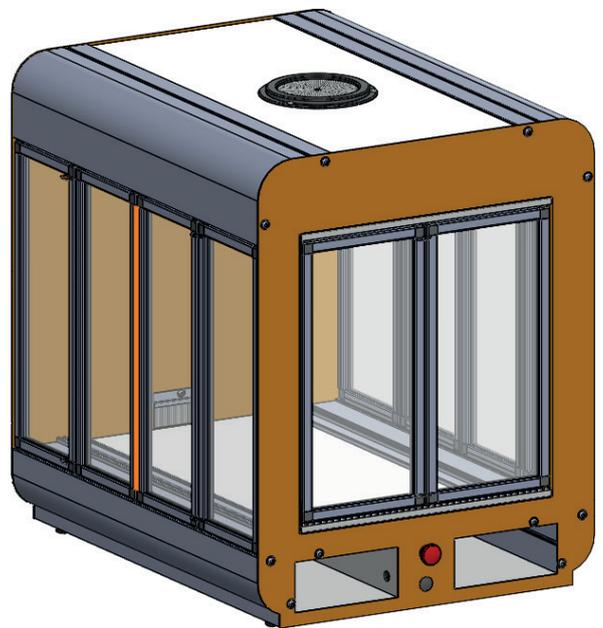


EASYBUILD- ASSEMBLY MANUAL

ENCLOSURE FOR DESKTOP CNC /3D SYSTEMS STEP-CRAFT 300/ 420



Original assembly manual
date of 01.07.2017

Dear customer,

thank you very much for purchasing our high-quality kit of an enclosure of your **STEPCRAFT** Desktop CNC /3D System. This manual will take you through every step of the assembly.

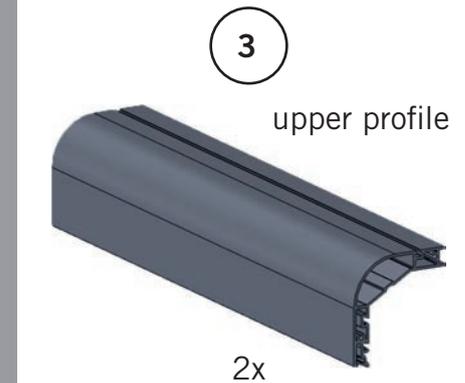
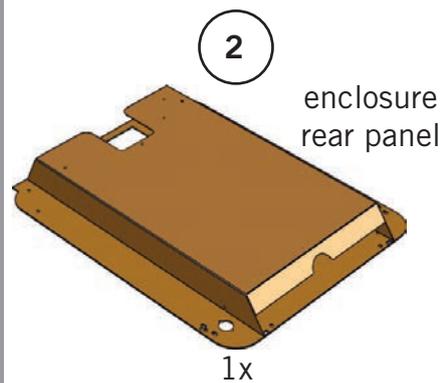
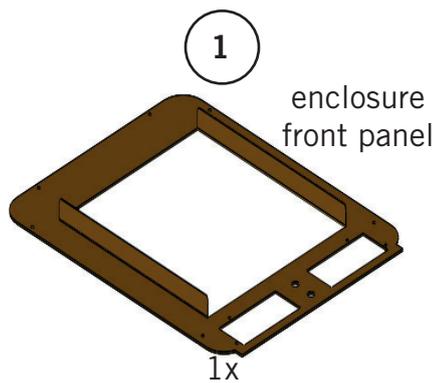
Please read the entire manual carefully before starting assembly. This way, you obtain an overview of the steps required which will help you avoid unnecessary mistakes. Please take care to use the the correct parts in the correct orientation as some parts differ only minimally. Please let a second person assist you in the assembly.

Before beginning the assembly process, please verify that you have all of the required parts in your kit using the list below. **STEPCRAFT** provides video support with certain assembly steps. Simply scan the related QR code with your smartphone. If you do not have a smartphone, please enter the following URL in your web browser:

www.stepcraft-systems.com/enclosure/xx-xx (replace xx-xx with the number under the QR code).

STEPCRAFT has taken extreme care to ensure the correctness of the information contained in this manual. We accept no liability for damage in materials or injury to persons caused by assembling the enclosure. You are responsible for the safe operation of your **STEPCRAFT** Desktop CNC /3D System and its accessories.

Content of the construction kit (illustrations are not true to scale)



10

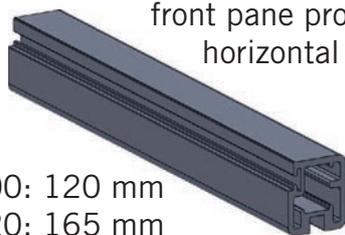
front pane profile
vertical with
handle



300: 302 mm
420: 372 mm
1x

11

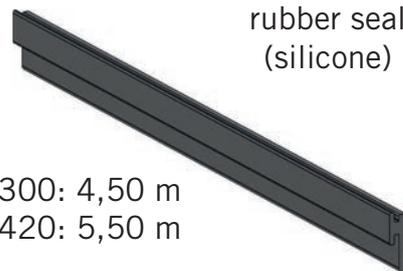
front pane profile
horizontal



300: 120 mm
420: 165 mm
4x

12

rubber seal
(silicone)

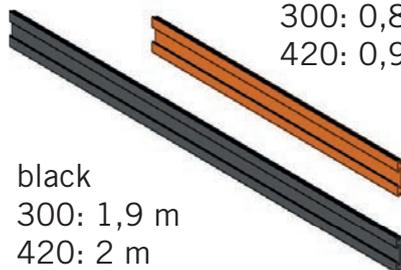


300: 4,50 m
420: 5,50 m

connection
profile
(silicone)

13

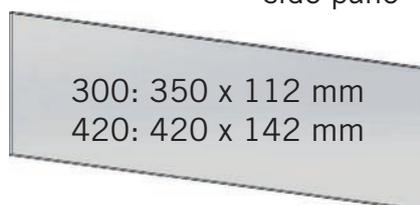
orange
300: 0,8 m
420: 0,9 m



black
300: 1,9 m
420: 2 m

14

side pane

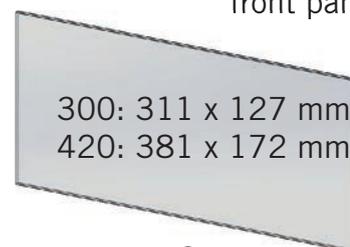


300: 350 x 112 mm
420: 420 x 142 mm

8x

15

front pane

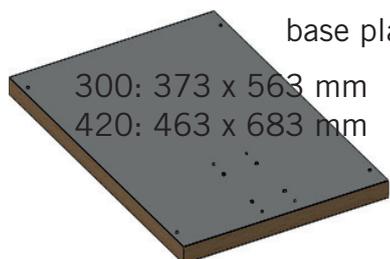


300: 311 x 127 mm
420: 381 x 172 mm

2x

16

base plate



300: 373 x 563 mm
420: 463 x 683 mm

1x

17

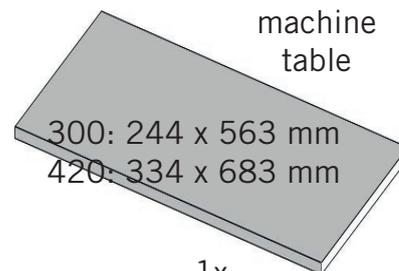
base plate partition



300: 0x
420: 2x

18

machine
table

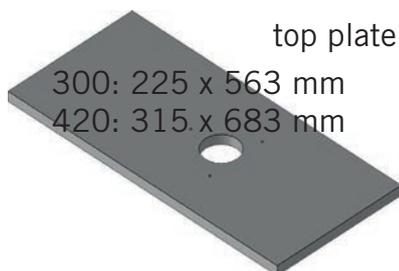


300: 244 x 563 mm
420: 334 x 683 mm

1x

19

top plate



300: 225 x 563 mm
420: 315 x 683 mm

1x

20

plastic corner



45x

21

circular brush



1x

22

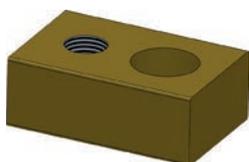
strip brush
cable outlet



1x

23

slot nut,
lockable



6x

24

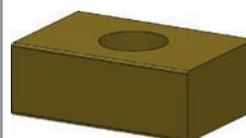
slot nut, loose



4x

25

slot nut, loose
external



6x

26

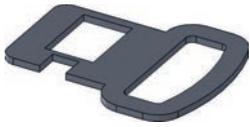
pivot pin



20x

27

door handle



10x

28

pressure pin



10x

29

plastic foot



4x

30

socket head screw,
M6 x 30 mm



4x

31

socket head screw,
M5 x 30 mm



6x

32

flange screw,
M5 x 12 mm



2x

33

flange screw,
M6 x 20 mm



20x

34

set screw,
M4 x 5 mm



6x

35

locking nut,
M5



6x

36

spacer
M3 x 10 mm



2x

37

spacer,
M5 x 50 mm



1x

38

button head
cap screw,
M3 x 6 mm



4x

39

wooden dowel



300: 0x
420: 4x

40

cam lock screw



300: 0x
420: 4x

41

cam screw



300: 0x
420: 4x

42

end switch with
cable supply



3x

43

cable conduit
6/4 mm



2,60 m

44

emergency switch



1x

45

emergency switch
cable



300: 0,75 m
420: 0,88 m

46

controller board



1x

47

hole plug
8 mm



1x

48

hole plug
36 mm



1x

49

15 pin Sub-D
cable



1x

50

wood screw
3,5 x 15 mm



3x

51

grounding cable
set incl. serrated
lock washer



1x

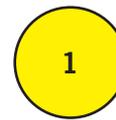
Explanation of symbols and details:



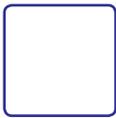
= assembly phase



= assembly group



= work step



= view of assembly phase



= required parts for this work step



= larger detailed view/
pre-assembly of parts



= Tighten the screw.



= Engage the screw, but do not tighten.



= Caution! Work particularly careful.



= Tighten clockwise.



= Remove protection film and affix self-adhesive part.



= Fasten part with superglue, use sparingly, must not get on bearing or running surface.



= Deburring.



= Apply dish liquid as shown in picture.

Required tools and materials:



- Needle file (supplied)
- Allen wrench 2,0 mm
- Allen wrench 3,0 mm
- Allen wrench 4,0 mm
- Allen wrench 5,0 mm

- Spanner 5,5 mm
- Spanner 8 mm
- Rubber mallet
- Crosstip screwdriver
- Superglue

Differences in the assembly of size 300 and 420:

The illustrations in this assembly manual are exemplary and are based on the enclosure for size 420.

The assembly group A as well as the work steps 1.1 and 1.2 do not apply with size 300!

Please pay attention to the different dimensions of the individual parts!



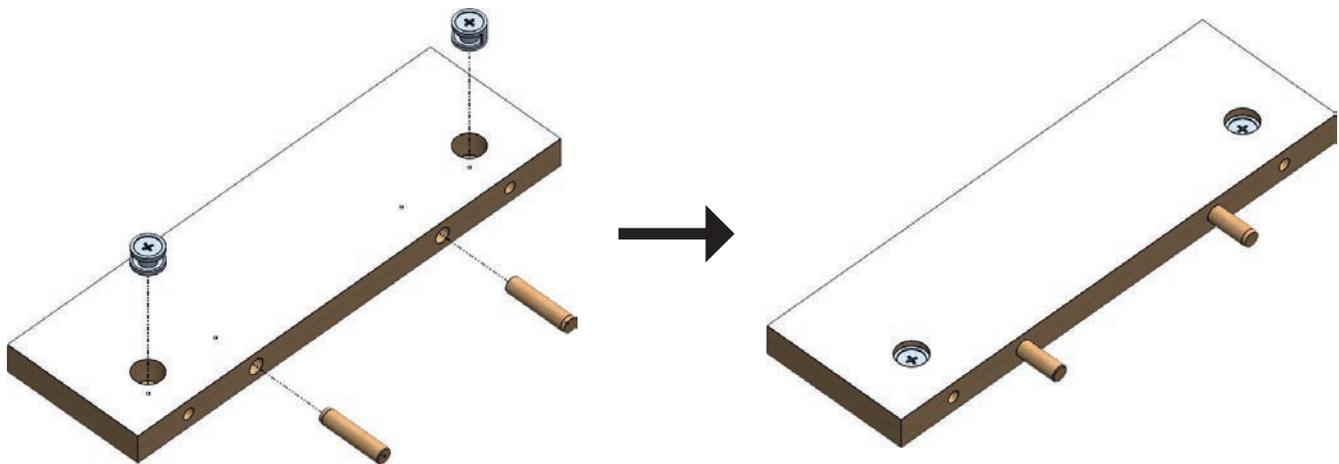
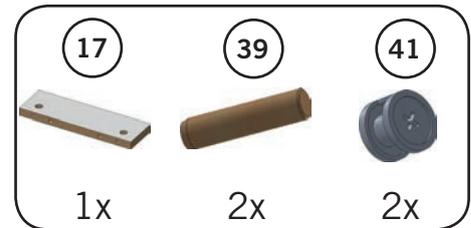
1



Base frame

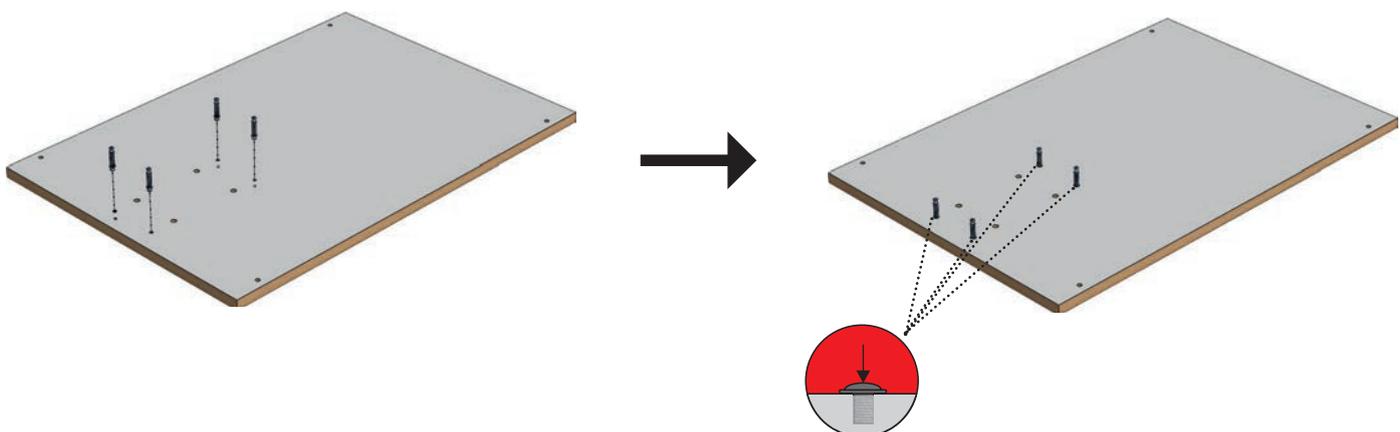
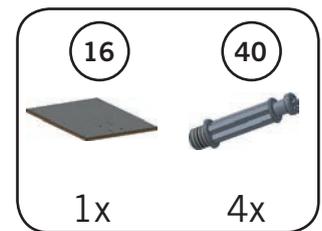
Assembly group A and work steps 1.1 and 1.2 only apply for size 420!

A

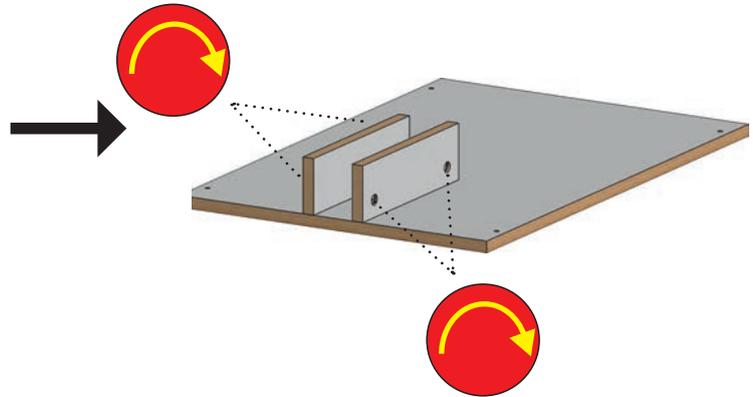
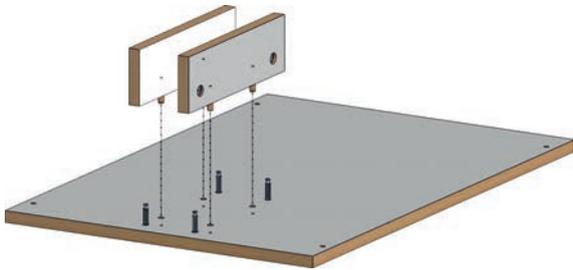


! Please produce 2x !

