necessary cables through the rubber caps and connect them to the modeling machine.

Note: Use a cutter to make a cross-shaped cut in the centers of the rubber caps to match the thickness of the cables.



- ① Attach the back panel A.

- ① Make sure the hatch panel opens and closes smoothly.
- ② Close the hatch panel and start the modeling machine. Make sure that cutting operation is possible when the hatch panel is closed.
- ③ Make sure that the interlock feature is actuated and cutting operation is restricted when the hatch panel is opened.

Note: If the interlock feature is not actuated correctly, repeat the adjustment in step 10.