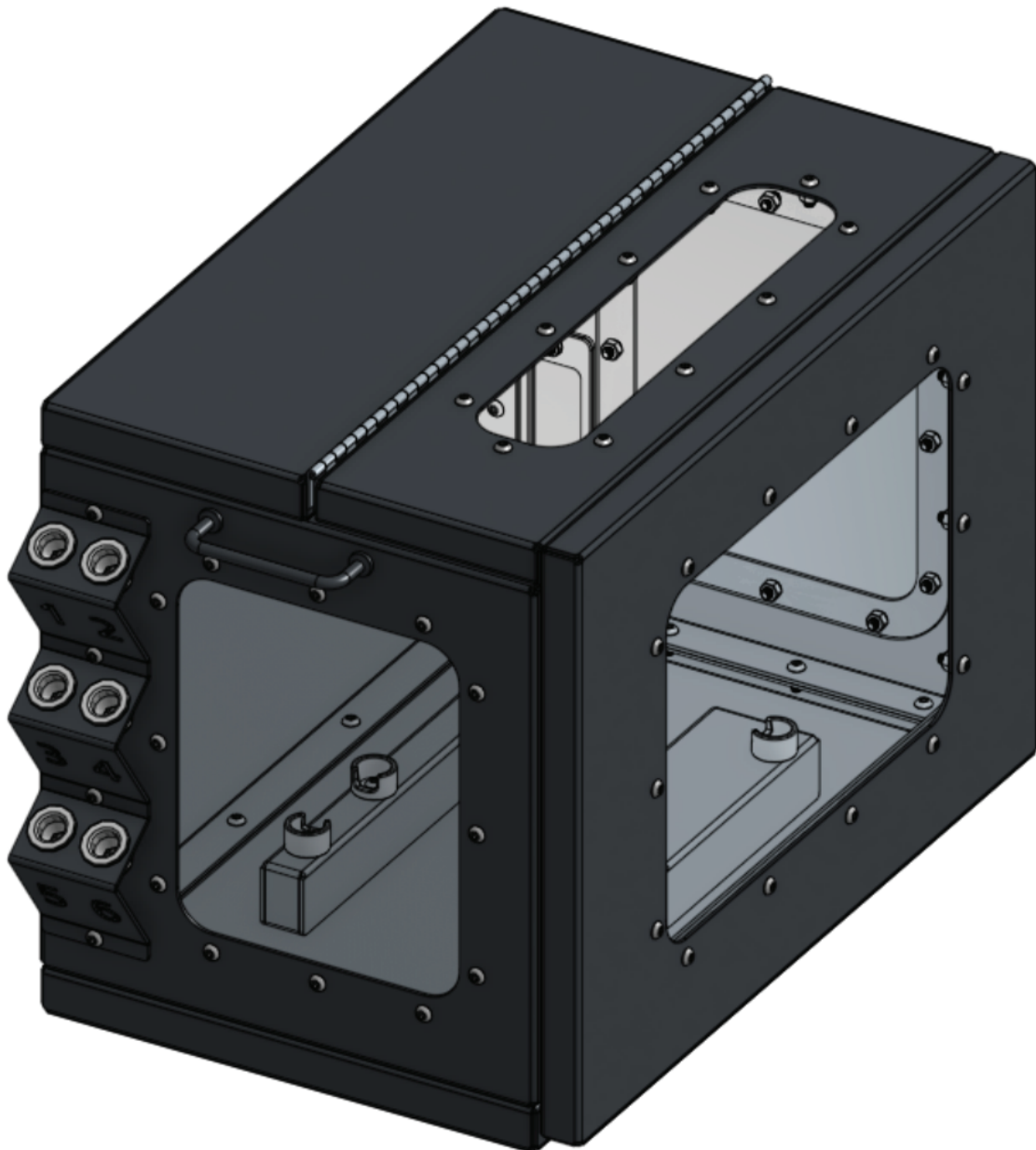




MACHINESUITS





BOM / Key

Tools

- 1/4-20, 6-32 allen key
- 7/16 wrench

Hardware/Misc

- (A) 1/4-20 button head bolt (5/8" long)
- (B) 1/4-20 button head bolt (3/4" long)
- (C) 6-32 countersunk head bolt
- (D) 1/4-20 nylock nut
- (E) Gasket material
- (F) Piano hinge
- (G) Rubber feet

Fab Parts

- (1) Bottom panel
- (2) Back panel
- (3) Left panel
- (4) Right panel
- (5) Top
- (6) Top door panel
- (7) Front door panel
- (8) Tool rack
- (9) Tool cups

Fab Parts cont.

- (10) Tool cup nuts
- (11) Rear riser block
- (12) Front riser block
- (13) Feet cups
- (14) Right window
- (15) Left window
- (16) Front window
- (17) Top window
- (18) Chip deflector
- (19) Port plate

Build Preface

Steps 1-6

- Mount panels

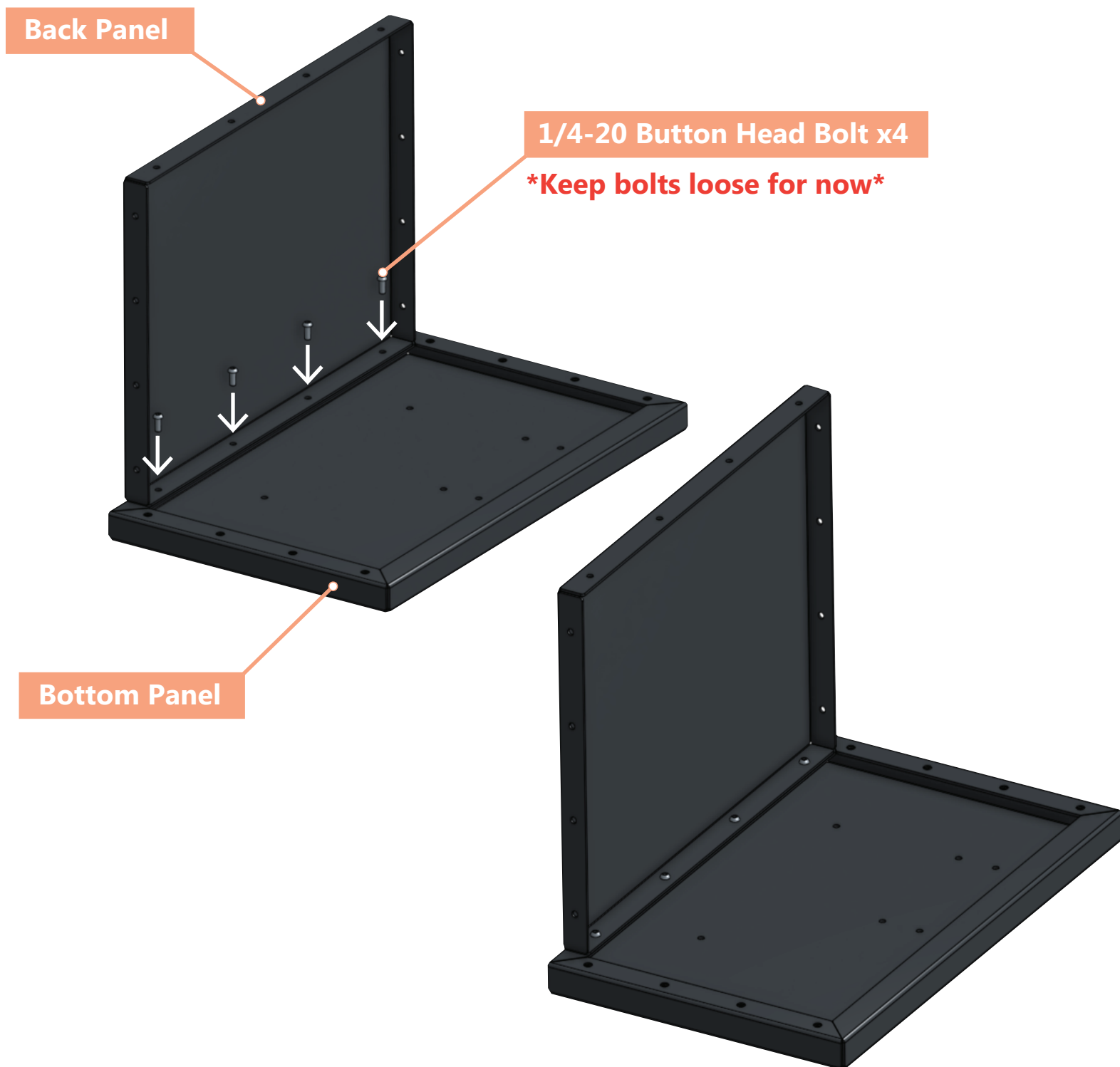
Steps 7-10

- Mount riser blocks
- Assemble tool rack
- Mount tool rack

Steps 11-15

- Attach windows/deflector
- Attach gaskets
- Attach port clamp
- Attach Rubber feet

