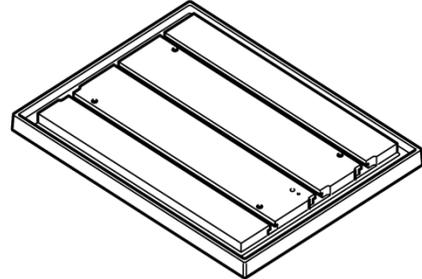

MODELAPROII

T-SLOT TABLE UNIT

ZTT-540

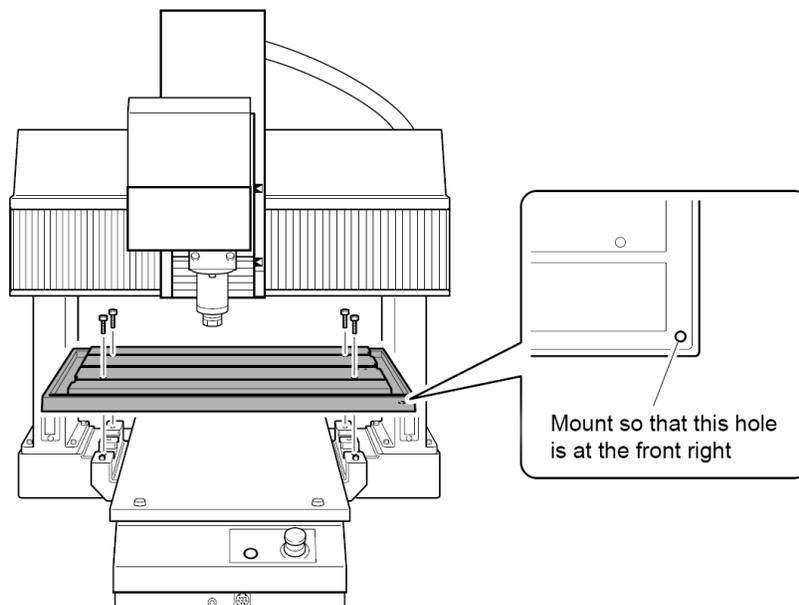


Setup & Applications

The purpose of this document is to help owners of the MDX-540, MDX-540A, MDX-540S and MDX-540SA milling machine setup and use the ZTT-540 T-Slot Table accessory for various applications.

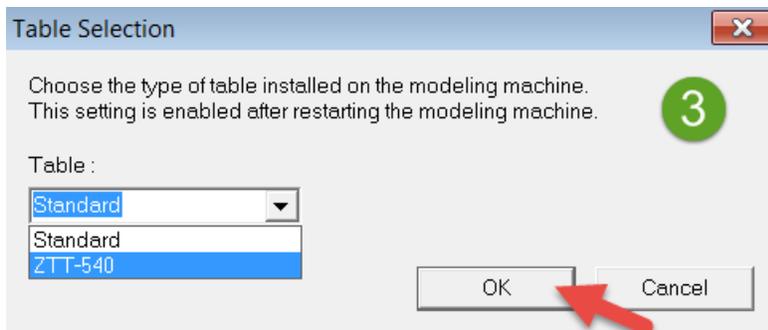
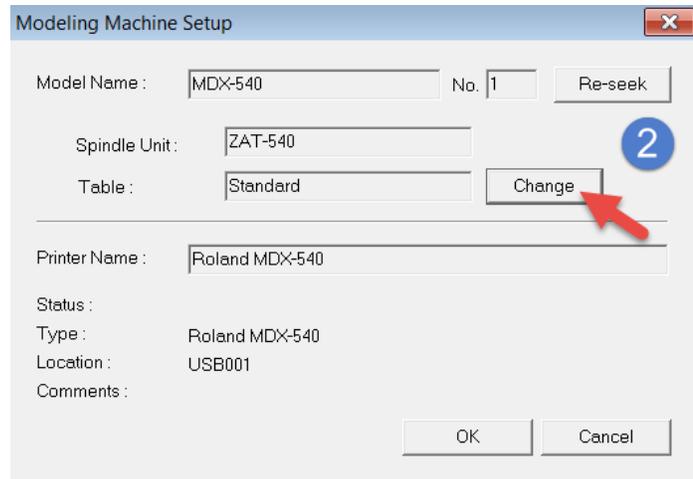
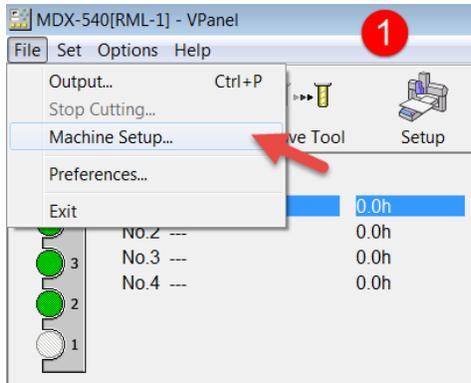
Installation of the T-Slot Table