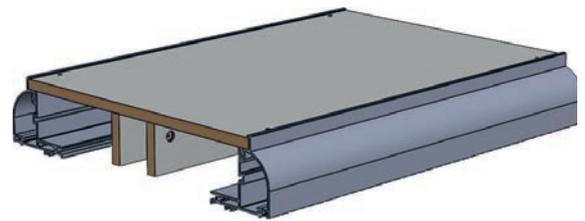
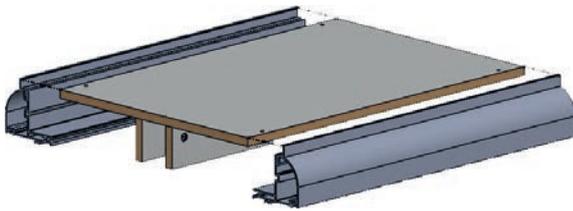
1.1



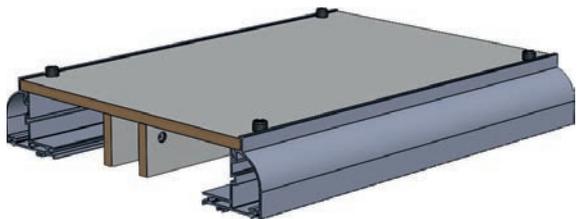
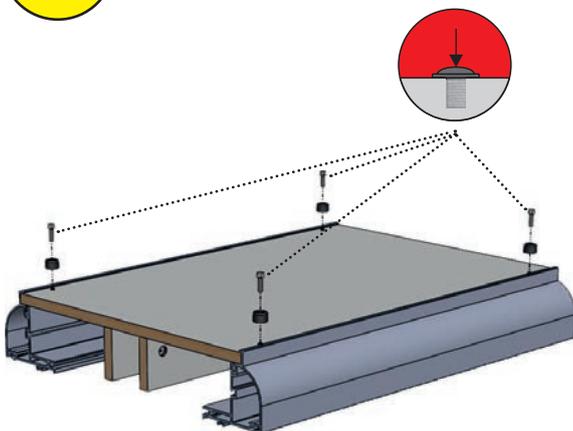
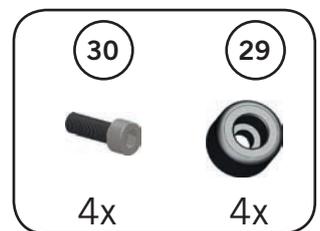
1.2



1.3

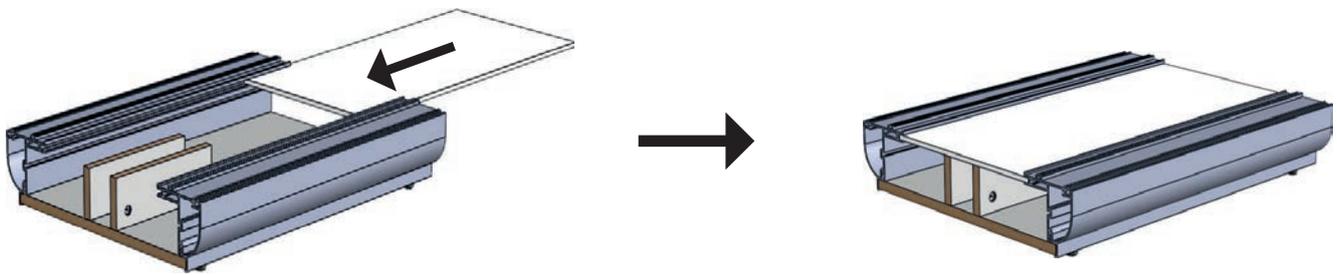


1.4



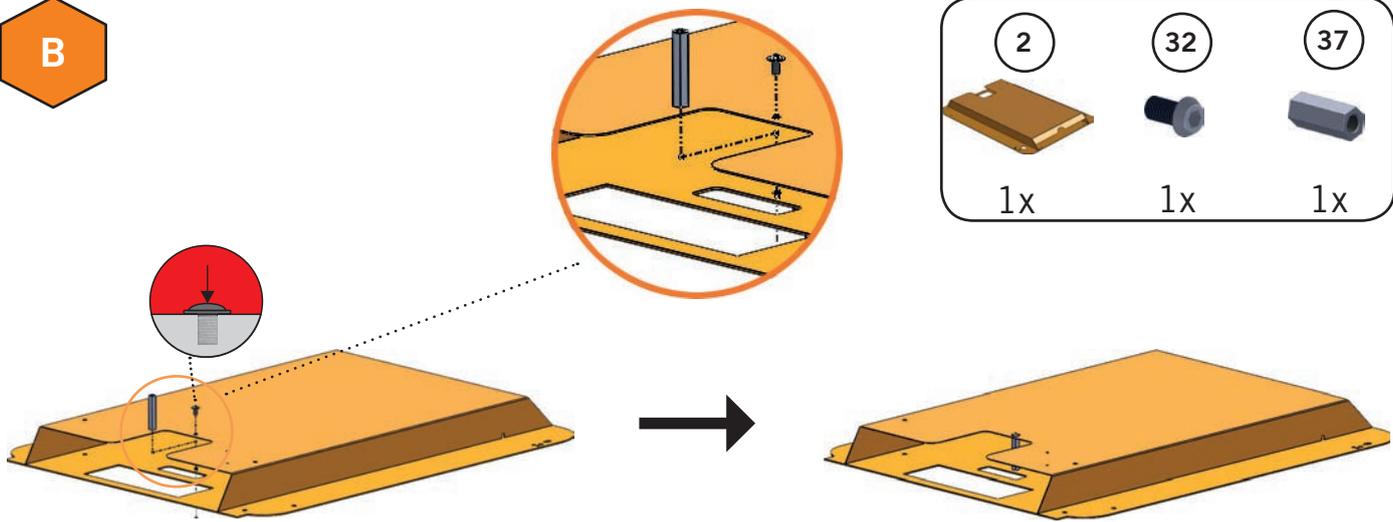
1.5

18
1x



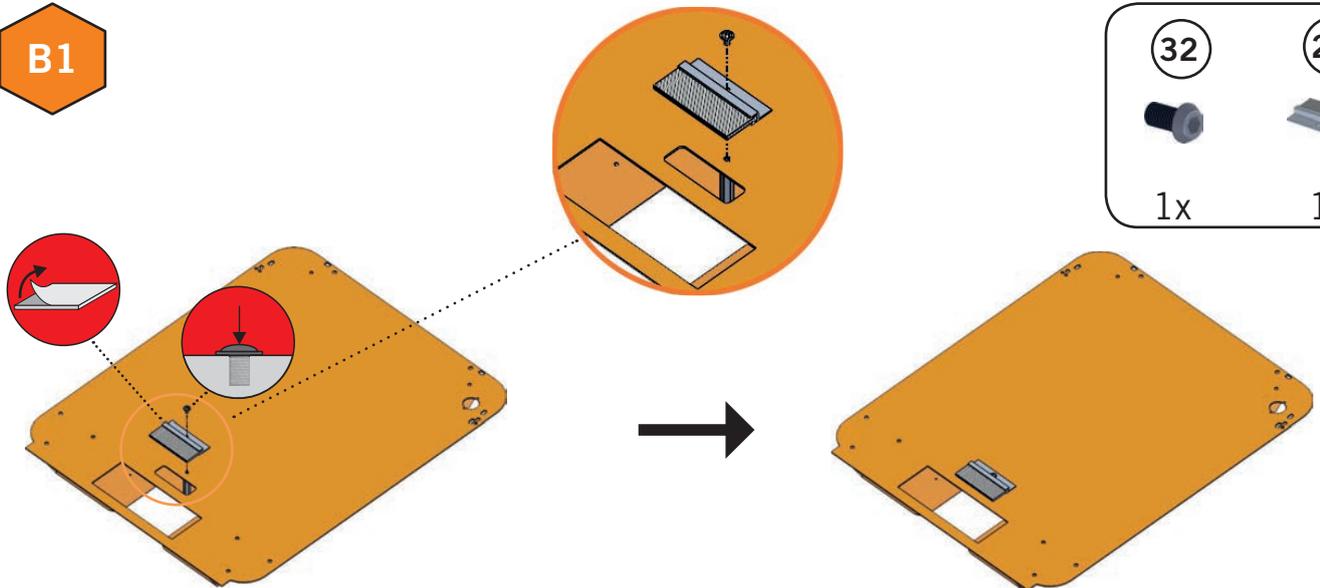
B

2 32 37
1x 1x 1x

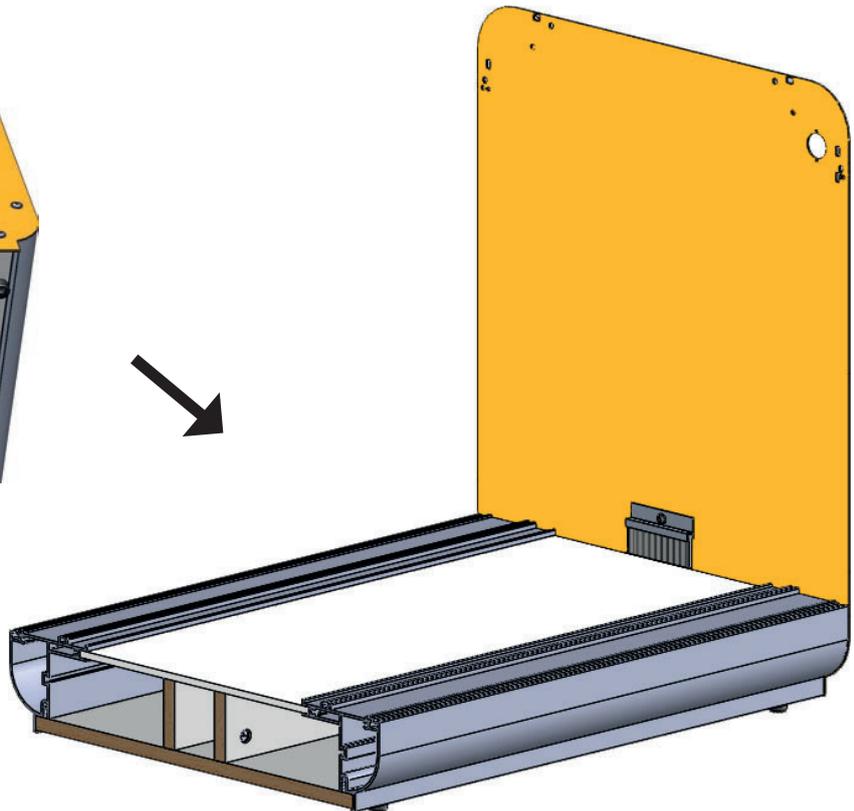
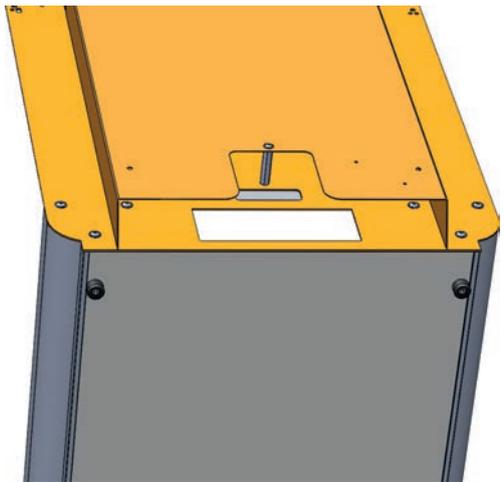
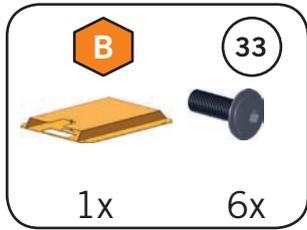
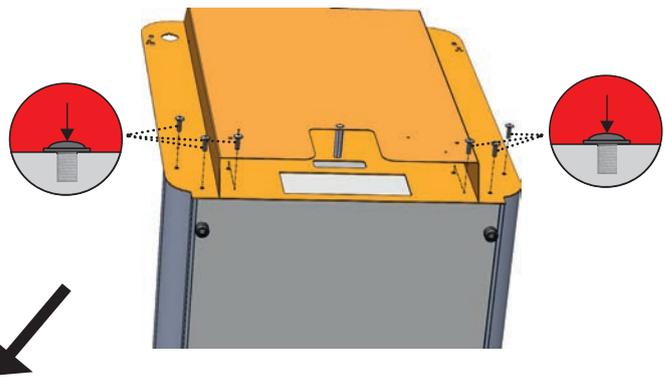


B1

32 22
1x 1x



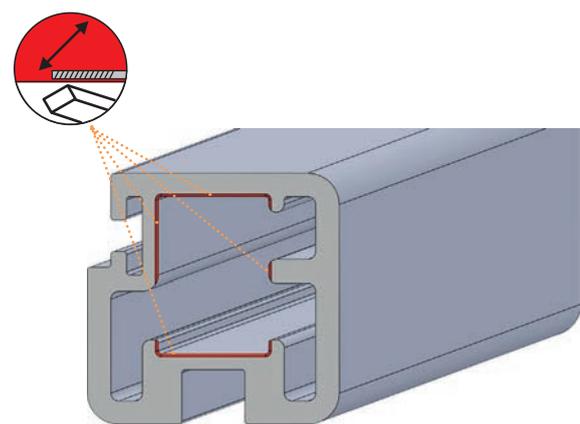
1.6



Preparatory steps for all doors:



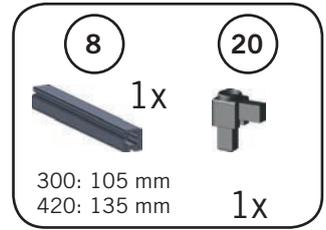
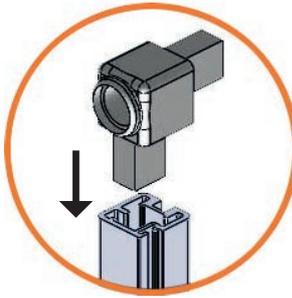
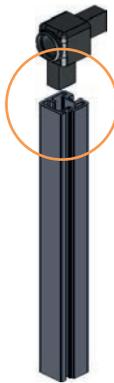
Before attaching the plastic corners it is especially important that the leading edges of all profiles are deburred with the supplied needle file in order to avoid blocking due to plastic chips.



C

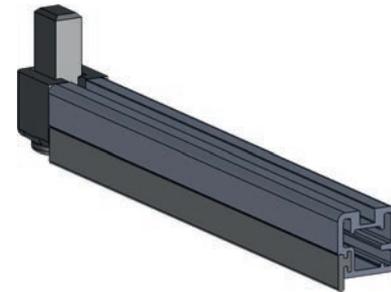
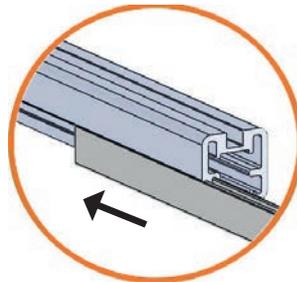
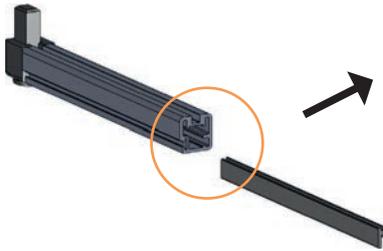


Please pay attention to the correct length!
105/ 135 mm !

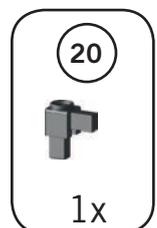
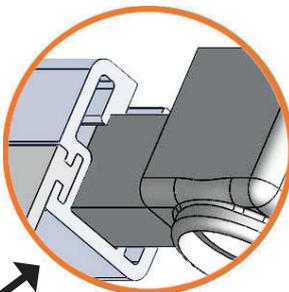


For an easier assembly of the plastic corners, please turn the profile and use the rubber mallet to fix it to the corner!

C1



C2

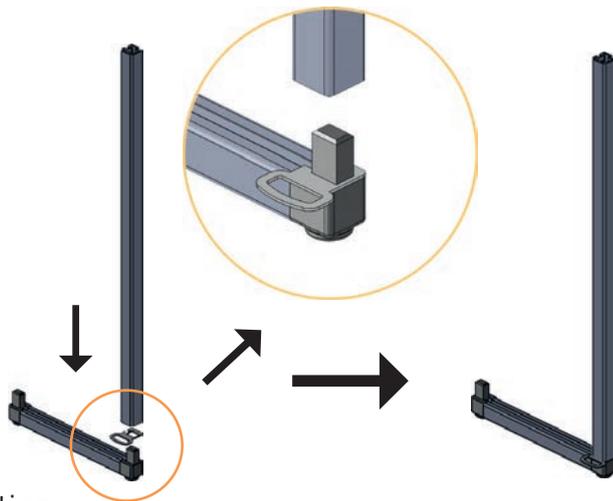


! Please produce 16x !

D



Please pay attention to the correct length!
341/ 411 mm !



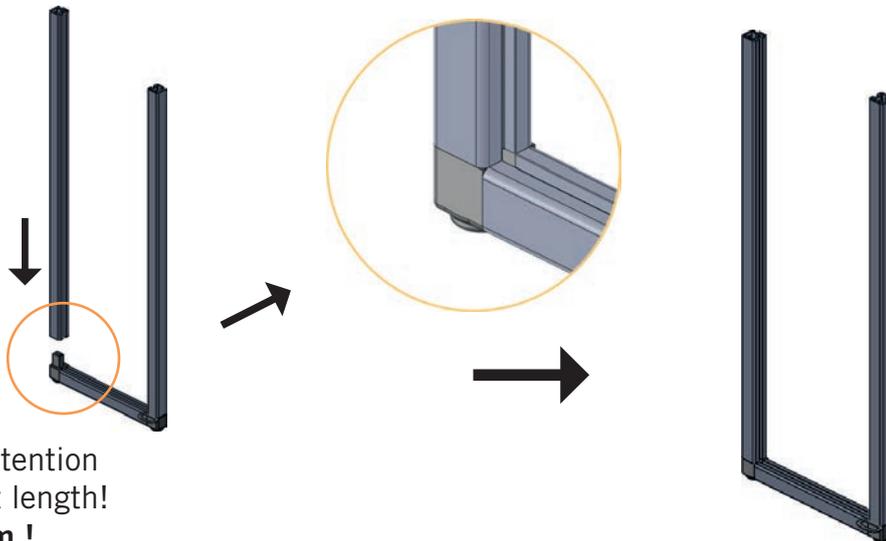
27	C	6
1x	1x	1x
		300: 341 mm 420: 411 mm



D1



Please pay attention to the correct length!
343/ 413 mm !



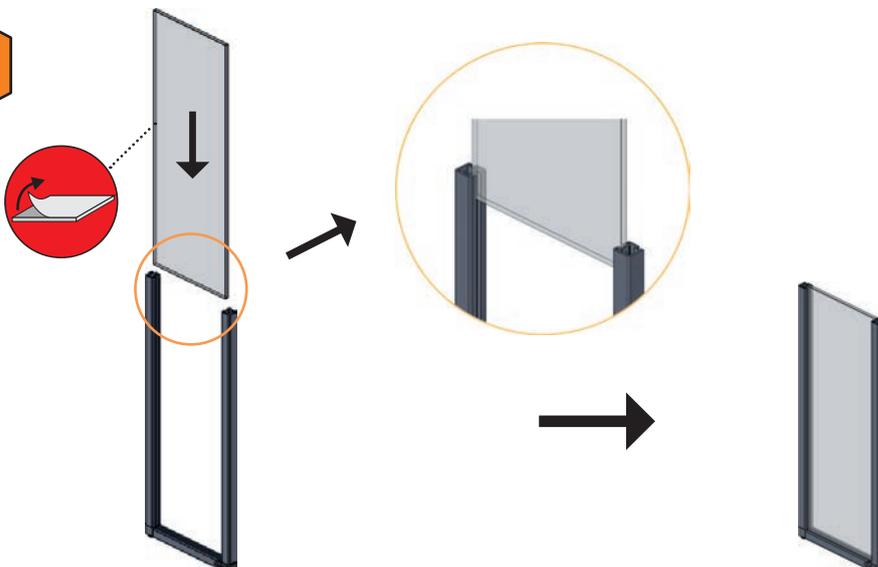
7
1x
300: 343 mm 420: 413 mm



D2



! Please produce 2x !