STEP 1: Attach Back Panel

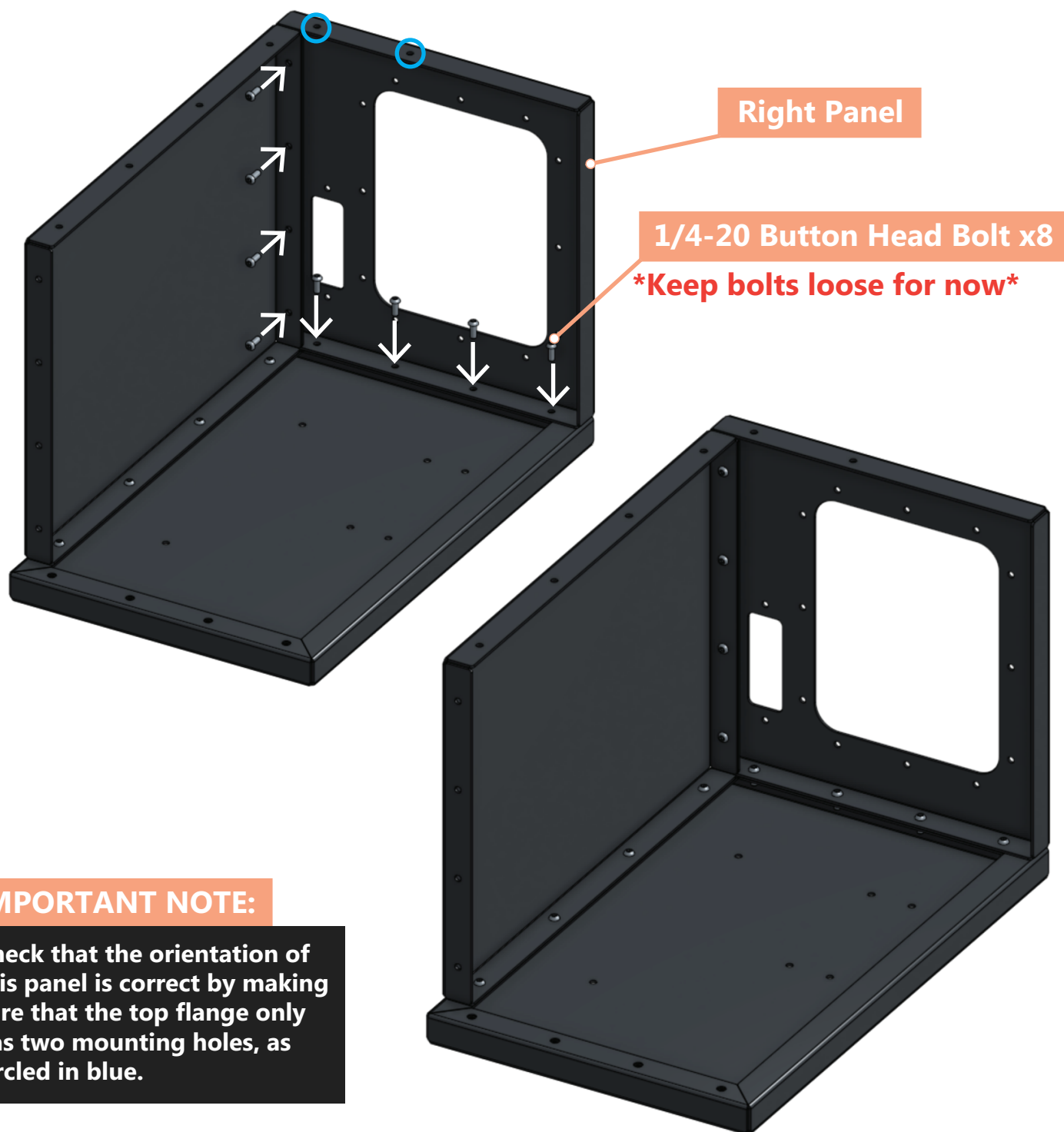


Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Bottom panel, Back panel
1/4-20 button head bolt (5/8") x4

STEP 2: Attach Right Panel



IMPORTANT NOTE:

Check that the orientation of this panel is correct by making sure that the top flange only has two mounting holes, as circled in blue.

Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Right panel, 1/4-20 button head bolt (5/8") x8

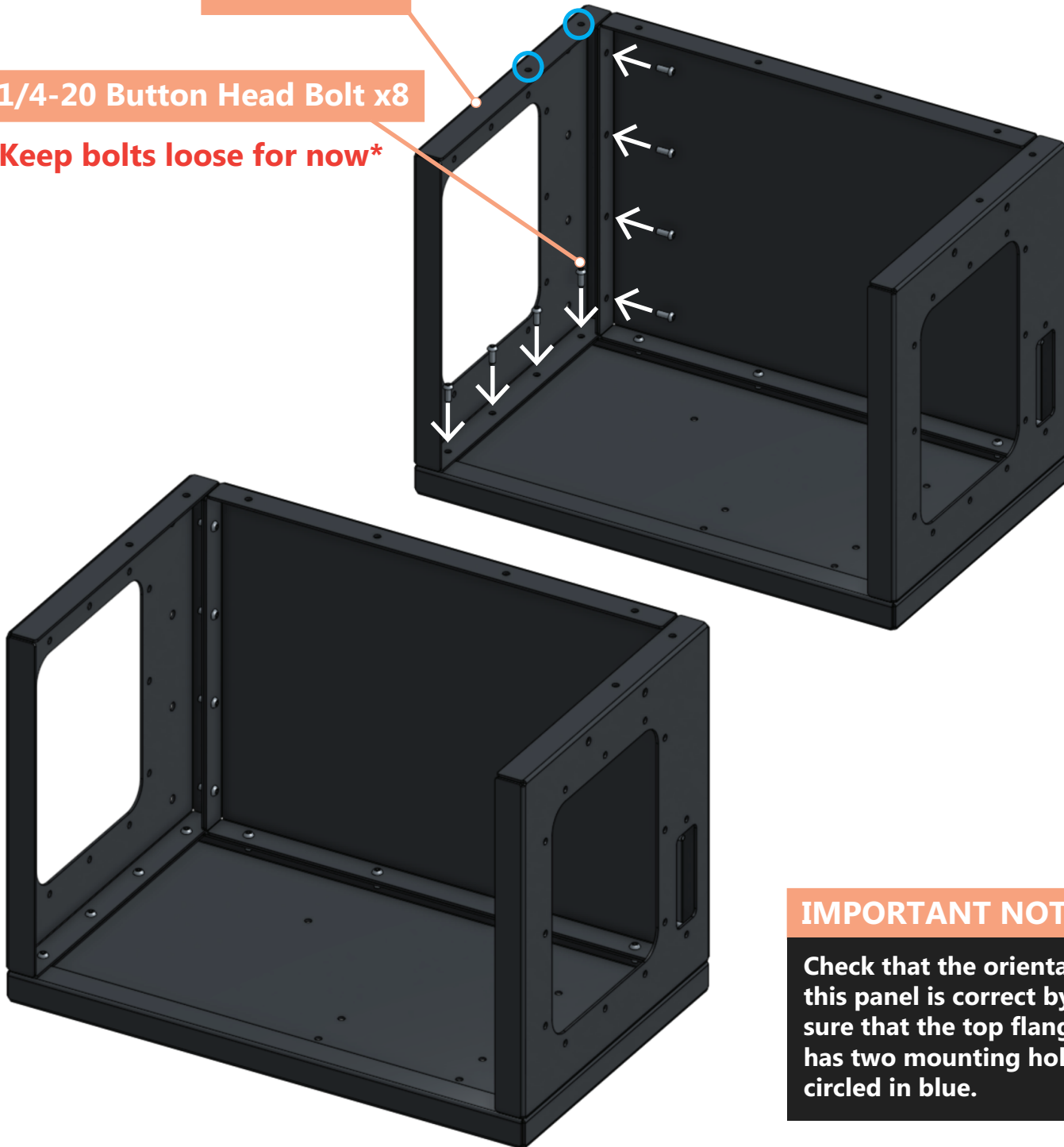
STEP 3: Attach Left Panel



Left Panel

1/4-20 Button Head Bolt x8

Keep bolts loose for now



IMPORTANT NOTE:

Check that the orientation of this panel is correct by making sure that the top flange only has two mounting holes, as circled in blue.

Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Left panel, 1/4-20 button head bolt (5/8") x8

STEP 4: Attach Top Panel

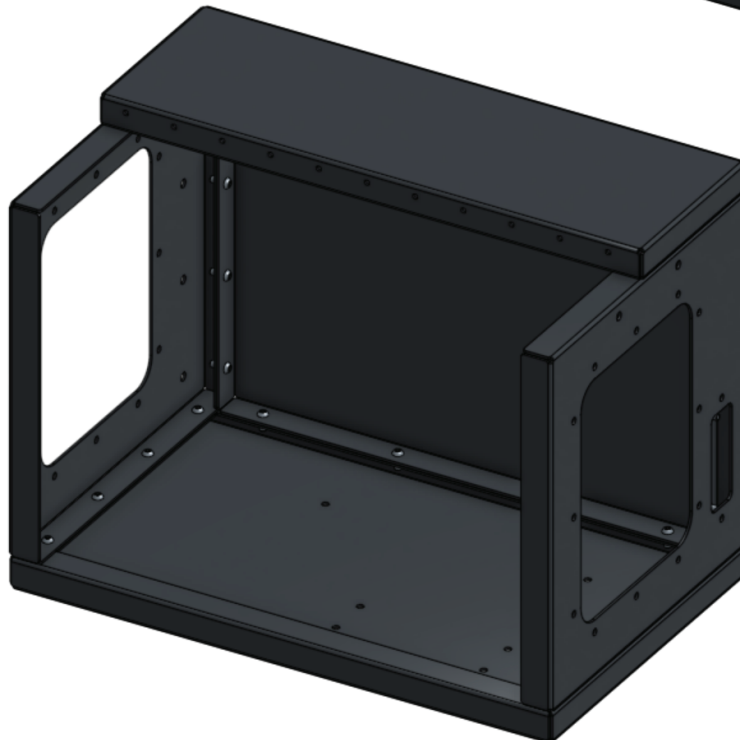
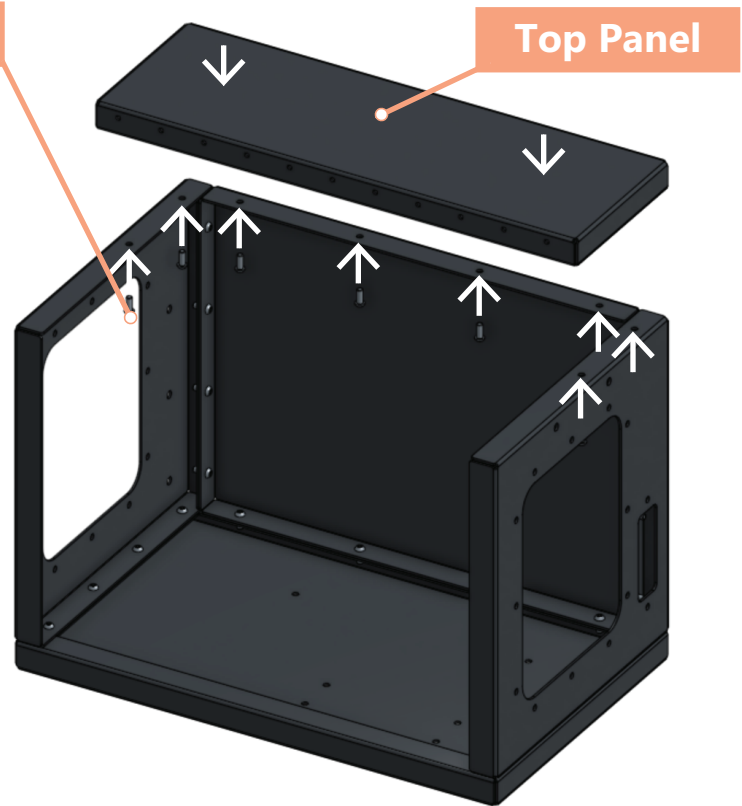


1/4-20 Button Head Bolt x8

Keep bolts loose for now

IMPORTANT NOTE:

Once you have all the bolts in **loose** for this step, you may tighten all of the bolts **fully** for this step and all previous ones.

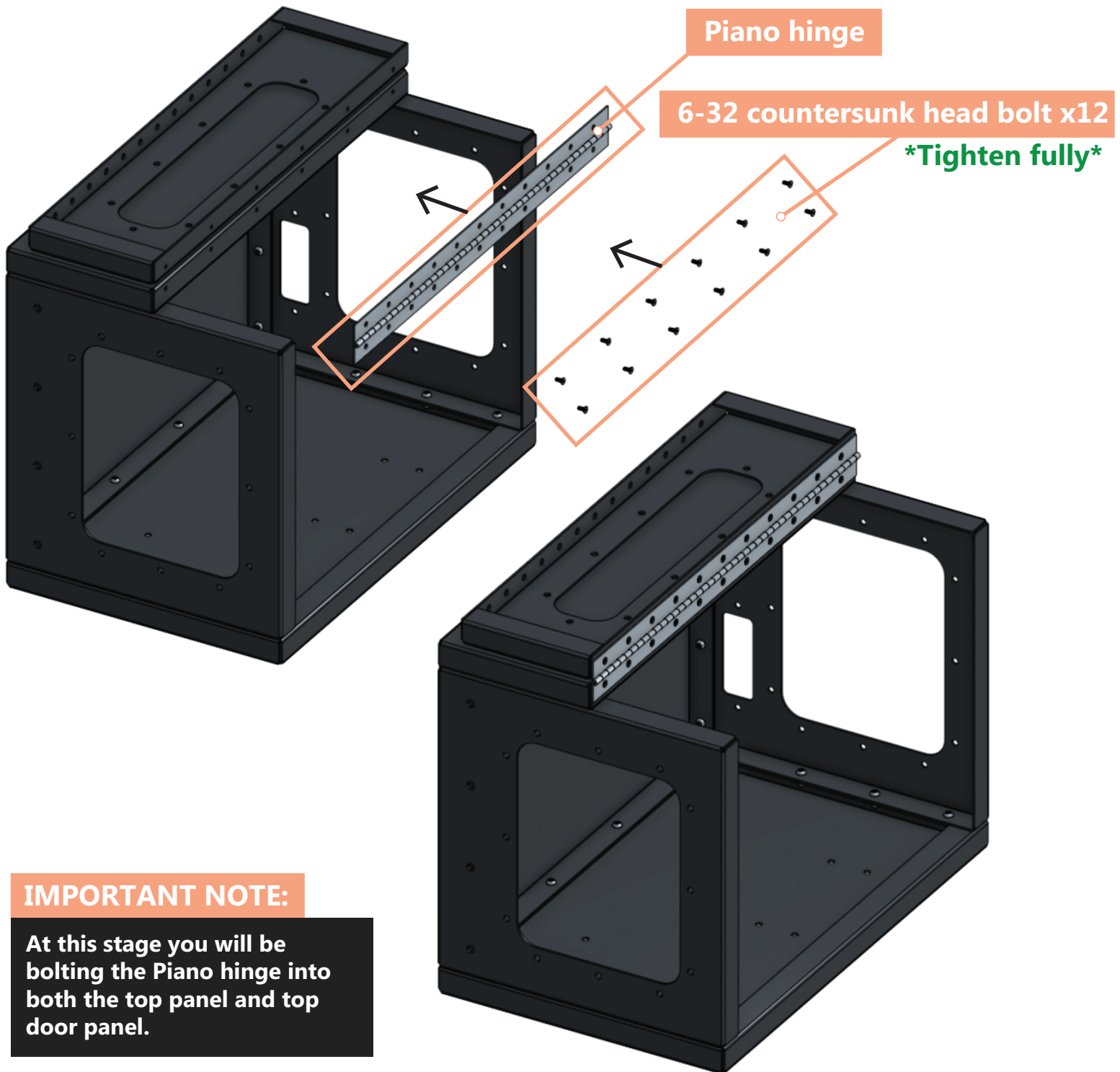


Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Top panel, 1/4-20 button head bolt (5/8") x8

STEP 5: Attach Top Door Panel



Tools/Materials Required:

Tools: 6-32 Allen wrench

Materials: Top door panel, 6-32 countersunk head bolt x12, Piano hinge

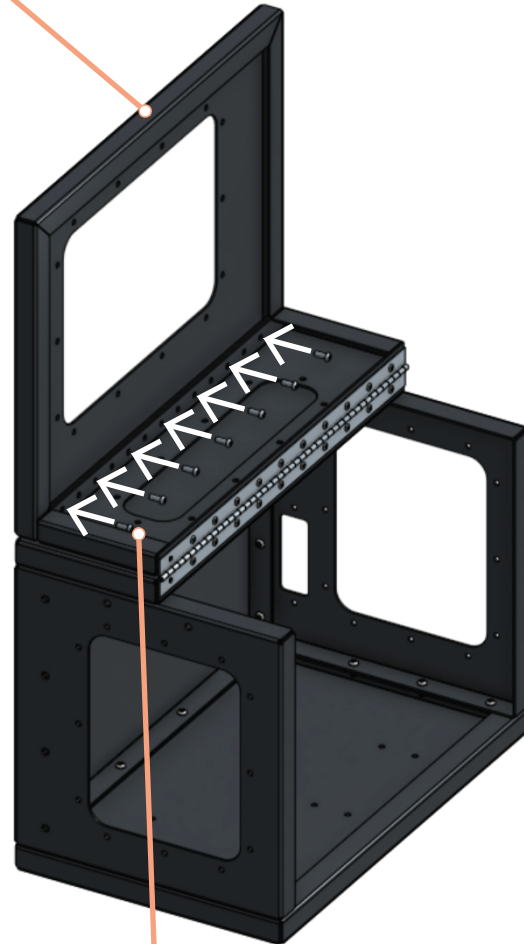
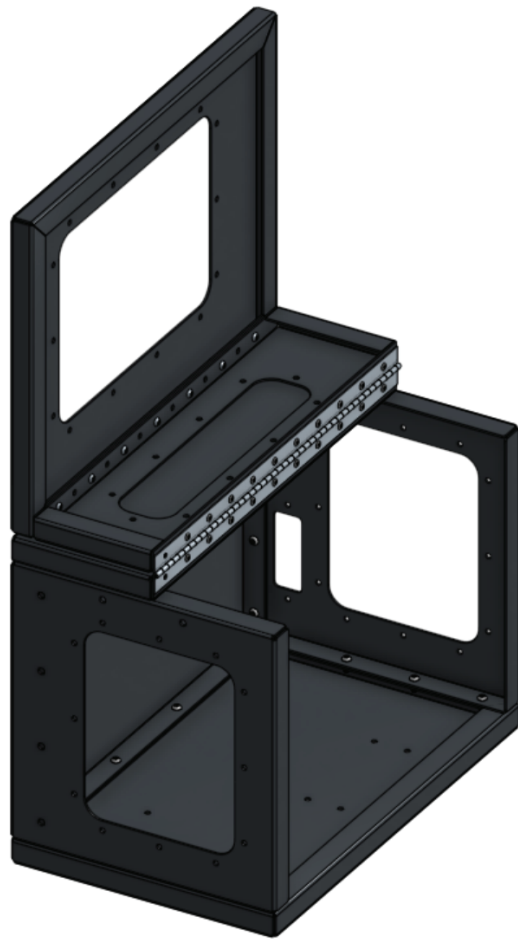
STEP 6: Attach Front Door Panel



Front Door Panel

IMPORTANT NOTE:

Not every bolt hole here must be used. It is recommended to use a fastener at every other bolt hole.