Remove the four cap screws and detach the standard table. Mount the T-slot table oriented as shown in the image below, and secure it in place with the four provided cap screws.



VPanel Adjustments

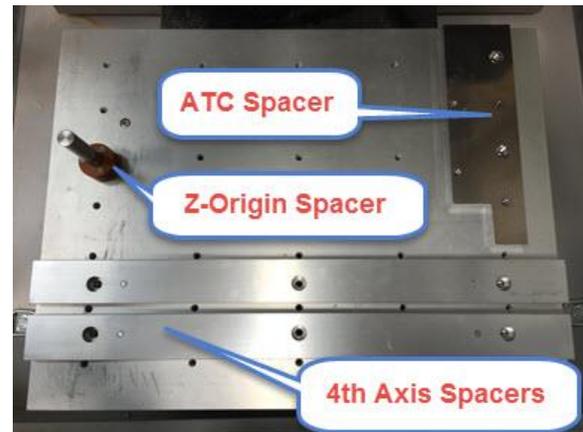
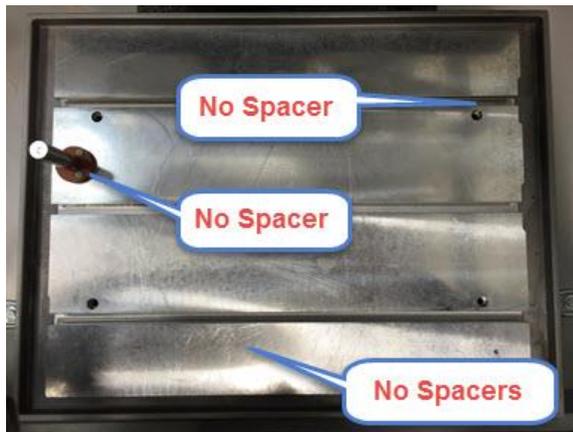
After installing the T-slot table for your MDX-540, you will need to make the following adjustments in the VPanel. The table setting must be changed from “Standard” to “ZTT-540”:



Tech Note: *Once you have follow these steps make sure restart your machine to commit these changes.*

Mounting the Z-origin Sensor

Due to the excess height of the T-slot table the Z-origin sensor will need to be installed on the table without its included riser. Remove the extra riser from the sensor and install the sensor on in the front right position using the three short length nylon screws that were provided in the original MDX-540 shipment (shown below) or in the back left position if the 4-th axis is being installed on the table.



Mounting the ATC (Optional)

Four T-slot nuts are included with the table for installing the ATC unit. Insert two T-slot nuts into each of the last two grooves so that the ATC can be fastened down with the 4 provided bolts. *Please refer to the ZAT-540 User Manual for detailed installation instructions.*