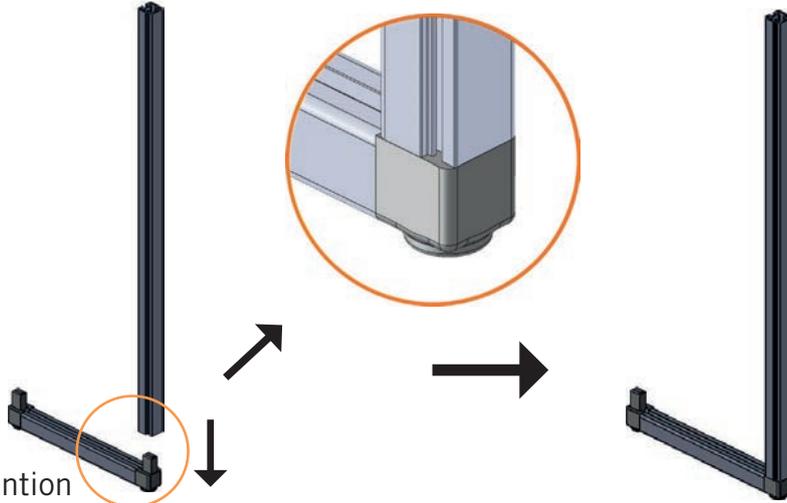
14
1x



E



Please pay attention to the correct length!
343/ 413 mm !



C

6

1x

1x

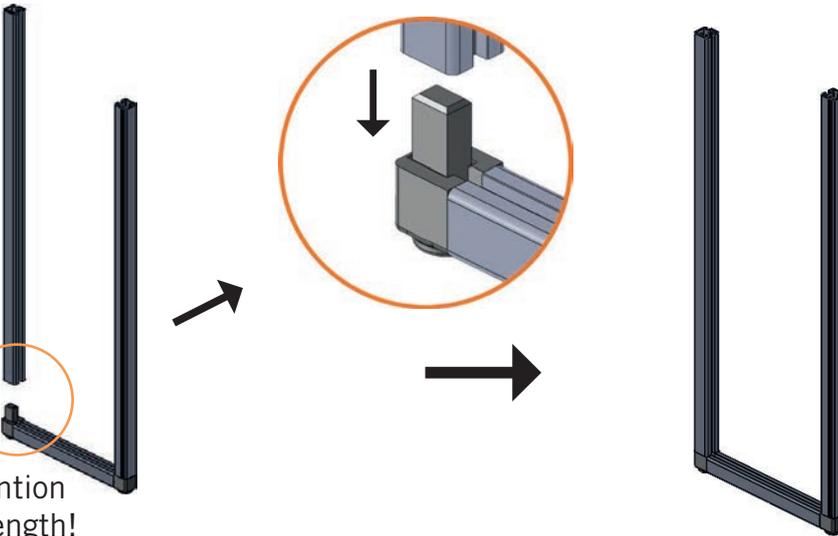
300: 343 mm
420: 413 mm



E1



Please pay attention to the correct length!
343/ 413 mm !

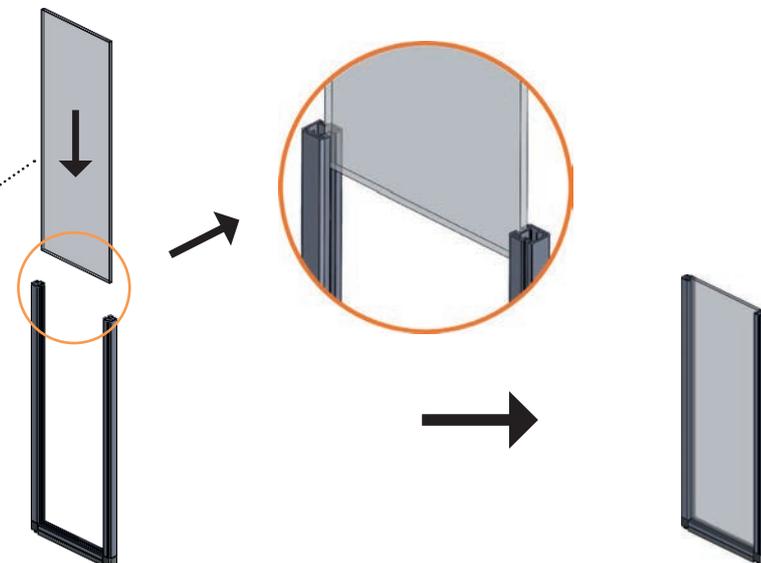


6

1x

300: 343 mm
420: 413 mm

E2



14

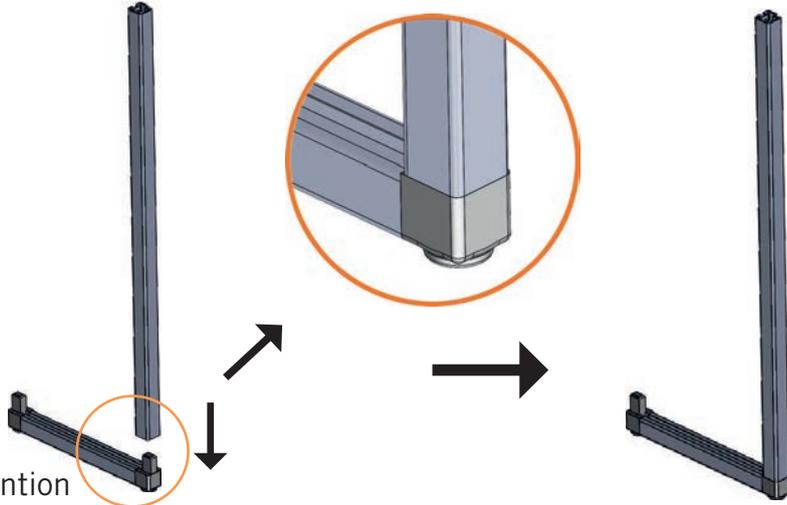
1x

! Please produce 2x !

F



Please pay attention to the correct length!
343/ 413 mm !



C

6

1x

1x

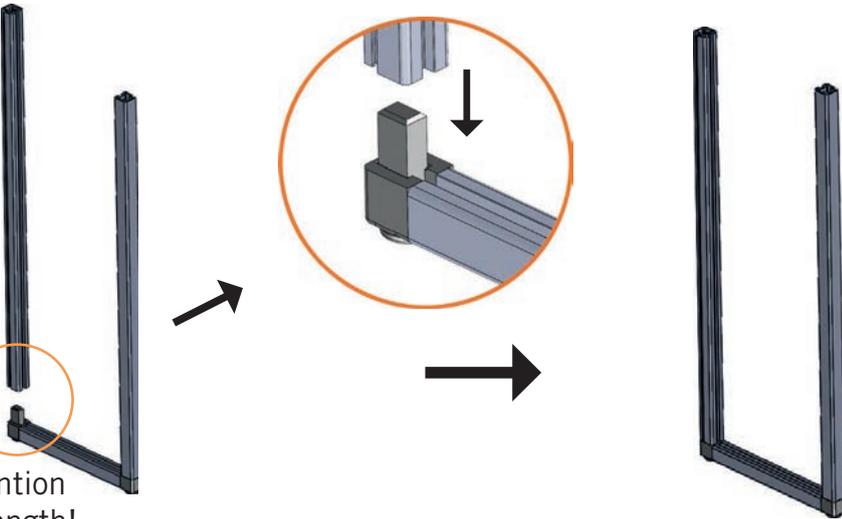
300: 343 mm
420: 413 mm



F1



Please pay attention to the correct length!
343/ 413 mm !

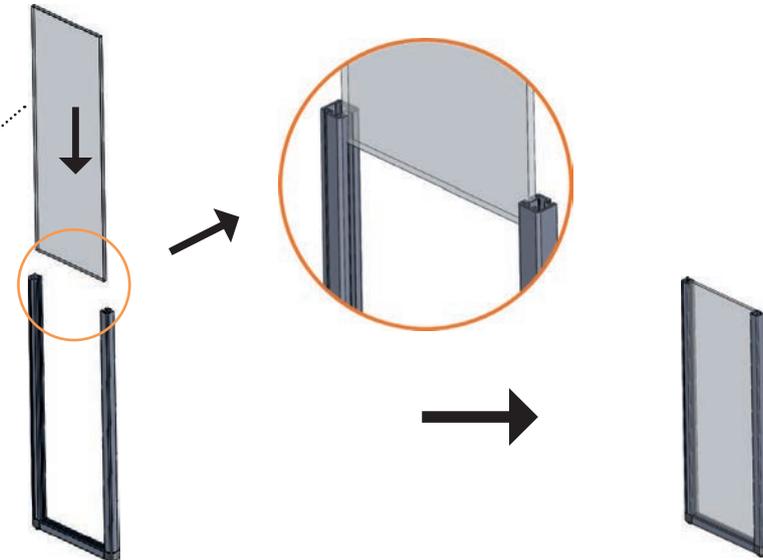


6

1x

300: 343 mm
420: 413 mm

F2



14

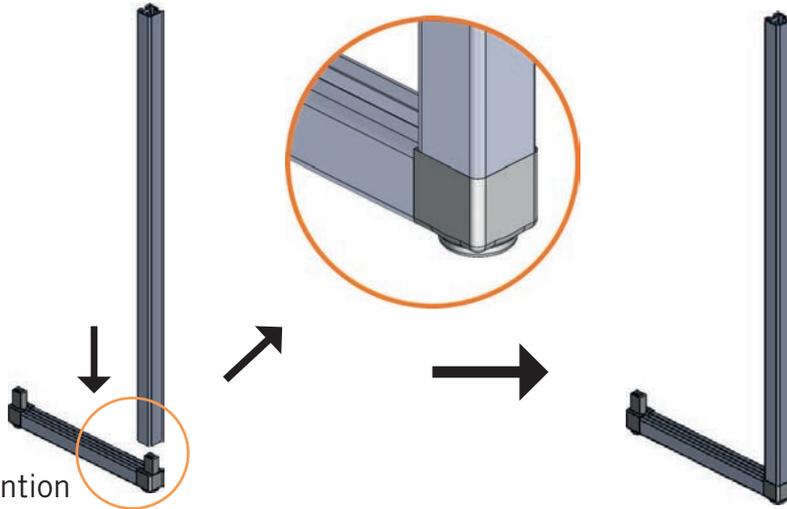
1x

! Please produce 2x !

G



Please pay attention to the correct length!
343/ 413 mm !



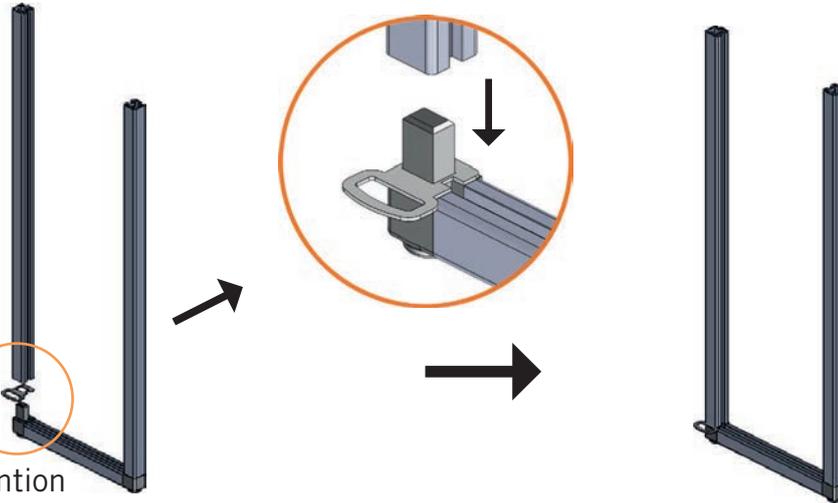
1x	1x
	300: 343 mm 420: 413 mm



G1

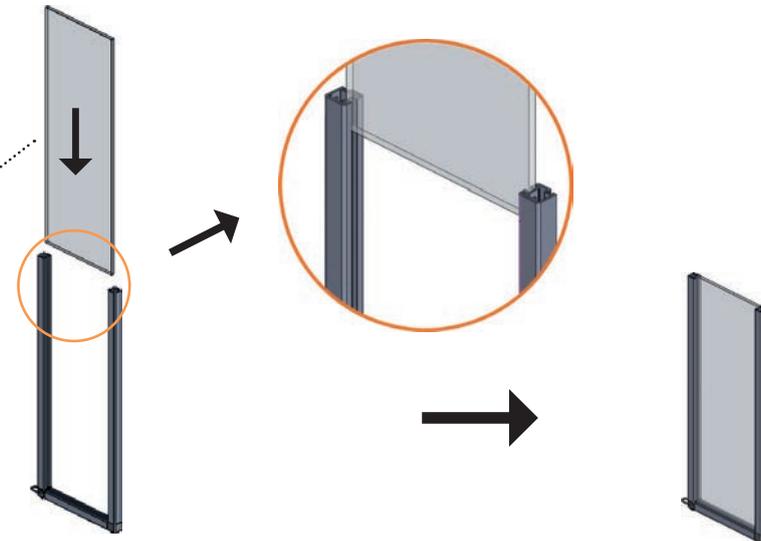


Please pay attention to the correct length!
341/ 411 mm !



1x	1x
300: 341 mm 420: 411 mm	

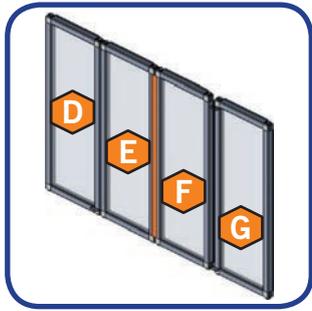
G2



1x

! Please produce 2x !

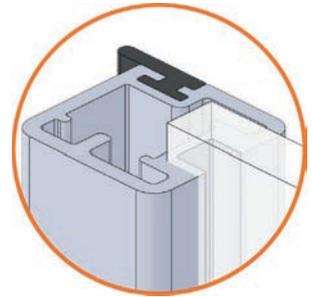
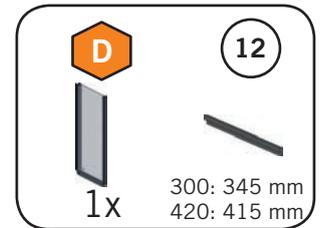
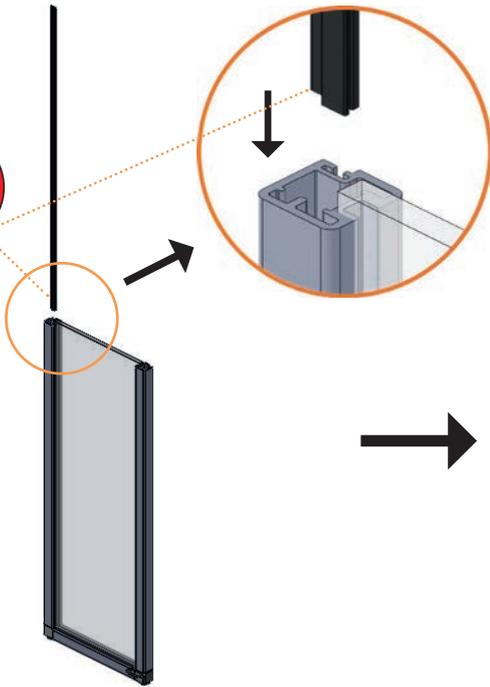
2



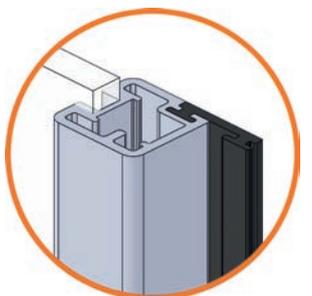
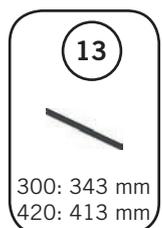
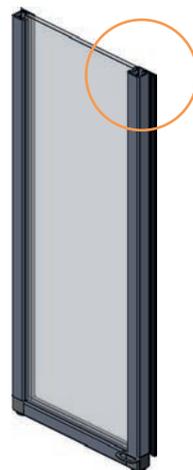
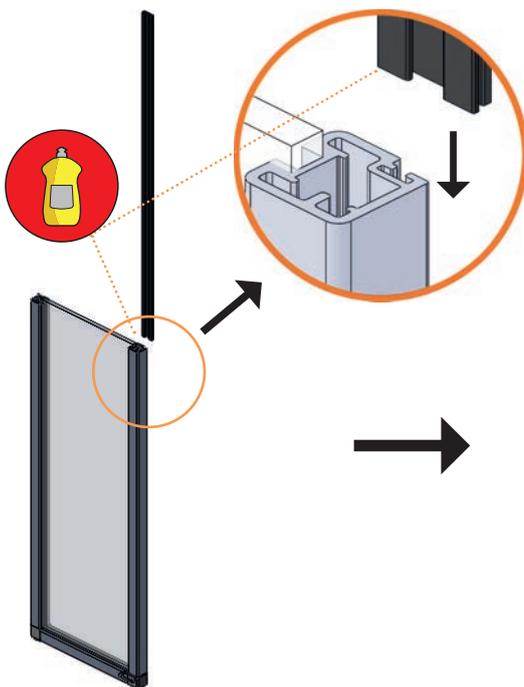
Side doors

(produce 2x)

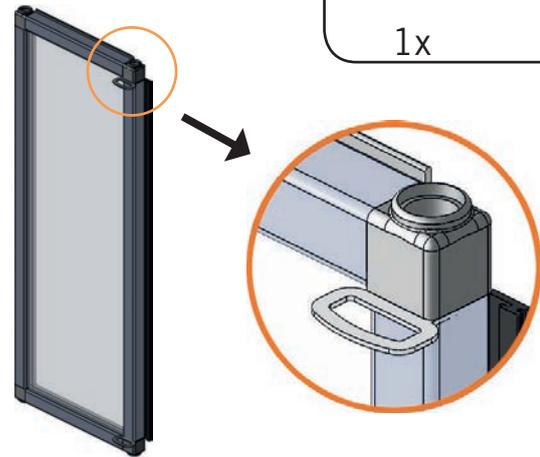
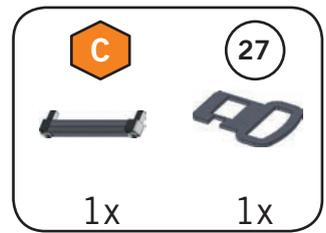
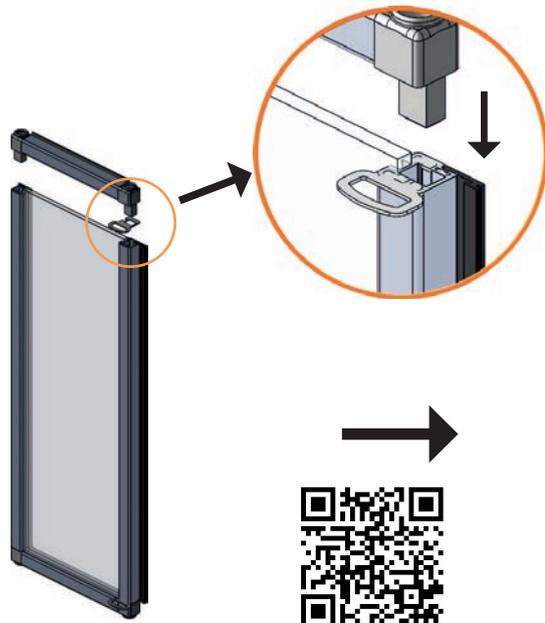
2.1