1/4-20 Button Head Bolt x7

Tighten fully

IMPORTANT NOTE:

Fold the top door panel all the way back for this step.

Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Top/top door panel, 1/4-20 button head bolt (5/8") x7

STEP 7: Feet Cups & Riser Blocks

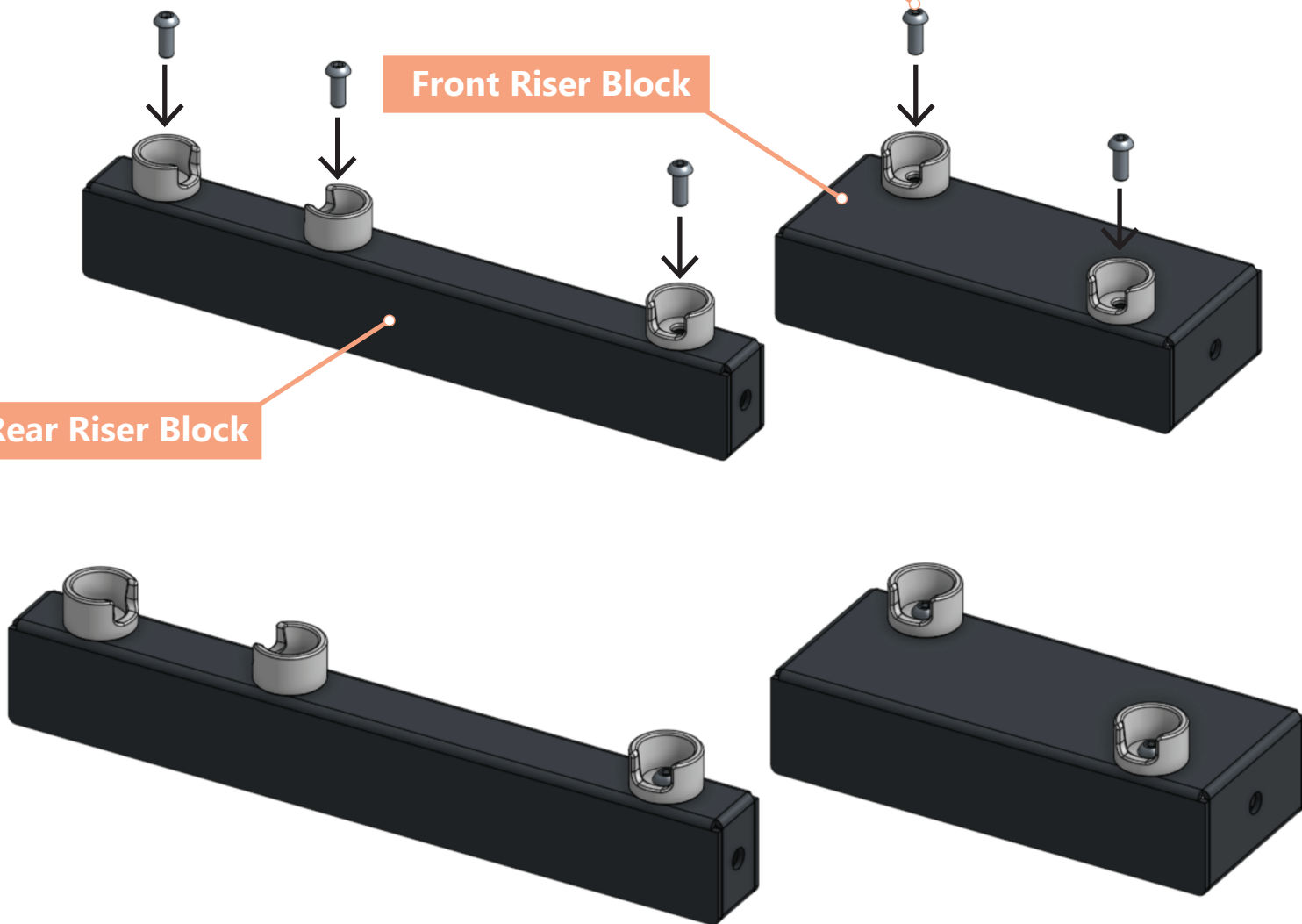


1/4-20 Button Head Bolt x5

Tighten fully

Front Riser Block

Rear Riser Block

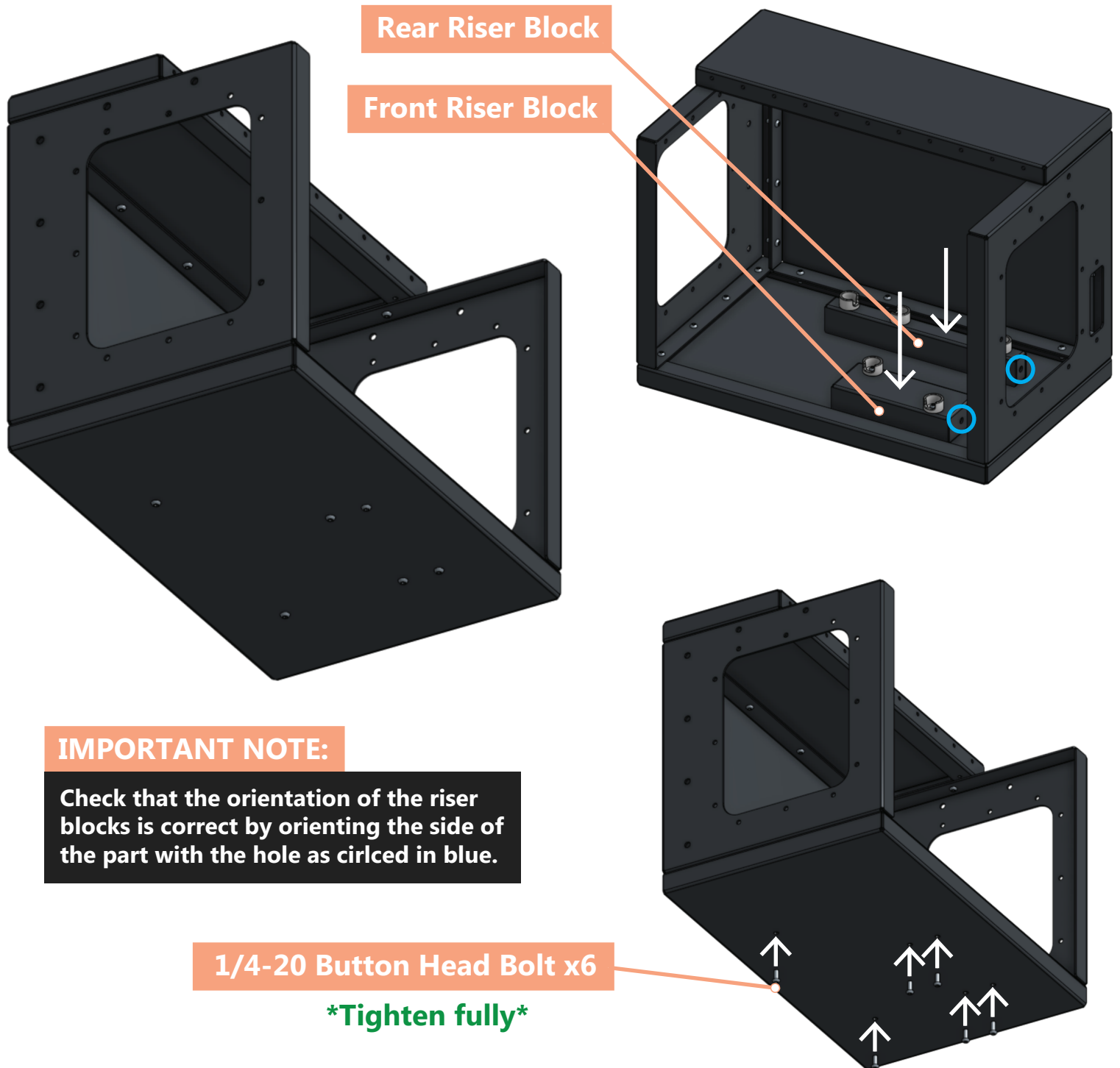


Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Front riser block, Rear riser block, Feet cups x5, 1/4-20 button head bolt (5/8") x5

STEP 8: Attach Riser Blocks



IMPORTANT NOTE:

Check that the orientation of the riser blocks is correct by orienting the side of the part with the hole as circled in blue.