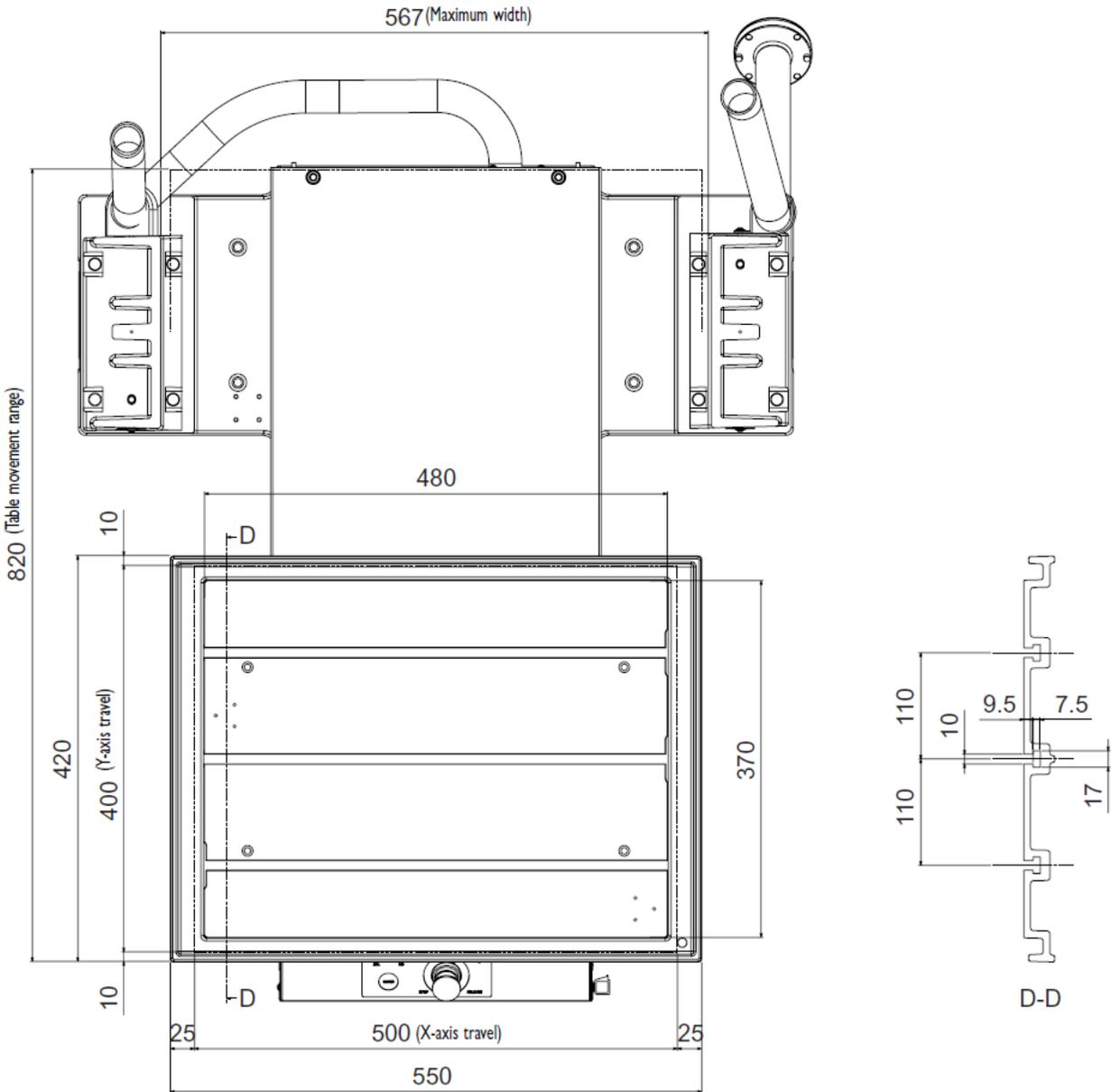
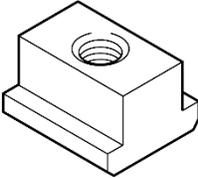
Mounting the 4th Axis (Optional)

Mount the ZCL-540 directly to the T-slot table's front groove. The 4th axis is designed to mount to the T-slot table without and added spacer show above. The Z-origin sensor will need to be installed in the rear left position of the table. *Please refer to the ZCL-540 User Manual for detailed installation instructions.*

ZTT-540 SCHEMATIC

T-Slot Table Nut Specifications:

- Slot Size: 10mm
- Thread Size: M8 x 1.25



APPLICATIONS

The ZTT-540 T-slot table works together with a variety of clamps, vises and other fixtures that allow for one off or repeatable production of parts for various purposes. All clamps and kits need to have T-slot nuts that fit the above mentioned T-slot and stud size specifications.

Clamping

Various clamping kits are available that let you hold down blocks of material of various sizes without having to use any adhesives or tape. Riser blocks allow you accurately adjust the height of included strap clamps and bolt down your material tightly to the T-slot table.