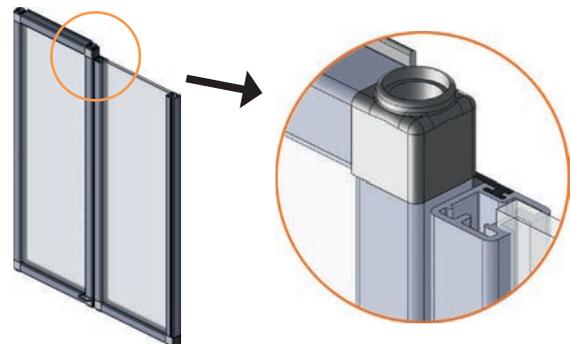
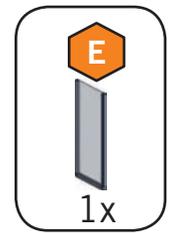
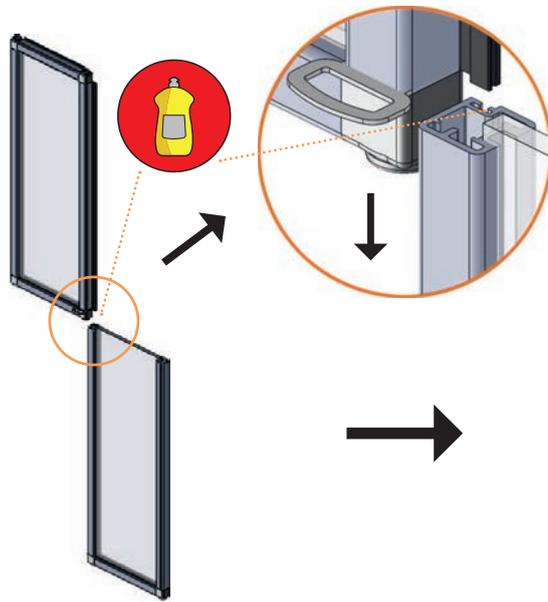
2.2



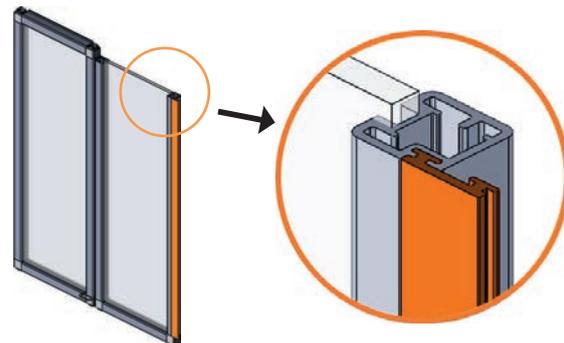
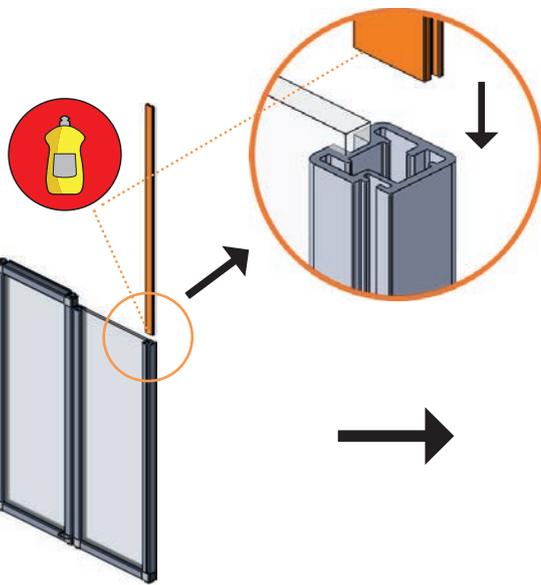
2.3



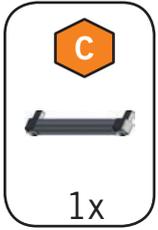
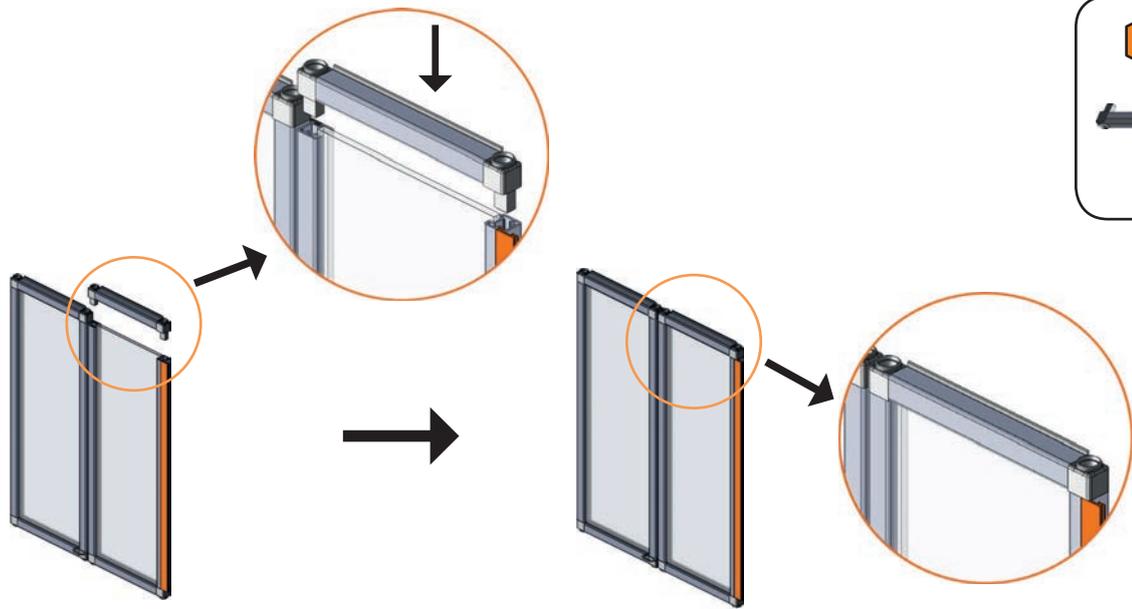
2.4



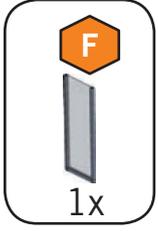
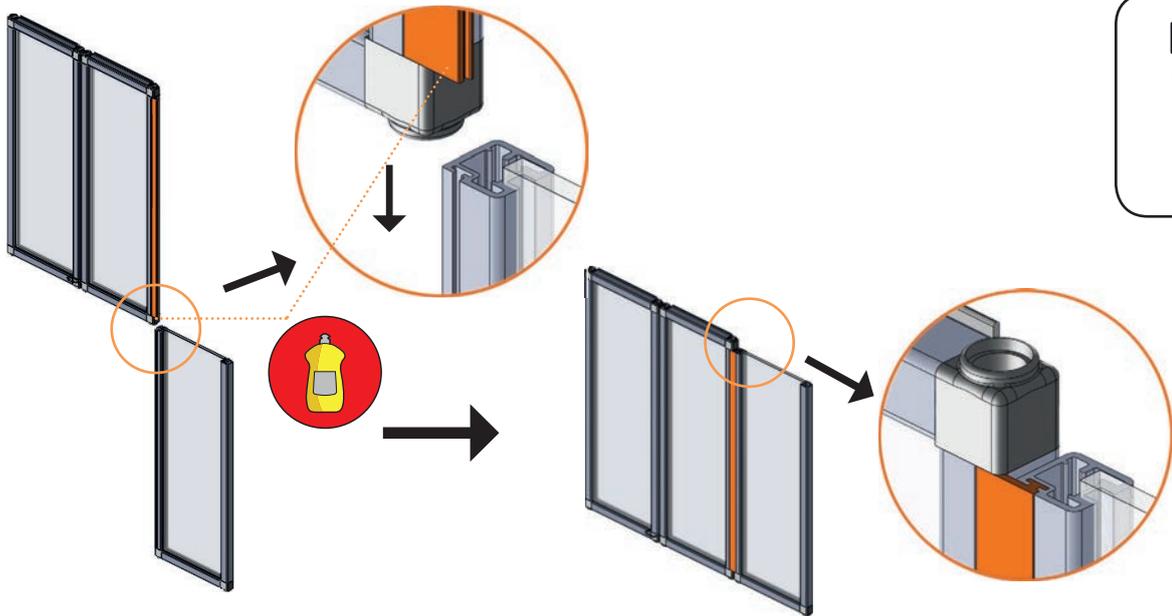
2.5



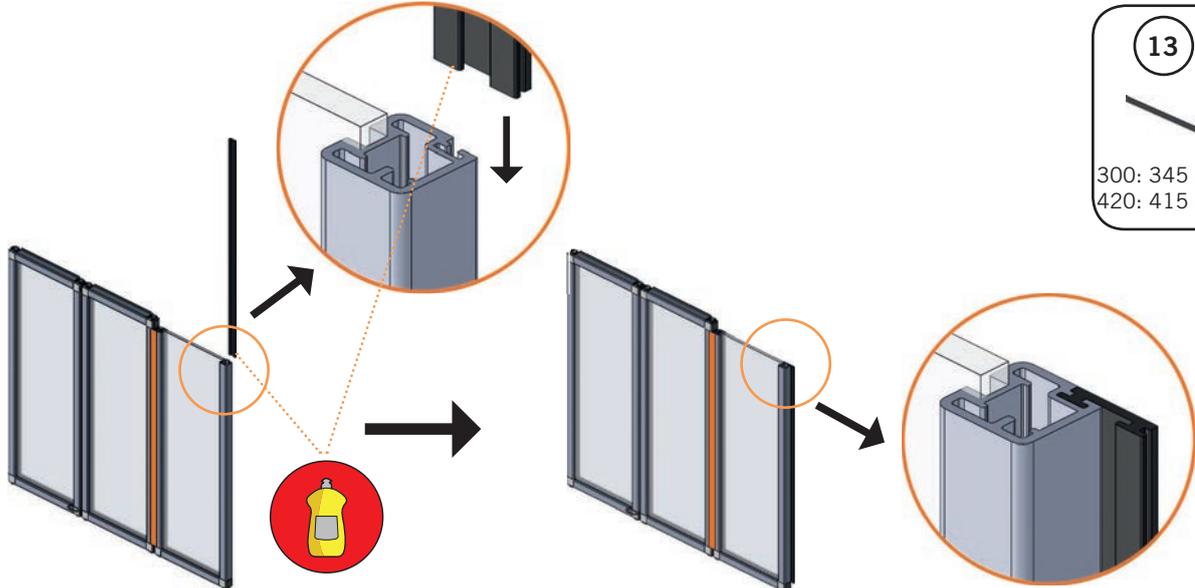
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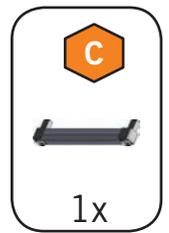
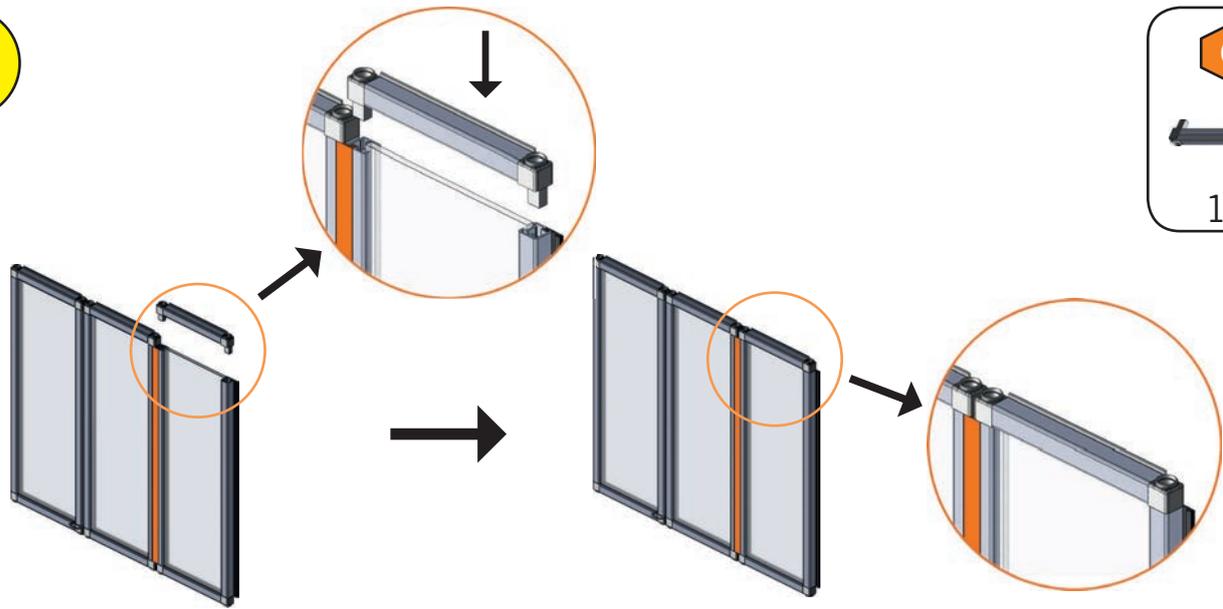
2.7



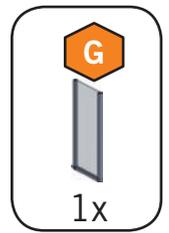
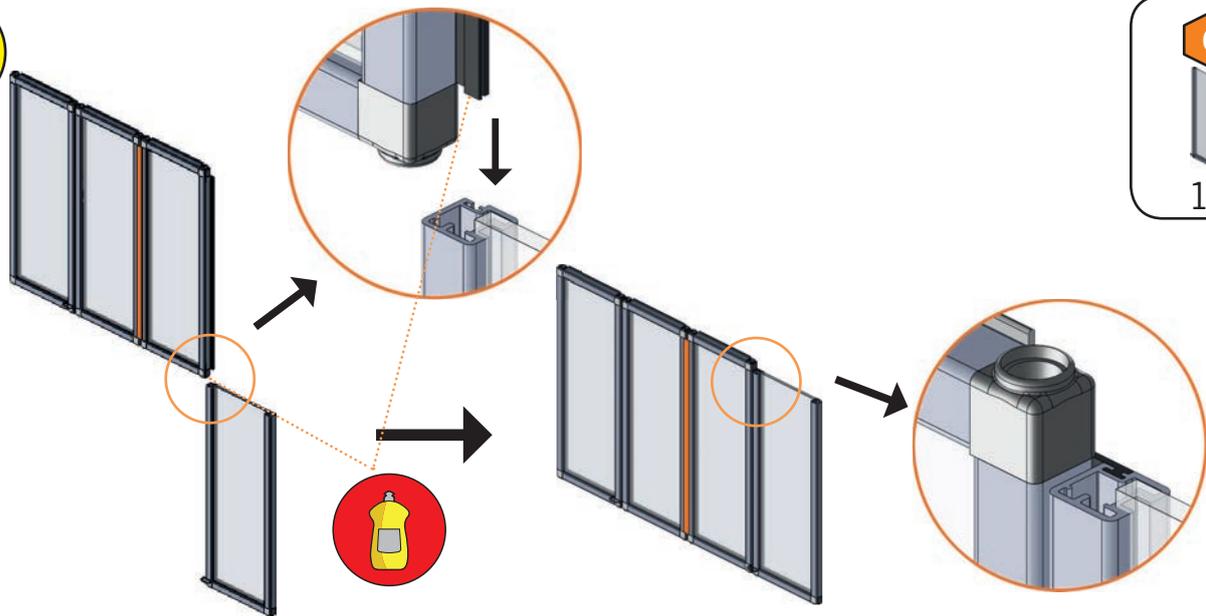
2.8



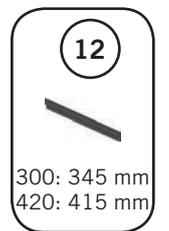
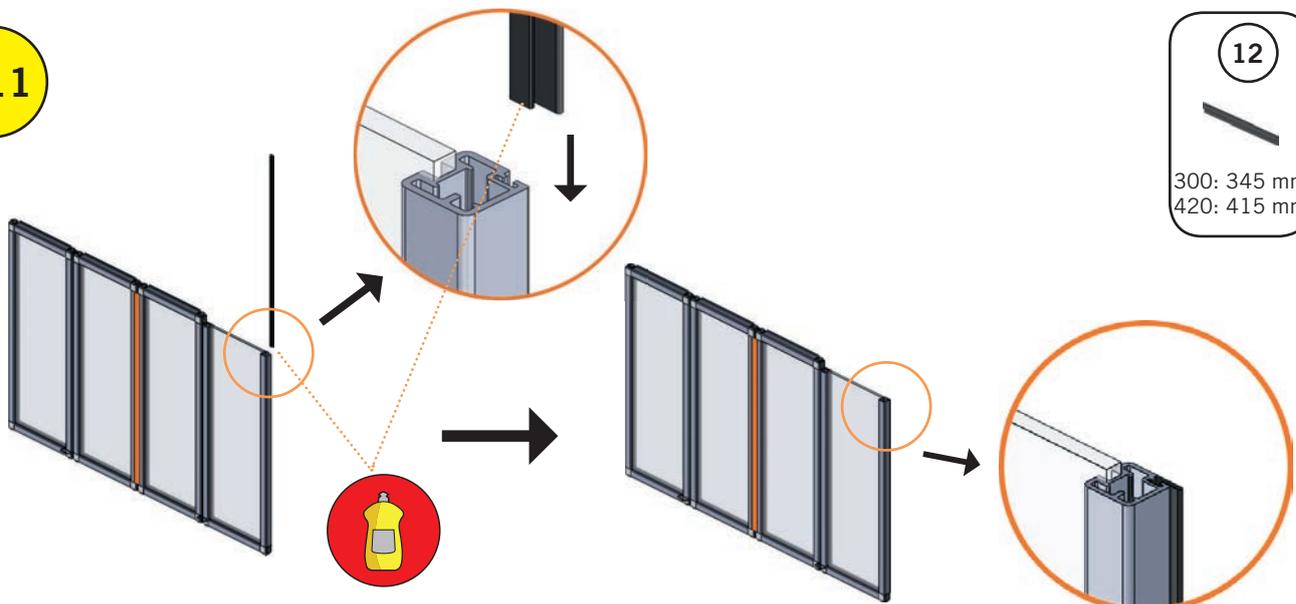
2.9