1/4-20 Button Head Bolt x6

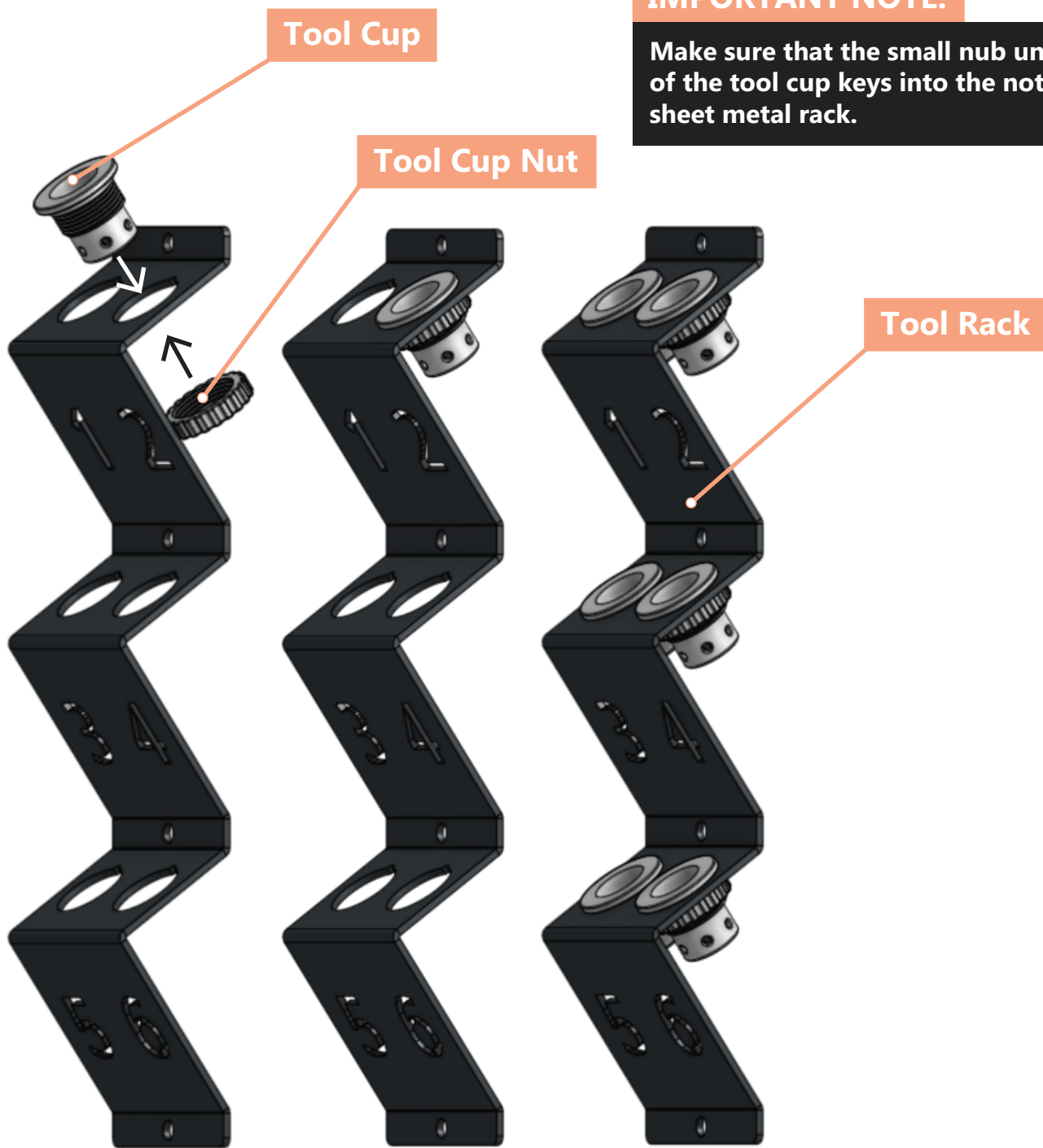
Tighten fully

Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Front riser block, Rear riser block, 1/4-20 button head bolt (5/8") x6

STEP 9: Assemble Tool Holder

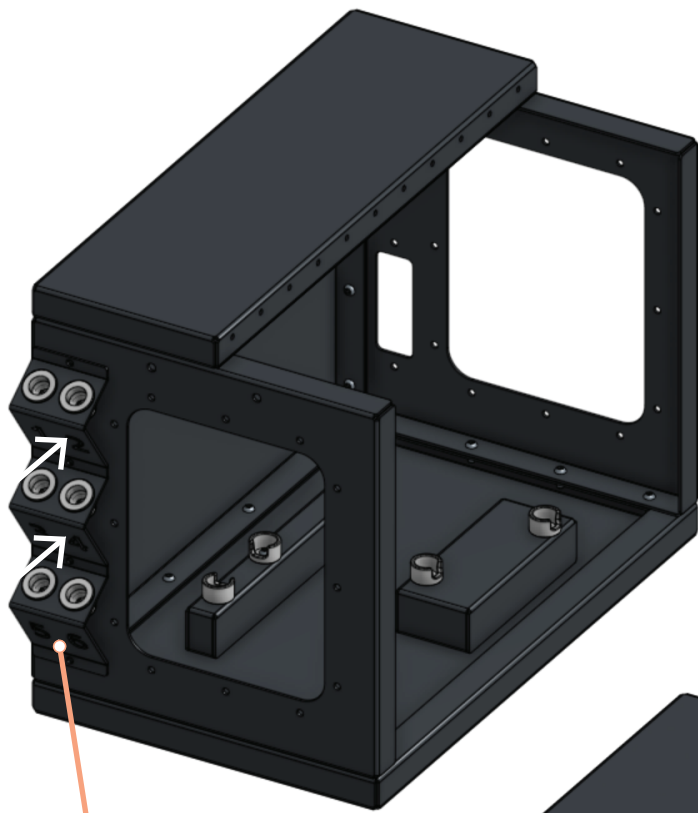


Tools/Materials Required:

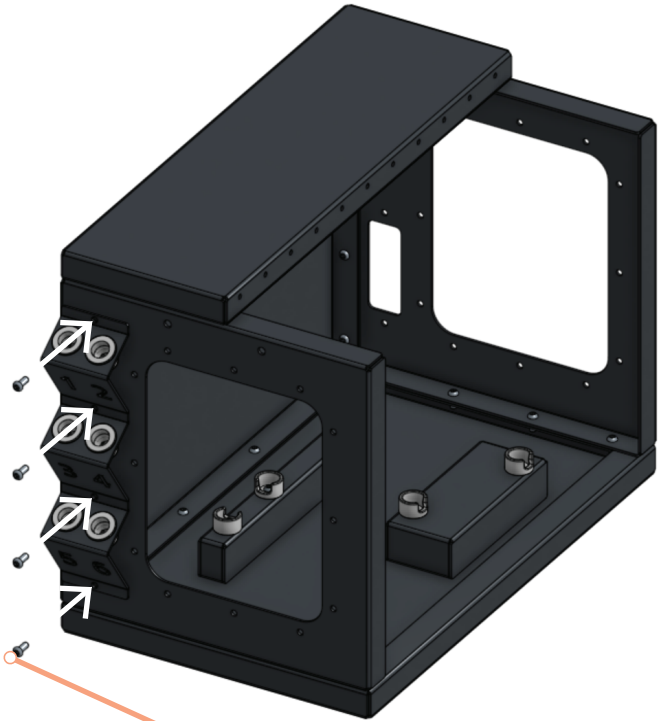
Tools: None

Materials: Tool rack, Tool cup x6, Tool cup nut x6

STEP 10: Mount Tool Holder

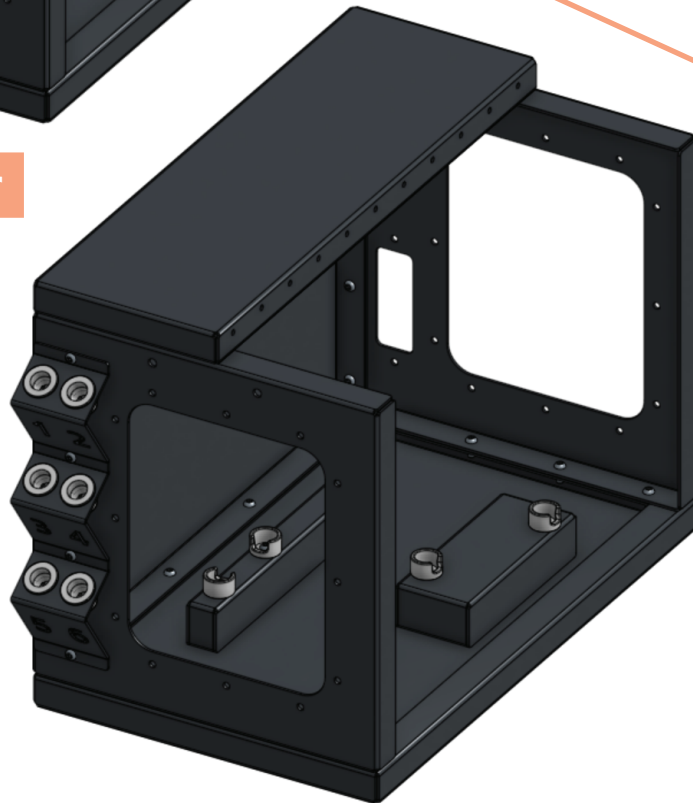


Tool Holder



1/4-20 Button Head Bolt x4

Tighten fully

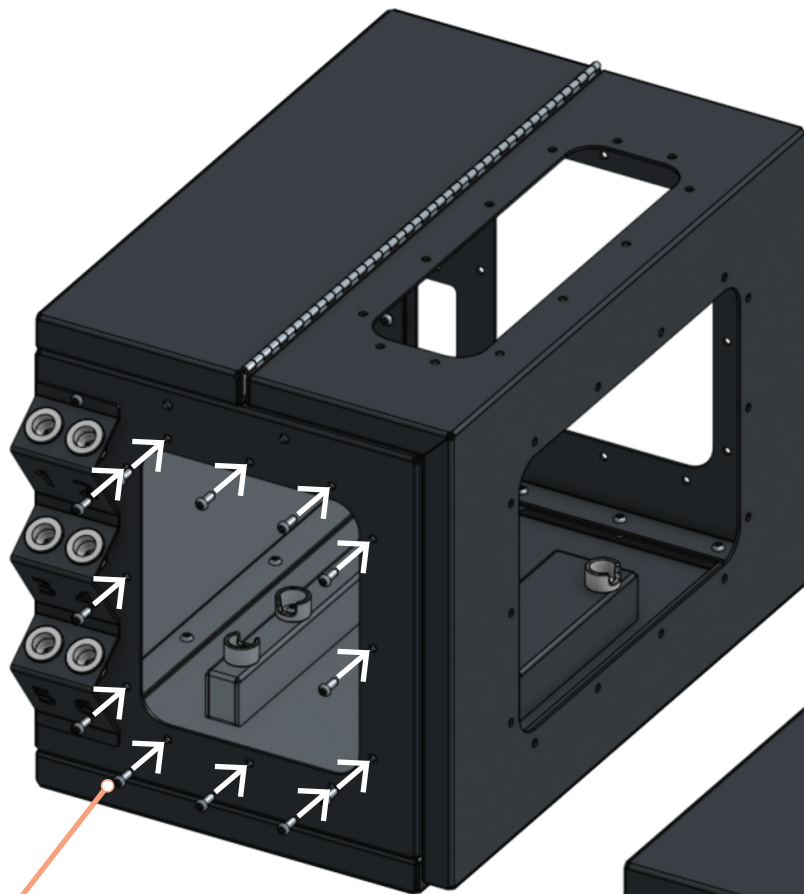


Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Tool holder, 1/4-20 button head bolt (5/8") x4

STEP 11: Windows! Right, Left & Top



IMPORTANT NOTE:

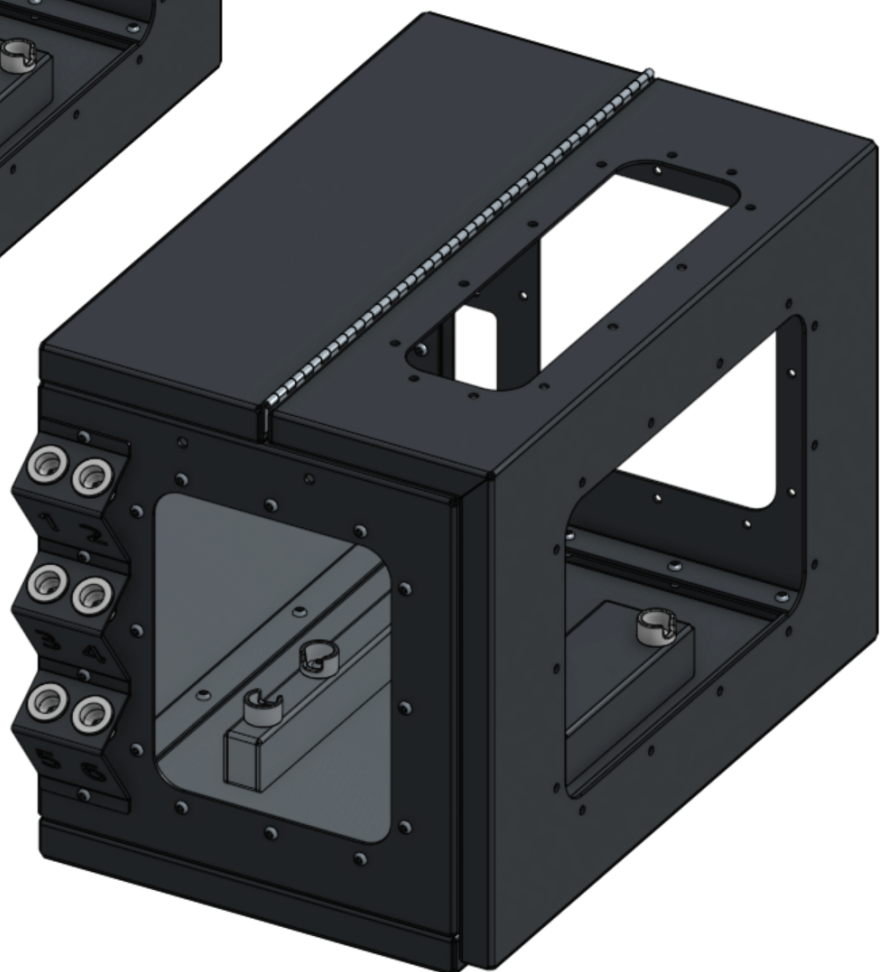
Make sure to attach the windows to the inside of the enclosure panels, and to attach an 1/4-20 nylock nut to the end of each bolt.

1/4-20 Button Head Bolt x36

Tighten fully

IMPORTANT NOTE:

Repeat this process for the right side window and top window.

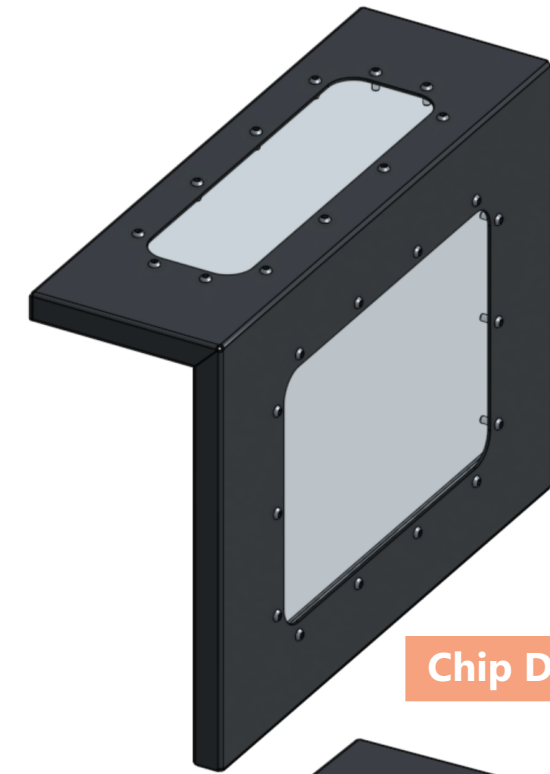


Tools/Materials Required:

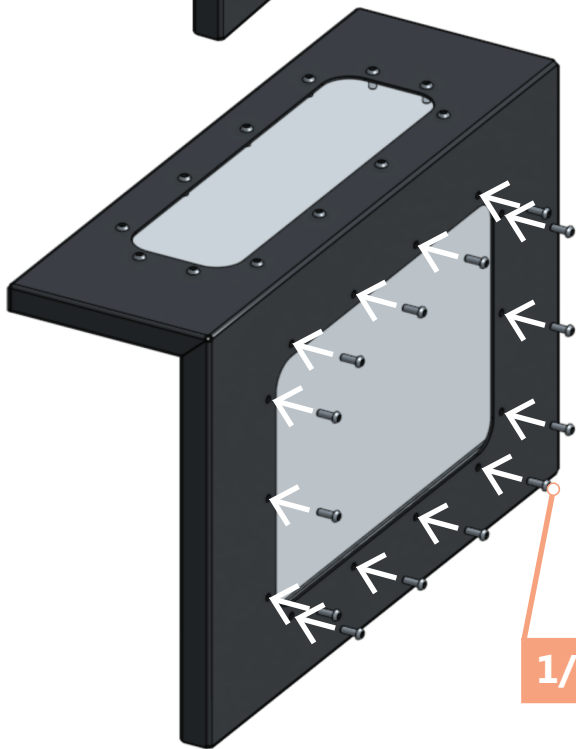
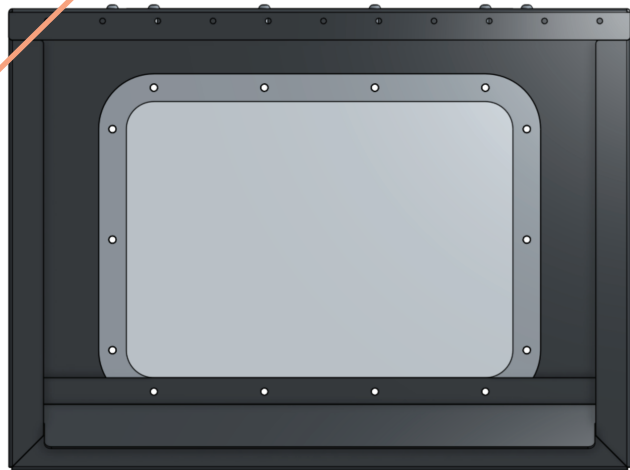
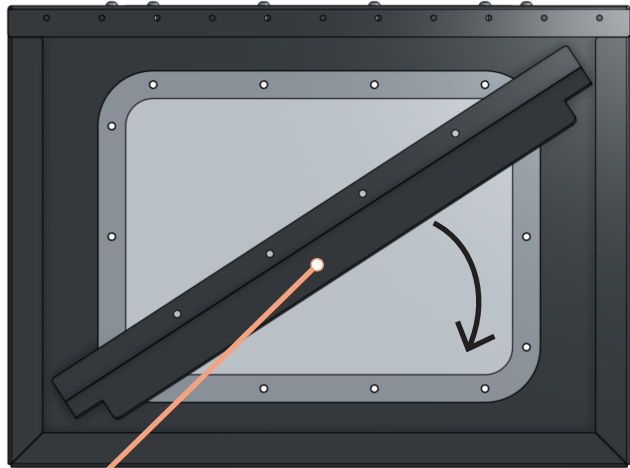
Tools: 1/4-20 Allen wrench,
7/16 wrench

Materials: Left window, Right window, Top window,
1/4-20 button head bolt (5/8") x36,
1/4-20 nylock nut x36

STEP 12: Chip Deflector & Front



Chip Deflector



1/4-20 Button Head Bolt x14

IMPORTANT NOTE:

Make sure to attach the windows to the inside of the enclosure panels, and to attach an 1/4-20 nylock nut to the end of each bolt.

IMPORTANT NOTE:

Insert chip deflector after window. To insert the chip deflector into the door panel, you must first rotate it to about 30 degrees, then set it in and rotate it back down to horizontal.

Tighten fully

Tools/Materials Required:

Tools: 1/4-20 Allen wrench, 7/16 wrench

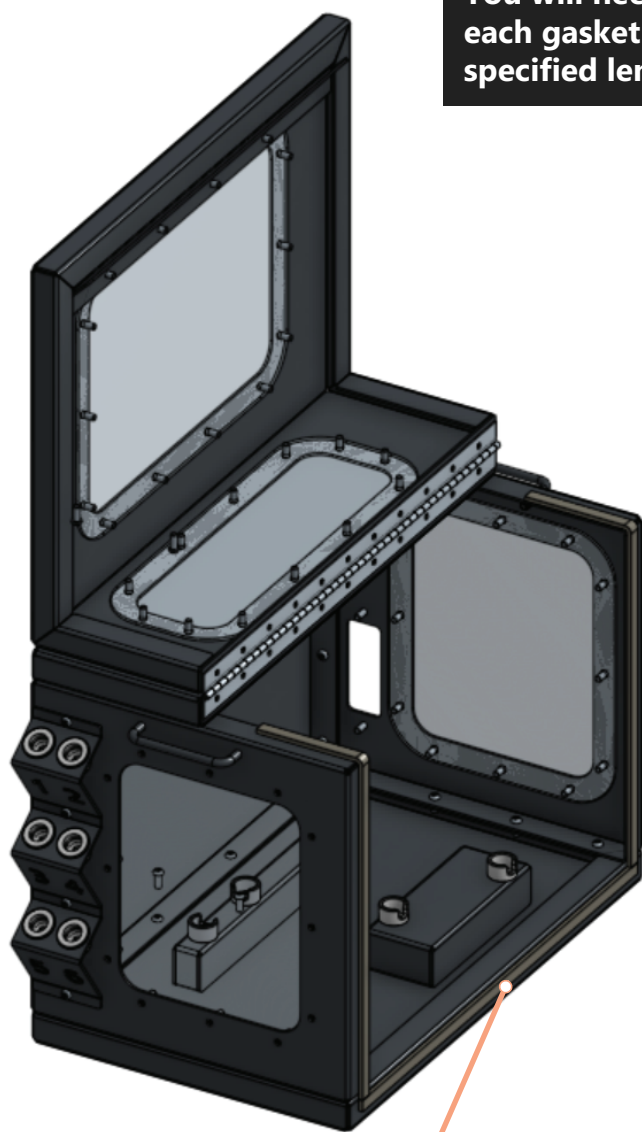
Materials: Front window, Chip deflector, 1/4-20 button head bolt (5/8") x14, 1/4-20 nylock nut x14

STEP 13: Attach Gasket Pieces

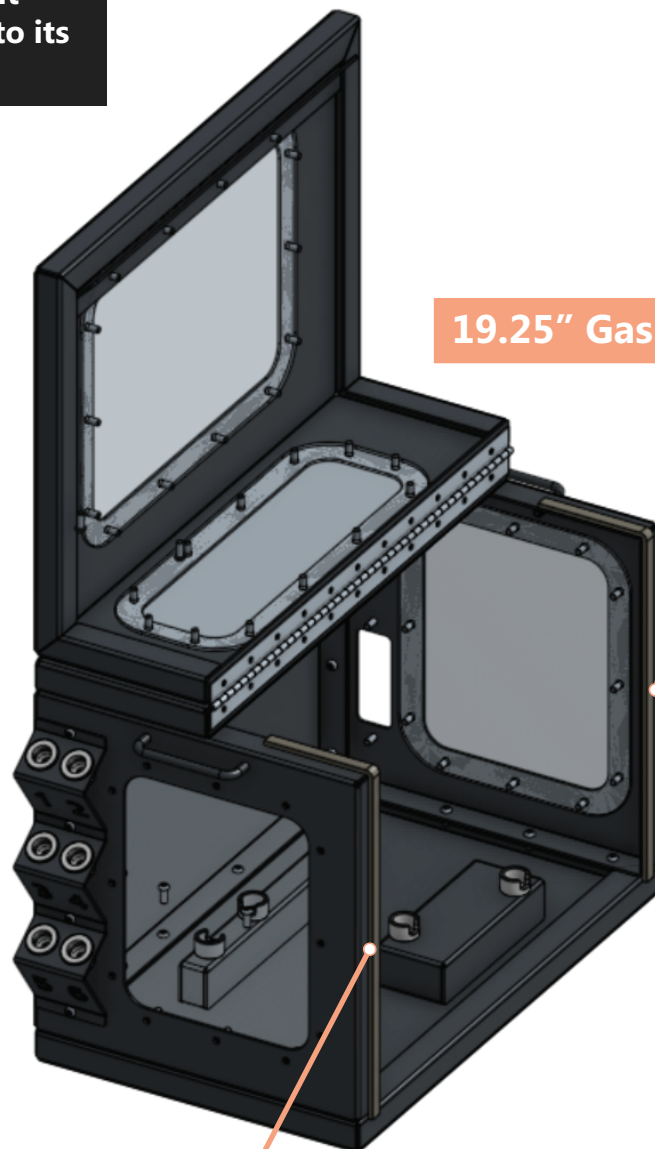


IMPORTANT NOTE:

You will need to cut each gasket piece to its specified length.



21" Gasket



19.25" Gasket

19.25" Gasket

Tools/Materials Required:

Tools: None

Materials: 21" gasket x1, 19.25" gasket x2

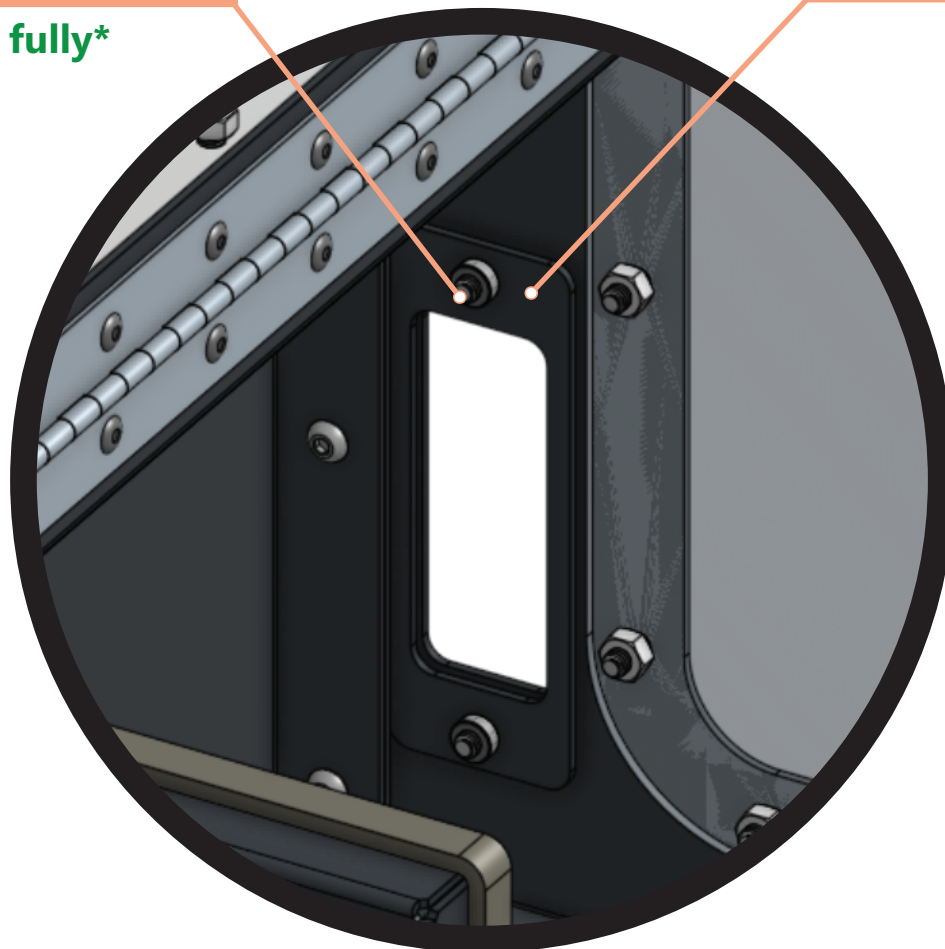
STEP 14: Port or Pass-through



1/4-20 Button Head Bolt x2

Tighten fully

Port Clamp



IMPORTANT NOTE:

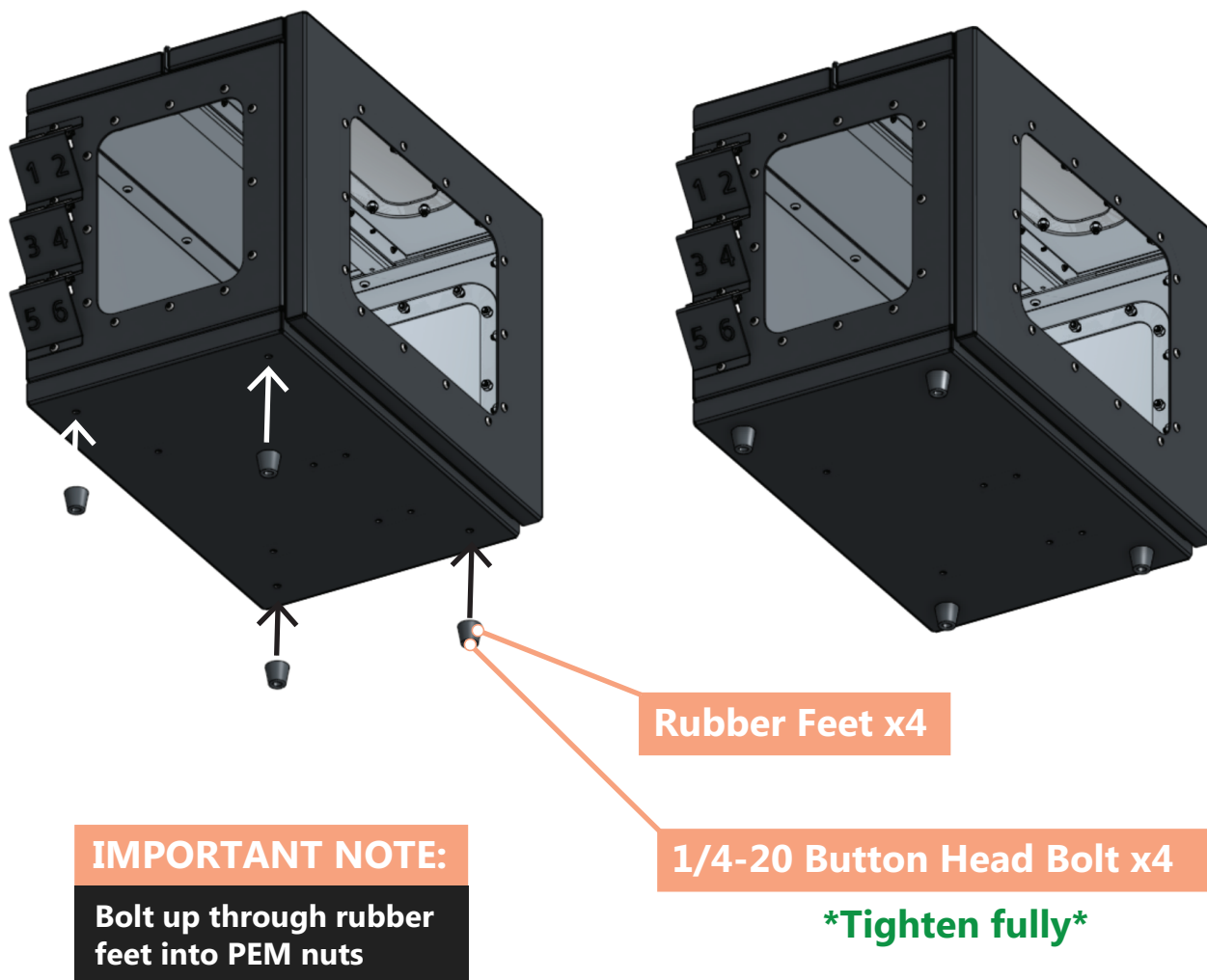
Between the port clamp and the inside face of the right panel, you may clamp any custom cable interface you like or leave it open just as a pass-through.

Tools/Materials Required:

Tools: 1/4-20 Allen wrench

Materials: Port clamp, 1/4-20 Button head bolt (5/8") x2

STEP 15: Rubber Bumpers and Feet



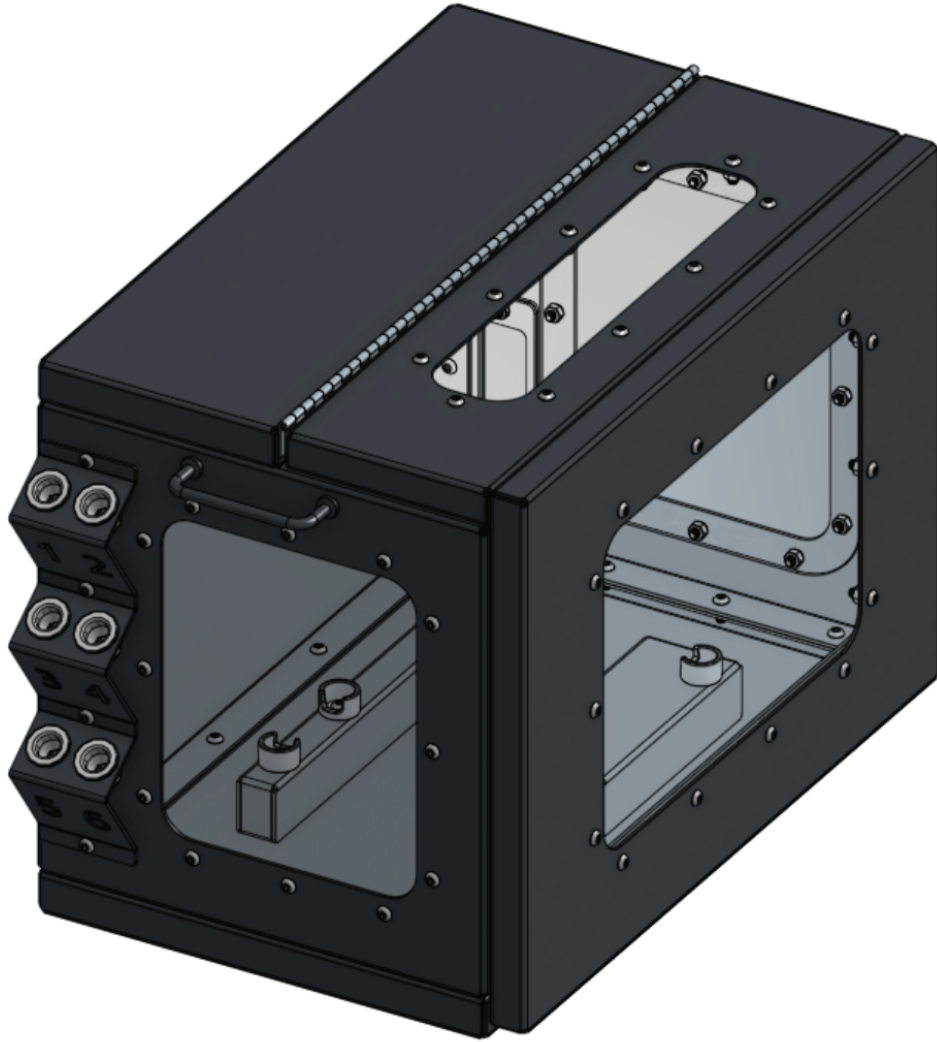
Tools/Materials Required:

Tools: None

Materials: Rubber Feet x4, 1/4-20 Button head bolt (3/4") x4



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COMPLETED!