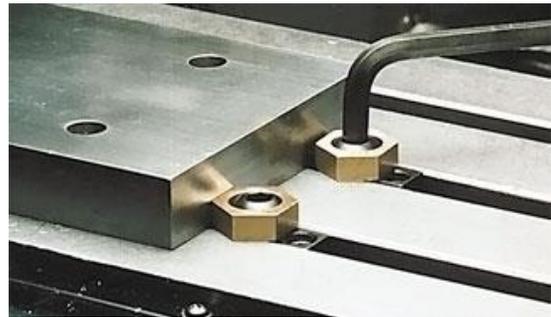
If you are new to using T-slot table CNC setups then using a clamp kit is the best way for you get started. All of the bolts, riser blocks and strap clamps that you need to start clamping down material blocks of various sizes will be included without having to hunt down the individual parts. One of the most popular and user friendly clamping kits for the MDX-540 is the TE-CO Metric Steel Super Clamp (below).



- TE-CO Metric Steel Super Clamp Kit
- Part Number: 68101
- www.te-co.com

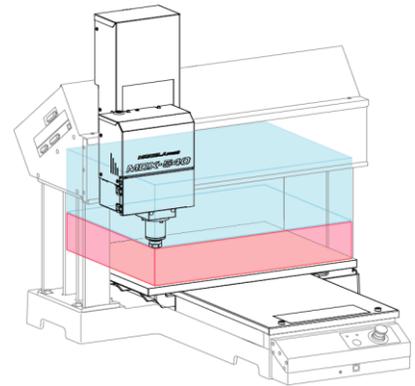


- MITEE-BITE T-Slot Clamp Kit
- Locks in machine T-slot for low profile clamping
- Part Number: 50644
- www.miteebite.com



Tech Note: *There is a range above the table where the spindle may not reach depending on the cutter length, there may be occasions where the cutter does not reach the material. Spacers to raise clamps can be used when necessary.*

Tech Note: *Size and weight limitations of the MDX-540 should be considered when using any table accessory. The maximum loadable limit, including the machine table of the MDX-540, is 44lbs. Please consider the overall weight of the machine platform, clamps, vises, and workpiece before use. Refer to the User's Manual for detailed information.*



Vises

Any given vise can only hold certain material sizes, but for the purpose of multiple index milling and other special applications there is no better option to speed up your workflow. Standard and self-centering vises are designed to give you the ability to quickly hold down your material for milling and then release to re-affix your part to mill more features, or start milling a new project.



Vises tend to be a more expensive solution for holding down your work piece, but the convenience and time savings that come from using a vise are hard to beat. Several vises are available that will work with the ZTT-540 table, but we recommend the following:

Gibraltar Standard Toolmakers Vise

- 5in Capacity
- Part Number: 42052761
- www.mscdirect.com



5th Axis Metric Self Centering Vise

- 125mm Capacity
- Part Number: V562M
- www.fifthaxis.com



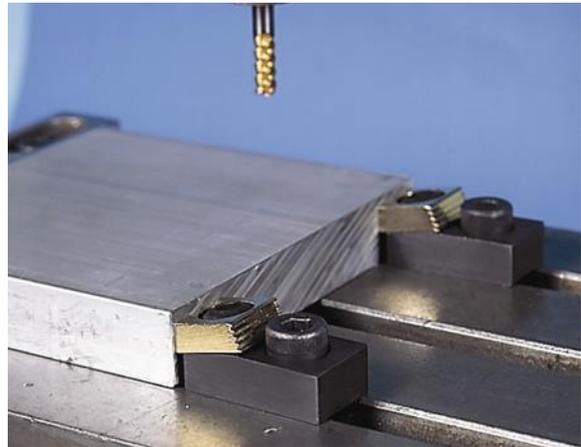
Individual Clamps/Hold Downs

There are a wide range of other fixture clamps and hold downs available for advanced users at www.miteebite.com among other providers. Choose which tools you want to use, but make sure that any T-slot nuts included are correctly sized.

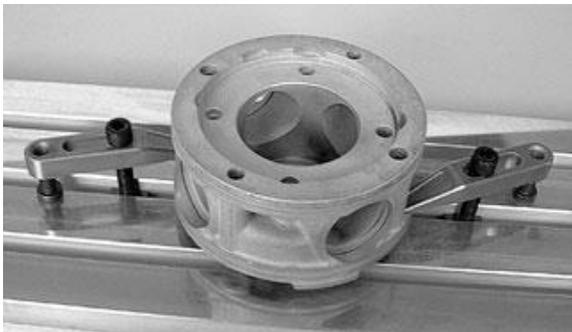
Riser Clamp Kits



T-Slot Toe Clamps



Individual Strap Clamps



Mono-Bloc Chain Clamps