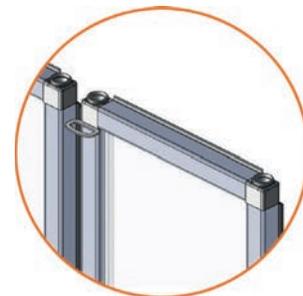
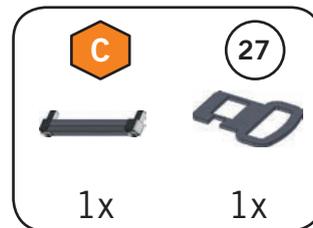
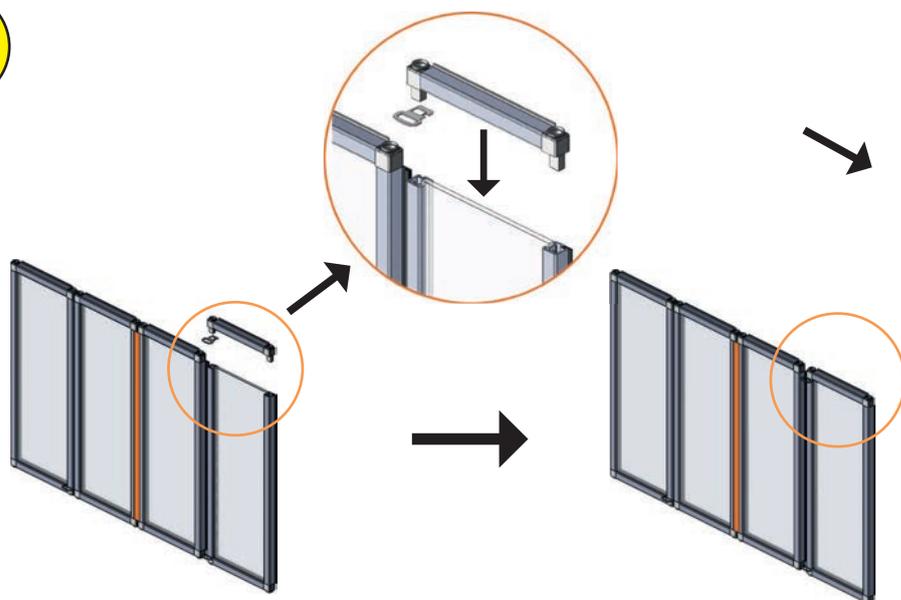
2.10



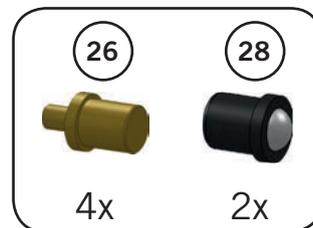
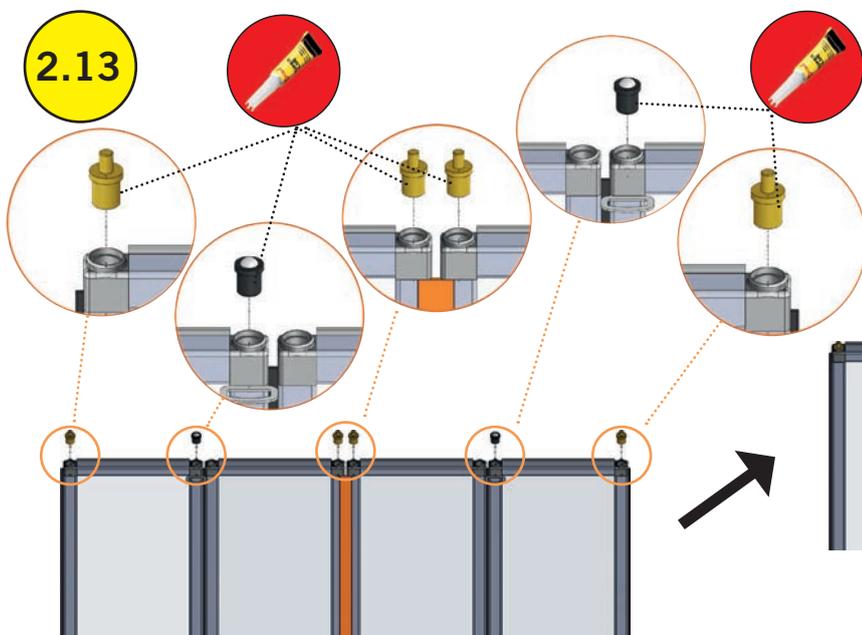
2.11



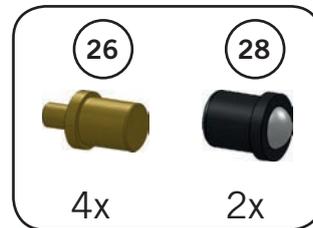
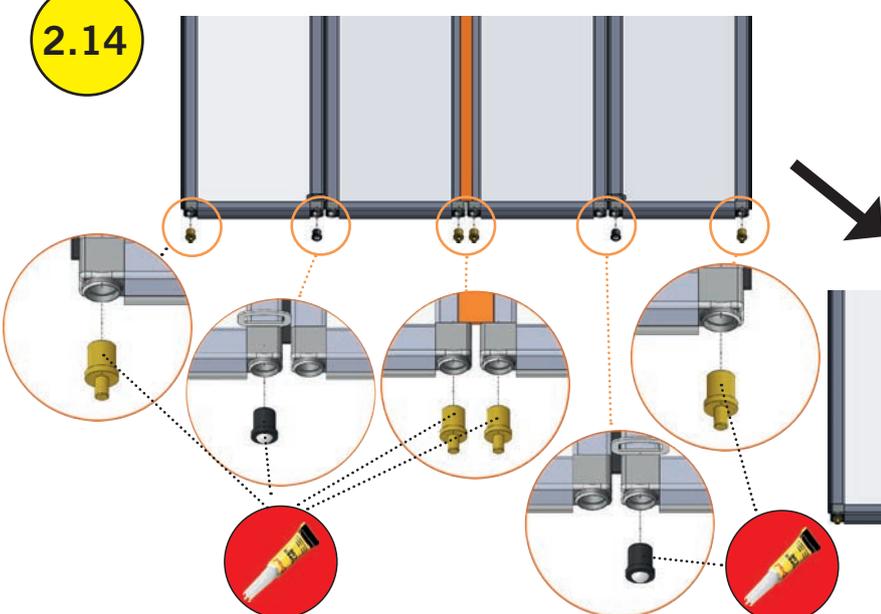
2.12



2.13



2.14



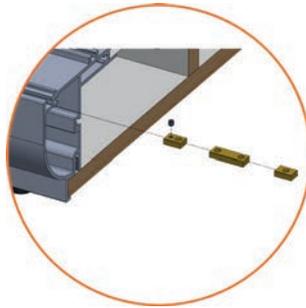
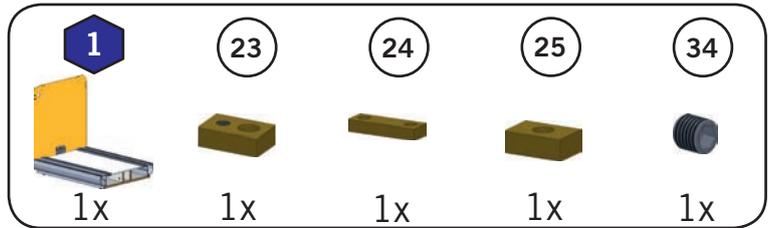
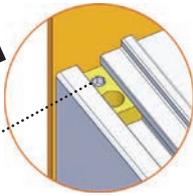
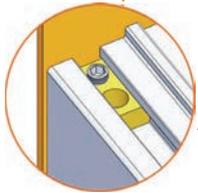
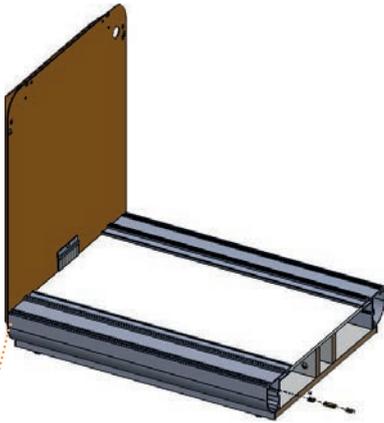
! Please produce 2x !

3

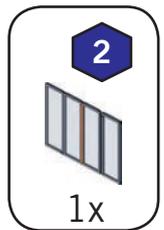
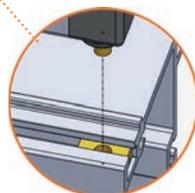
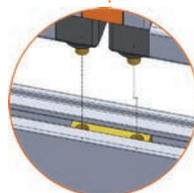
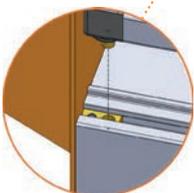
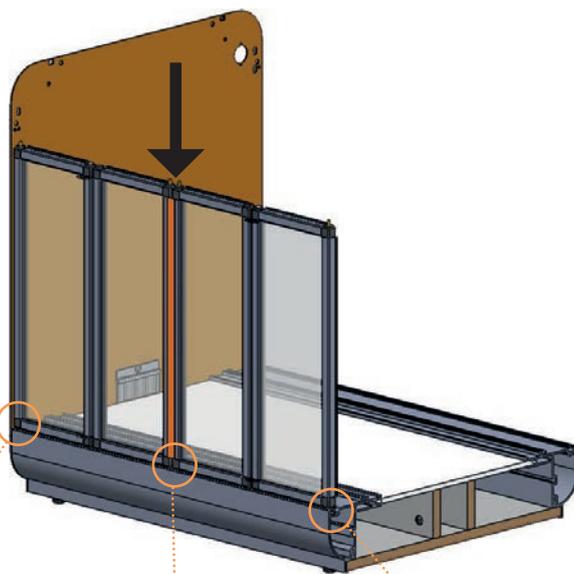


Upper frame

3.1

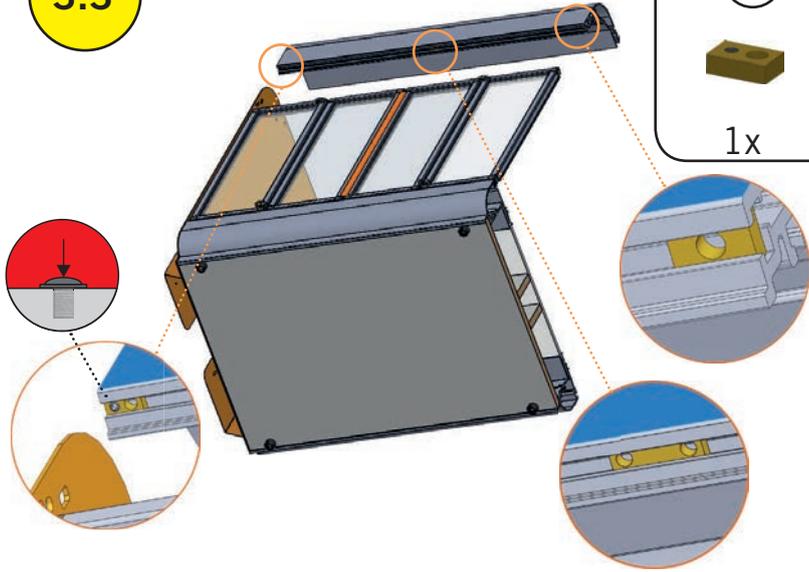


3.2

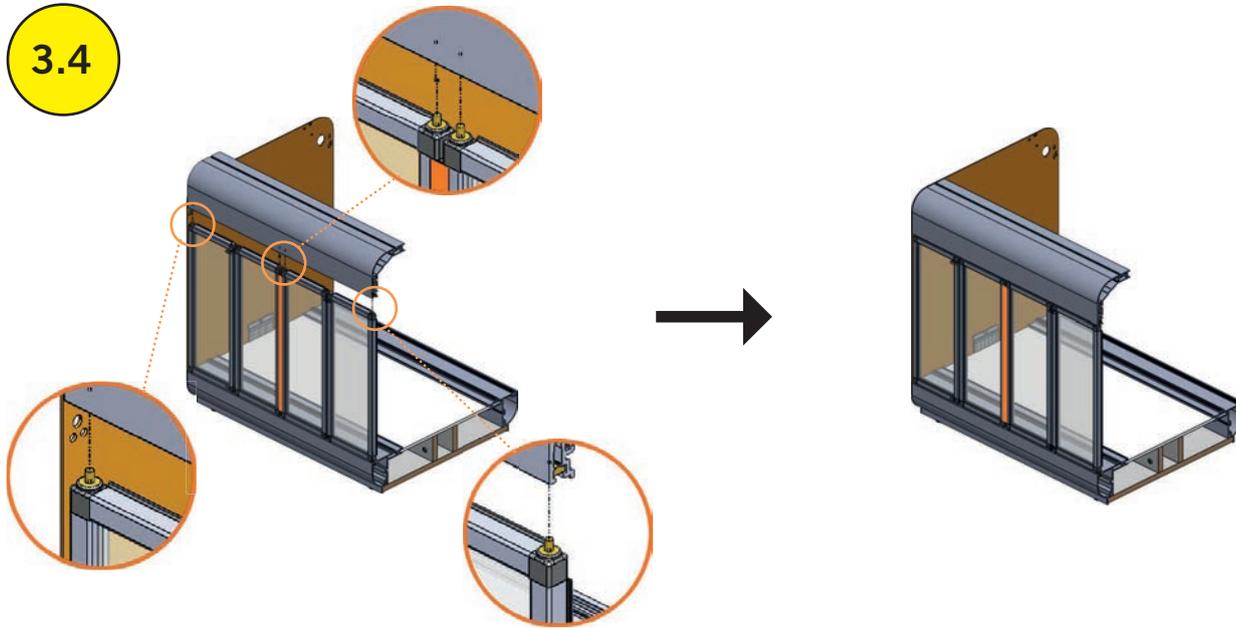


3.3

- | | | | | |
|----|----|----|----|----|
| 23 | 24 | 25 | 34 | 3 |
| | | | | |
| 1x | 1x | 1x | 1x | 1x |

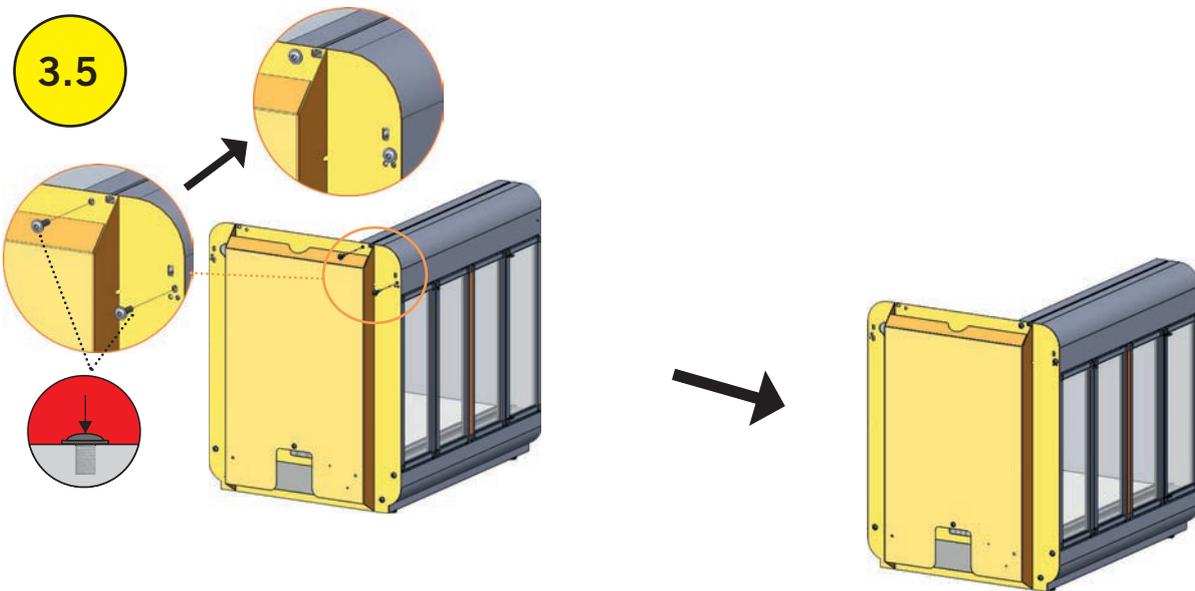


3.4



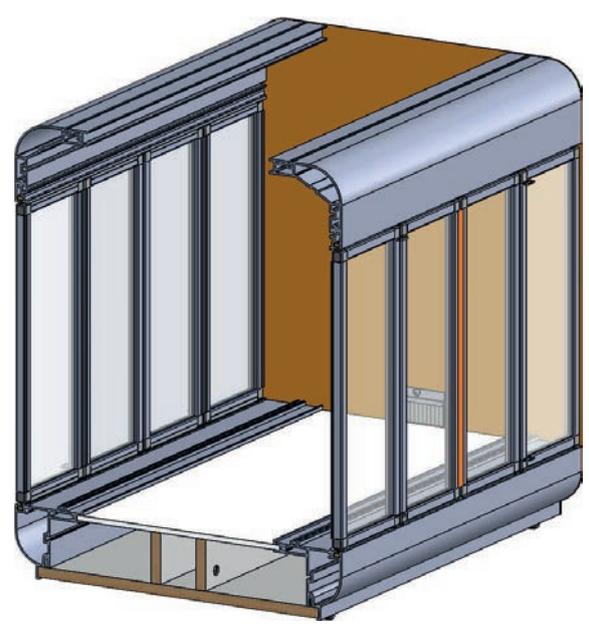
3.5

- | |
|----|
| 33 |
| |
| 2x |

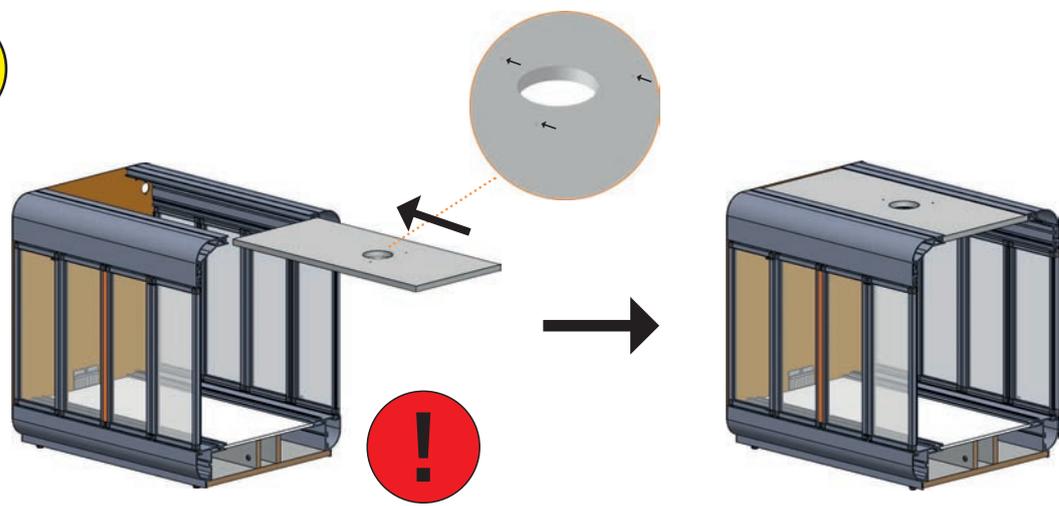


3.6

Please repeat work steps 3.1 to 3.5 mirror-inverted for the right side of the enclosure!



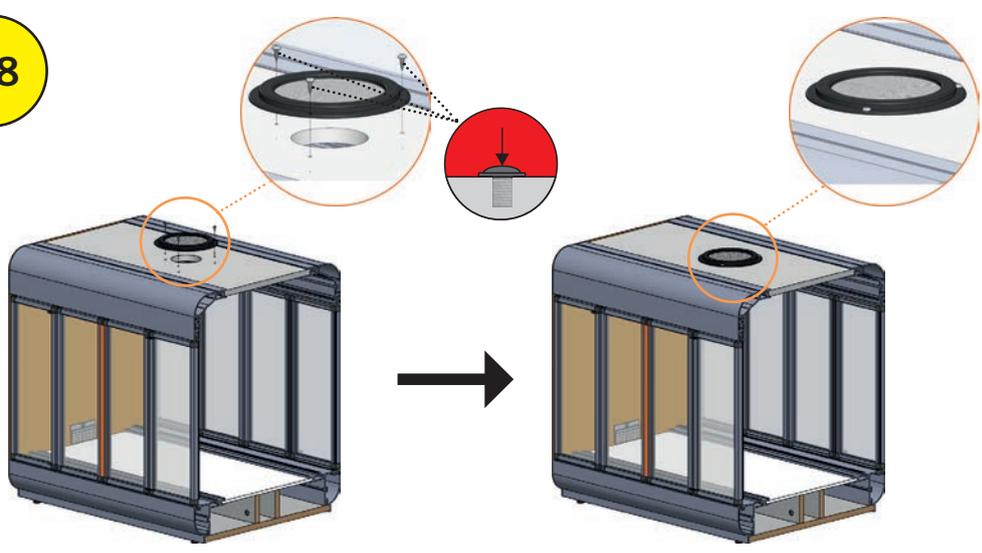
3.7



19
1x

Please pay attention to the orientation of the top plate!

3.8

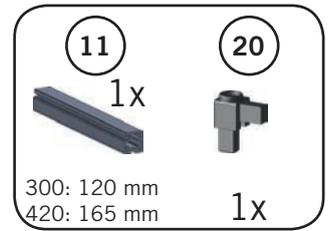
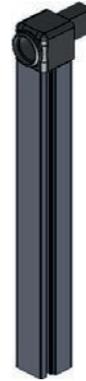
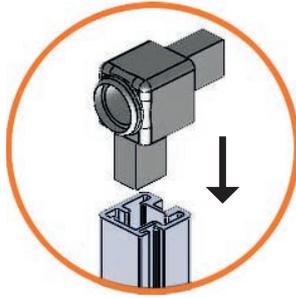
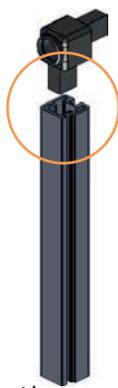


21 50
1x 3x

H

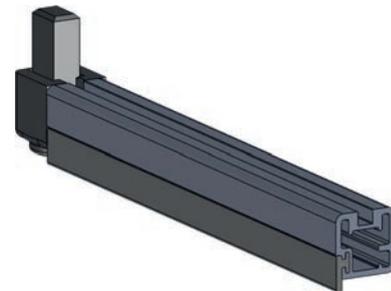
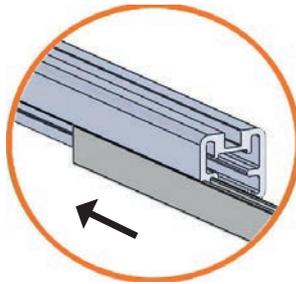
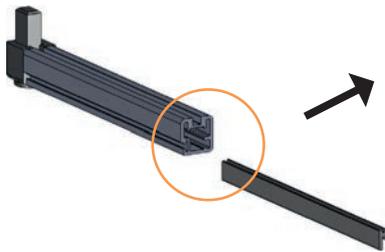


Please pay attention to the correct length!
120/ 165 mm !

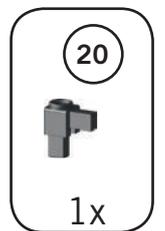
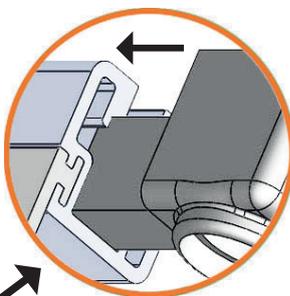


For an easier assembly of the plastic corners, please turn the profile and use the rubber mallet to fix it to the corner!

H1

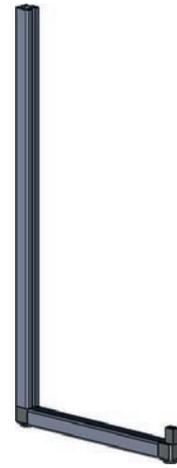
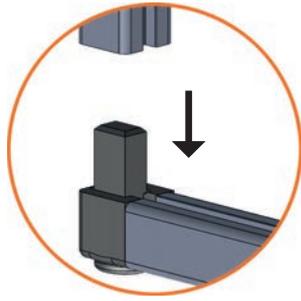


H2



! Please produce 4x !

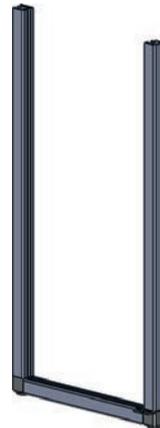
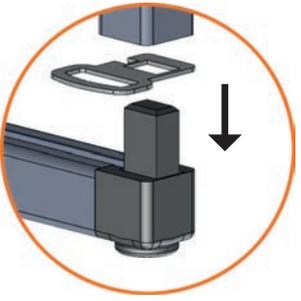
I



1x	1x
	300: 304 mm 420: 374 mm

Please pay attention to the correct length!
304/ 374 mm !

I1



1x	1x
300: 302 mm 420: 372 mm	

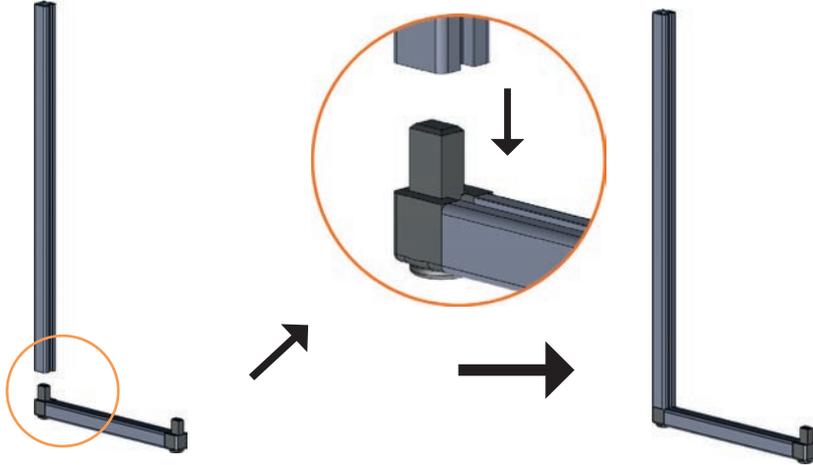
Please pay attention to the correct length!
302/ 372 mm !

I2



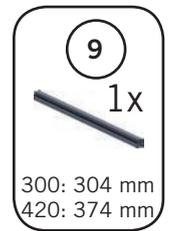
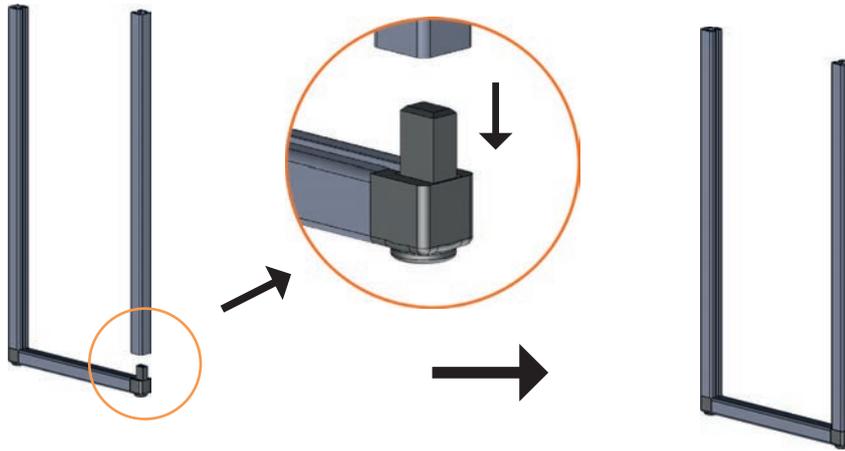
1x

J



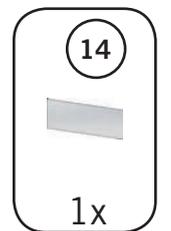
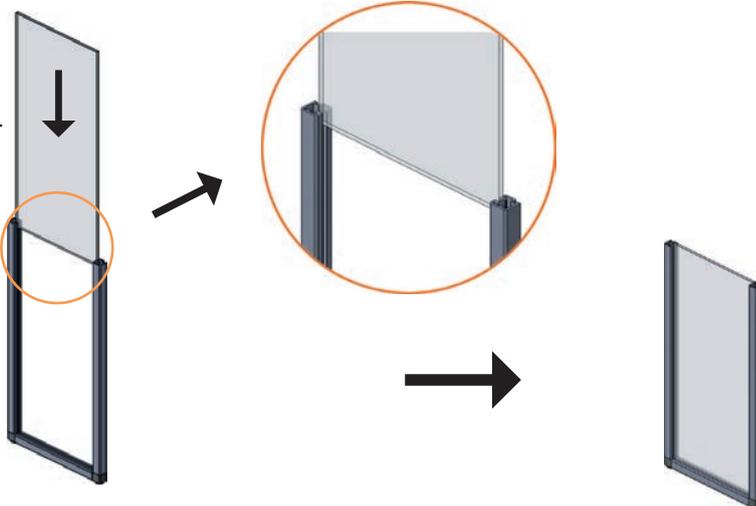
Please pay attention
to the correct length!
304/ 374 mm !

J1

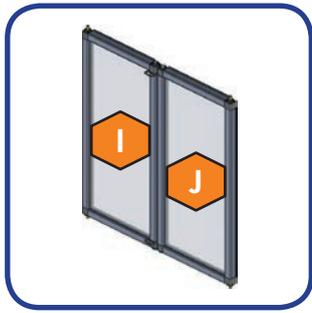


Please pay attention
to the correct length!
304/ 374 mm !

J2

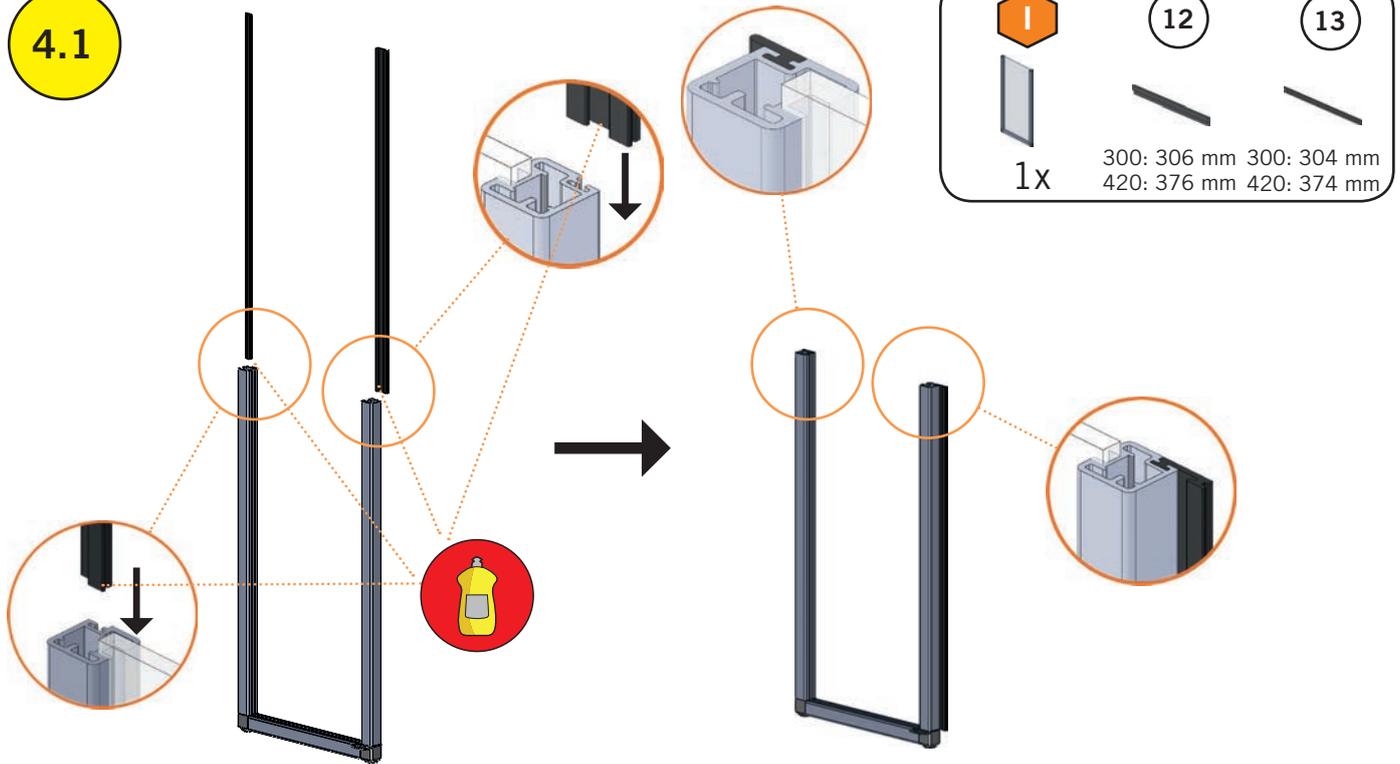


4

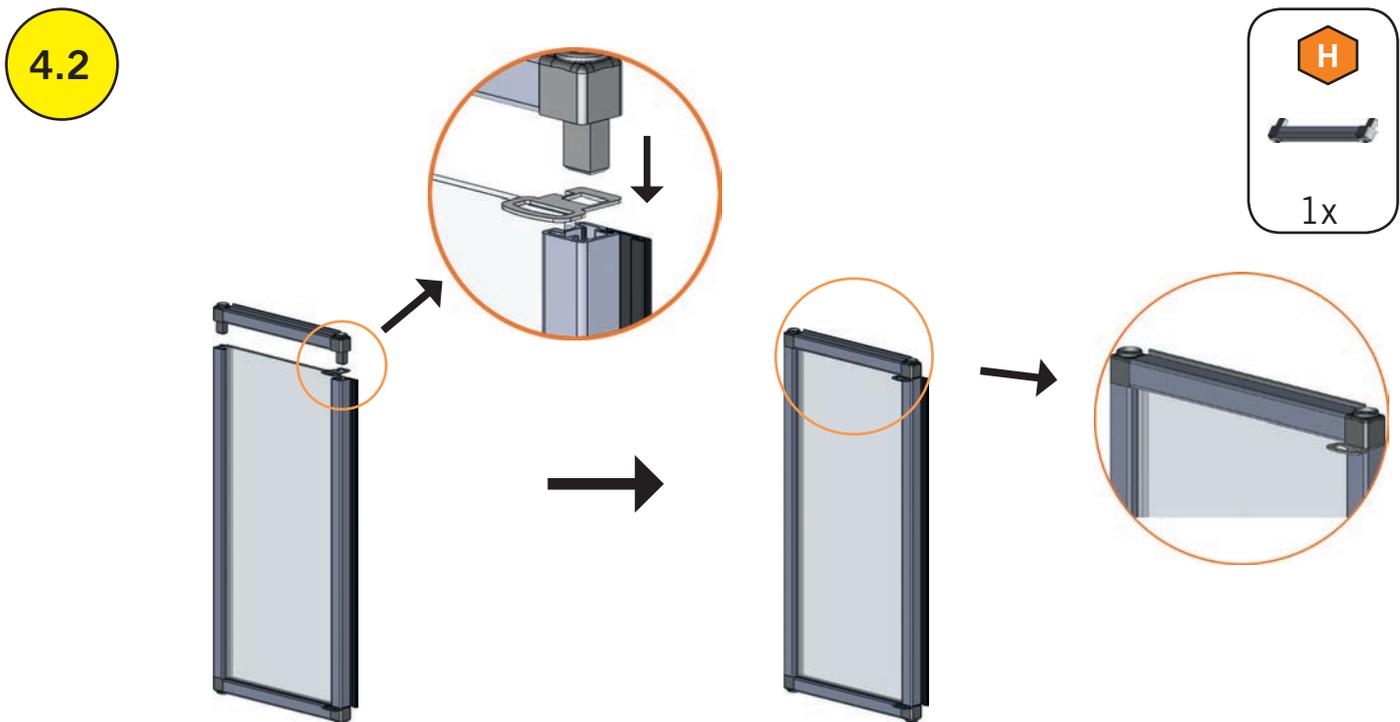


Front door

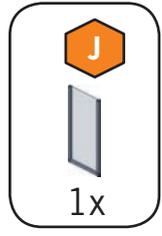
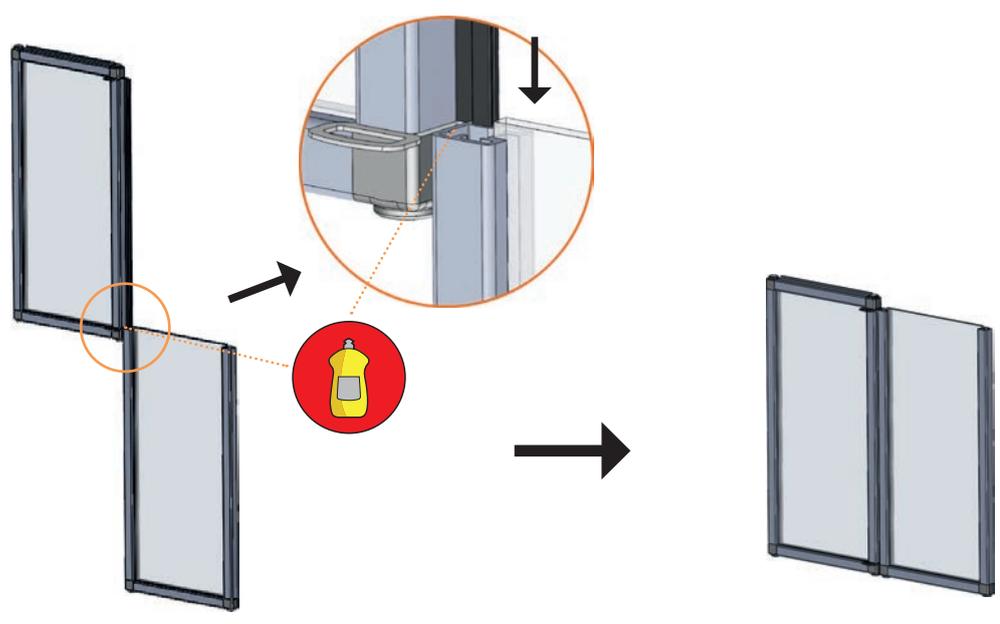
4.1



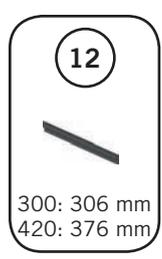
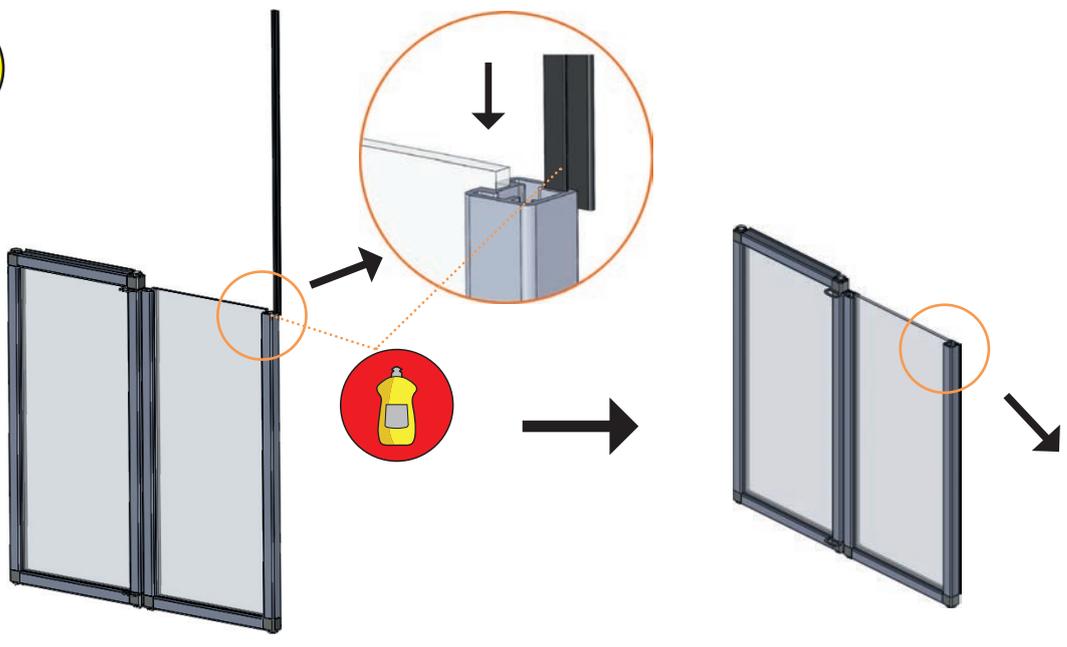
4.2



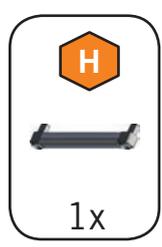
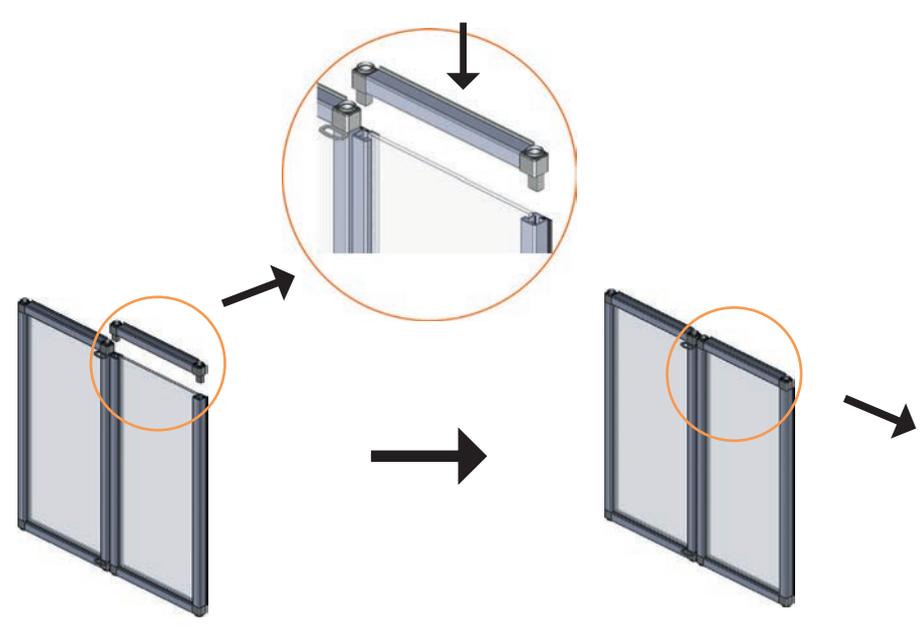
4.3



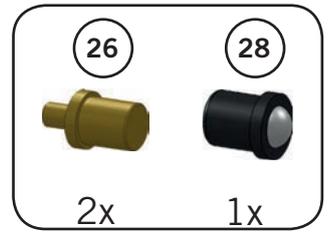
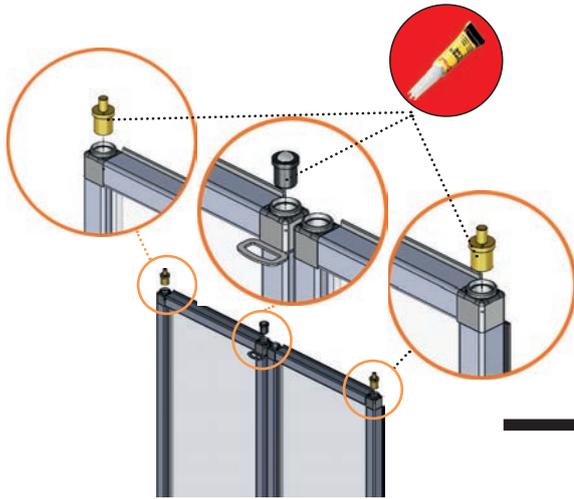
4.4



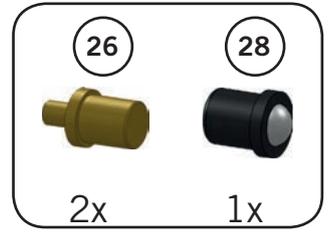
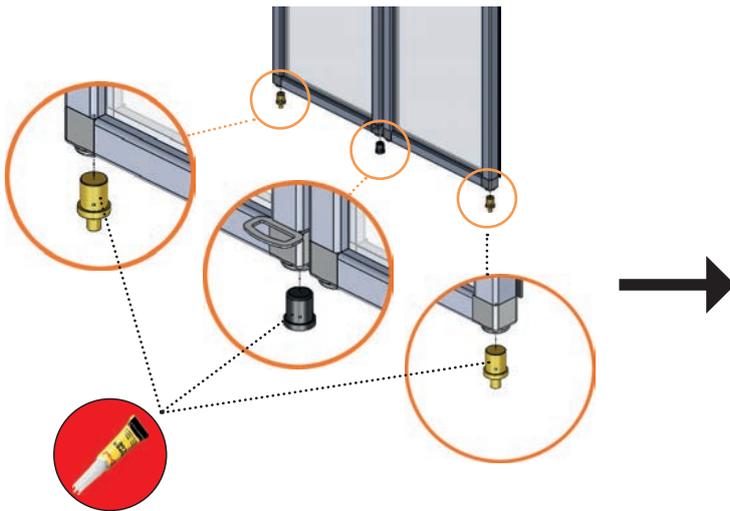
4.5



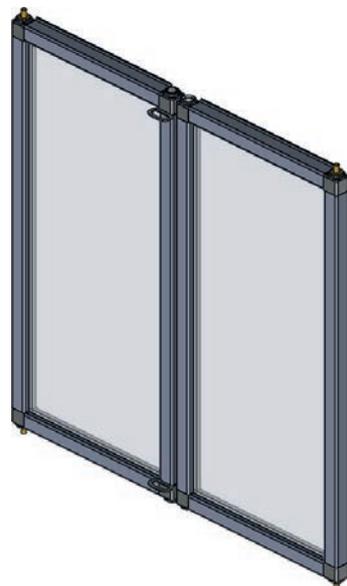
4.6



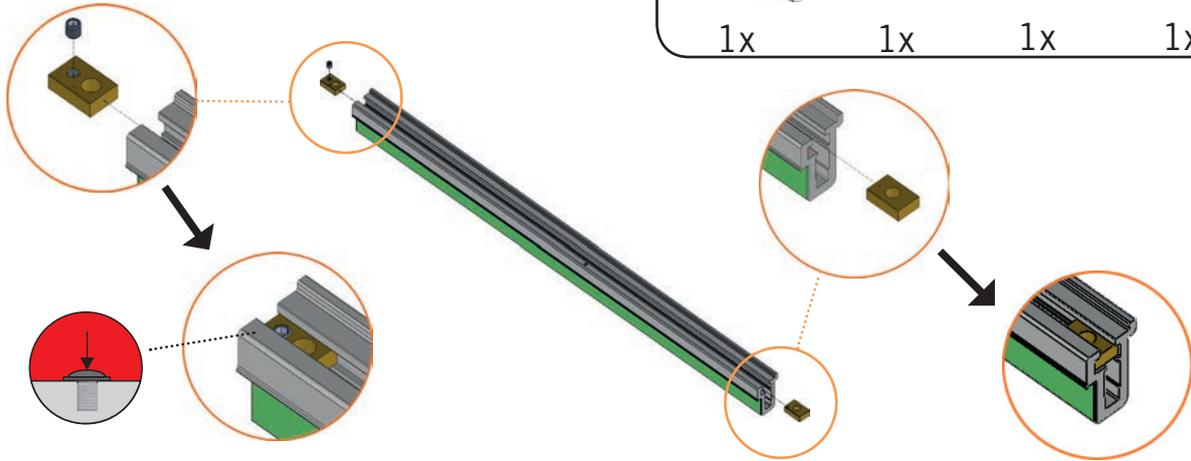
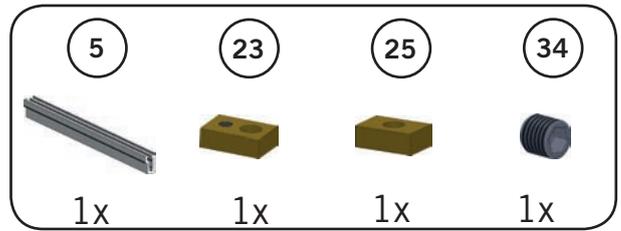
4.7



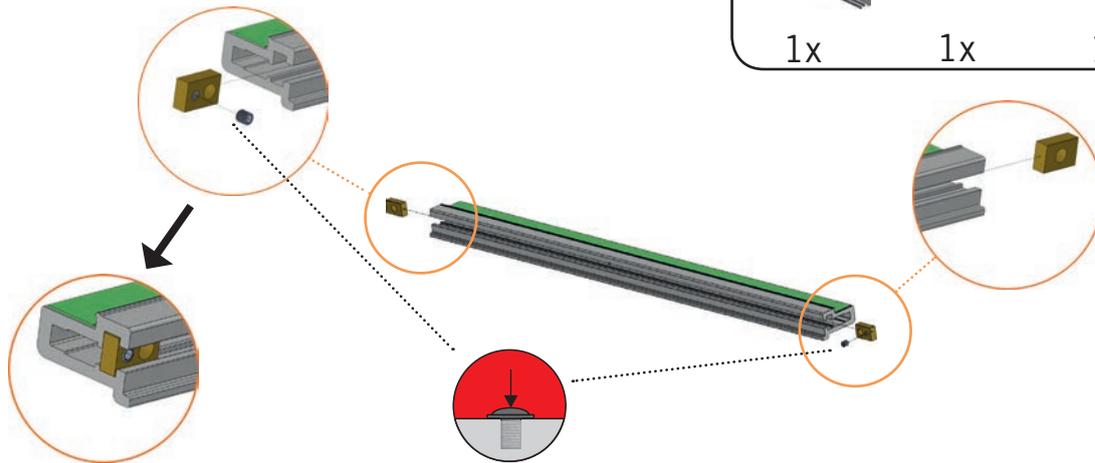
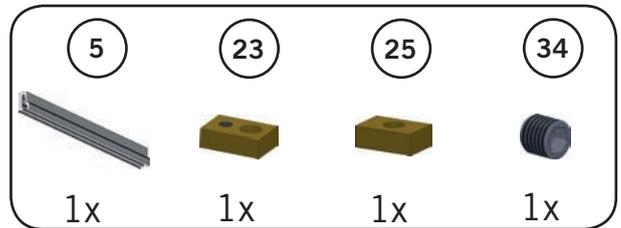
4.8



K



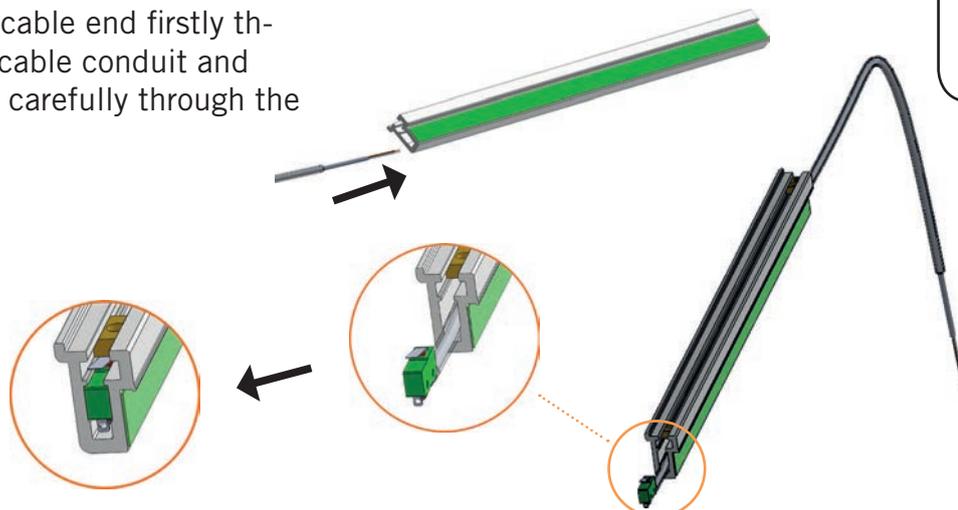
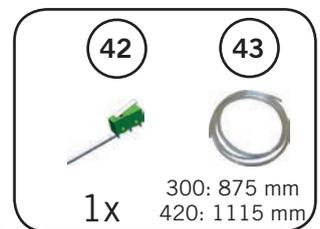
L



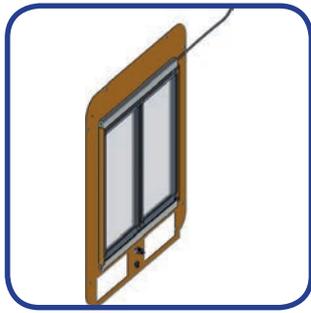
L1



Guide the cable end firstly through the cable conduit and afterwards carefully through the profile.



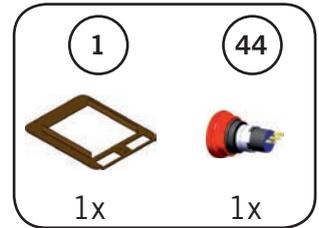
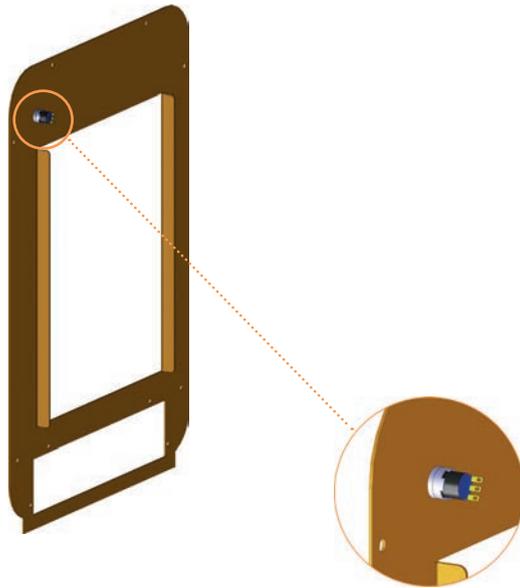
5



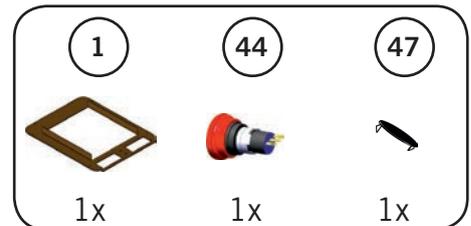
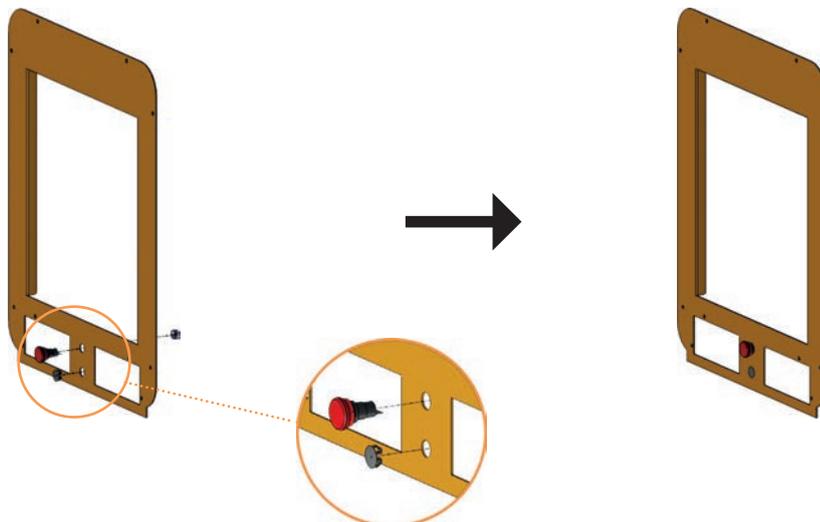
Enclosure front

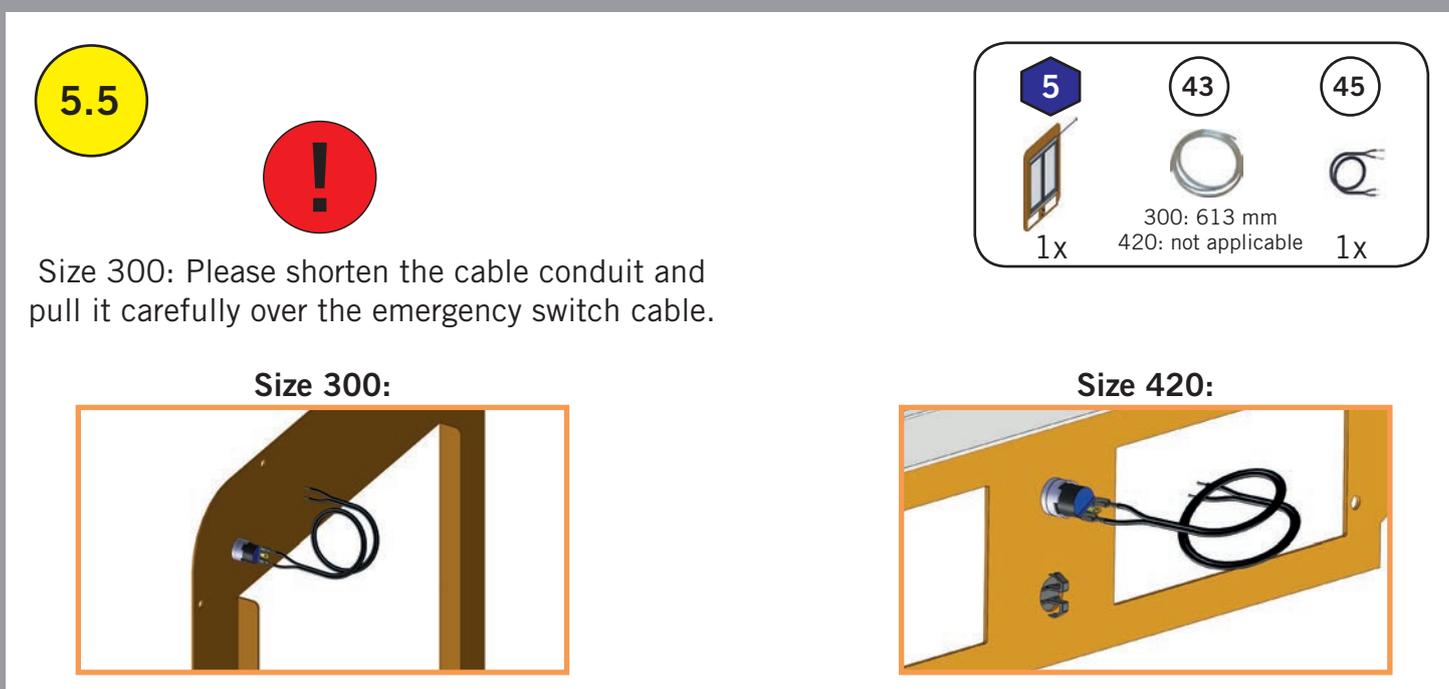
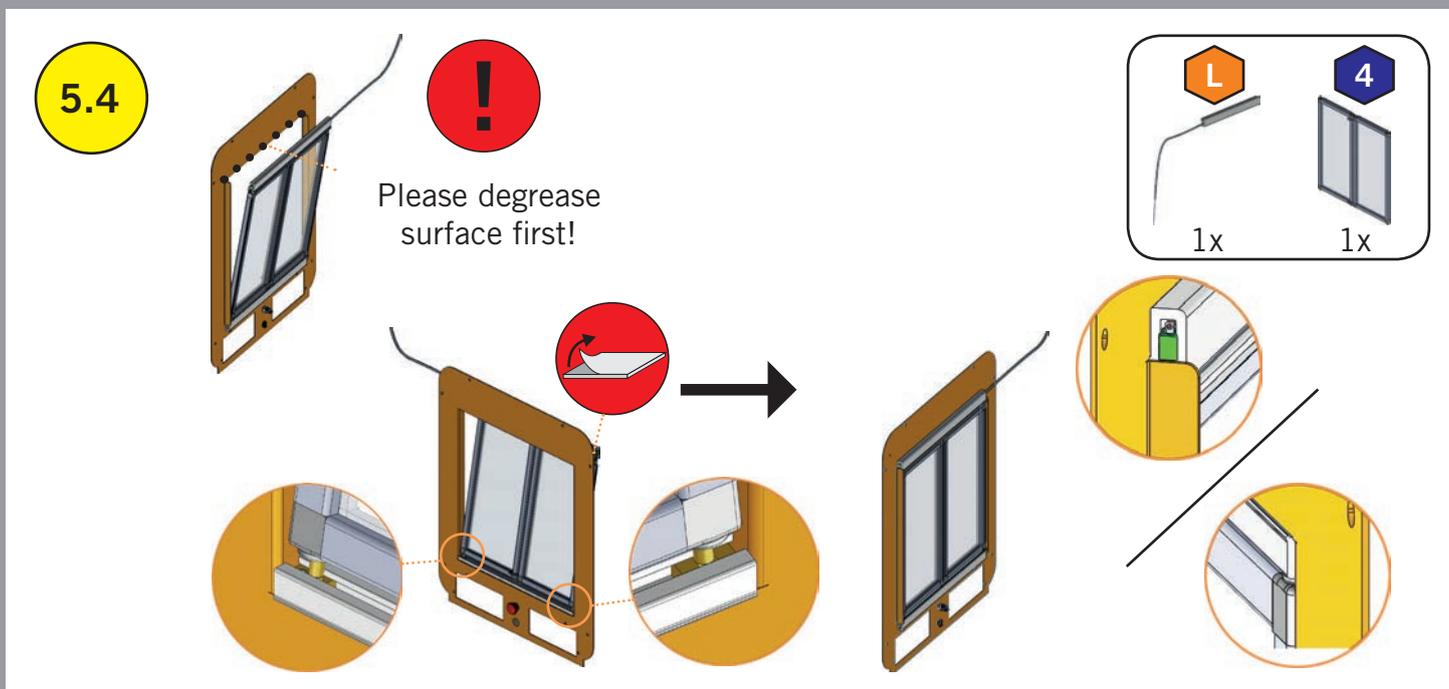
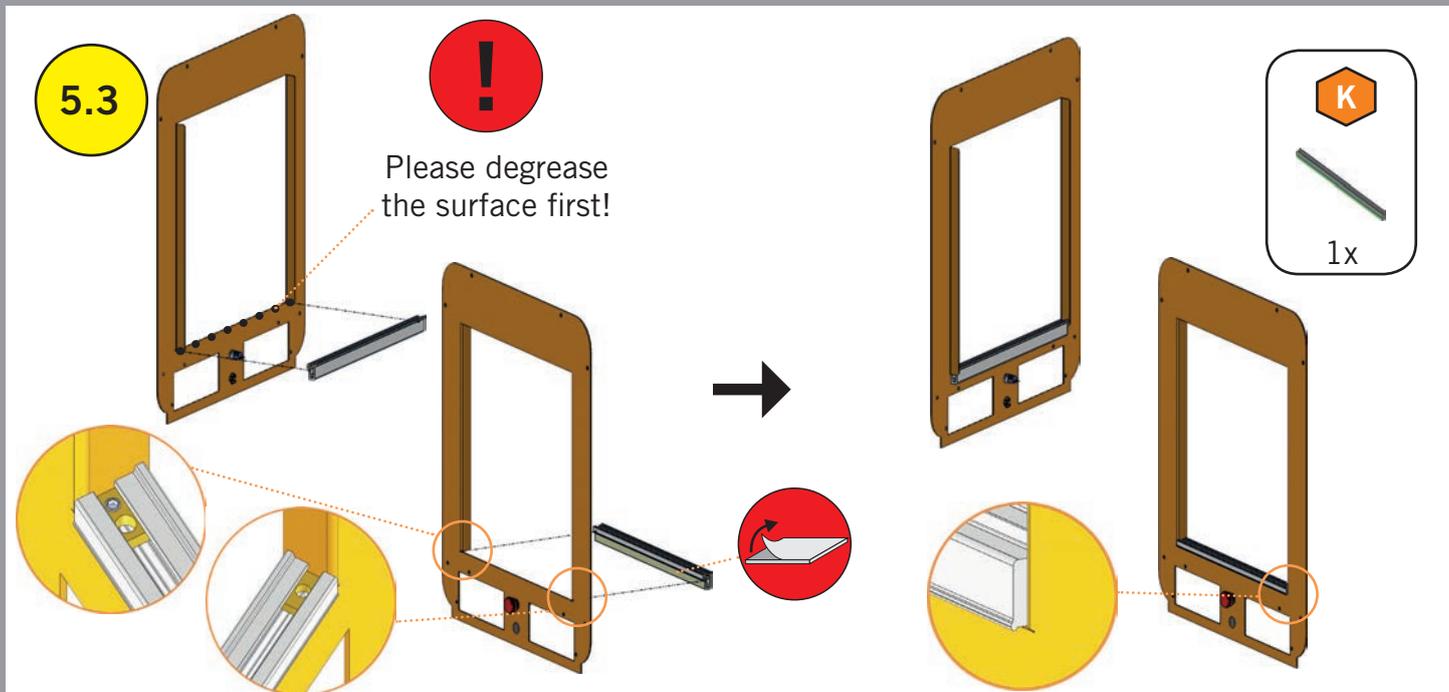
For size 300: Proceed with work step 5.1!
For size 420: Proceed with work step 5.2!

5.1



5.2



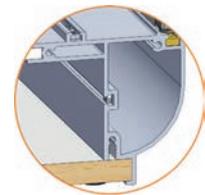
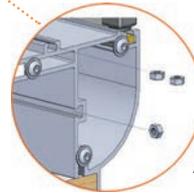
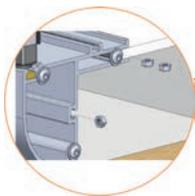
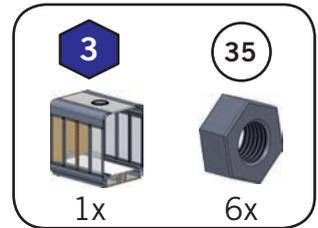
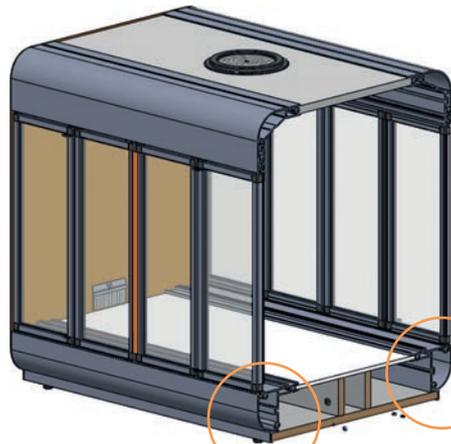


6



Final assembly

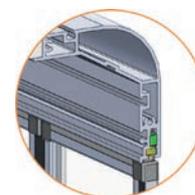
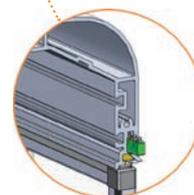
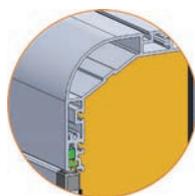
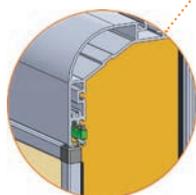
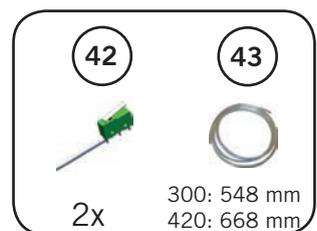
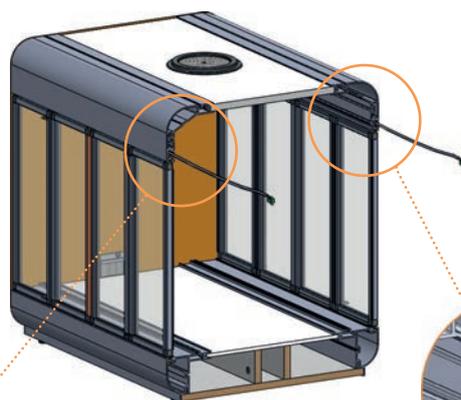
6.1



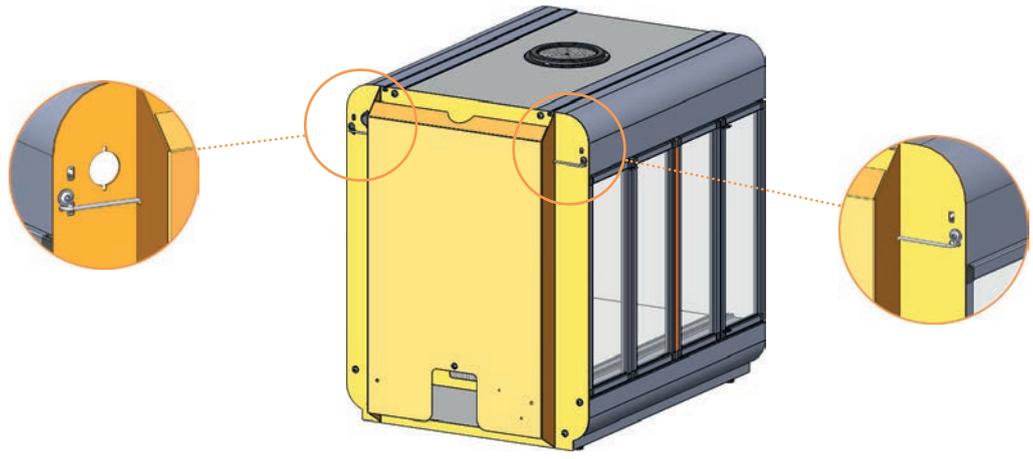
6.2



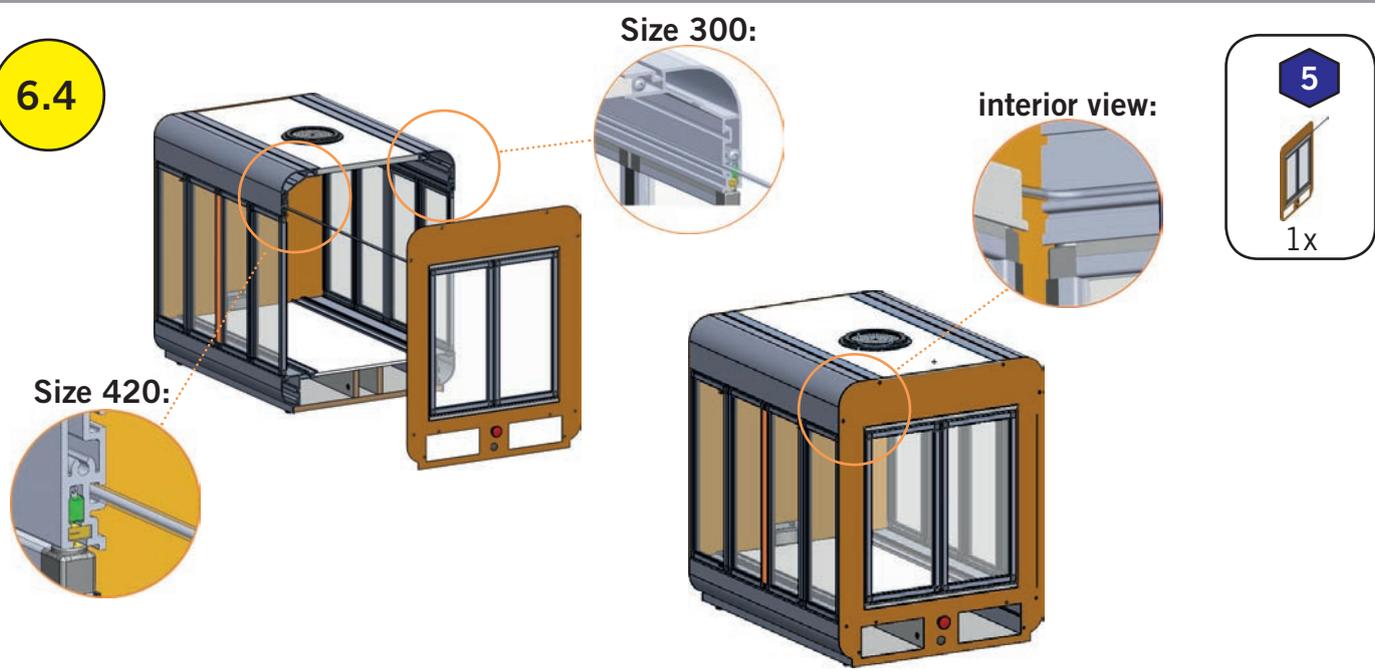
Guide the cable end firstly through the cable conduit and afterwards through the profile.



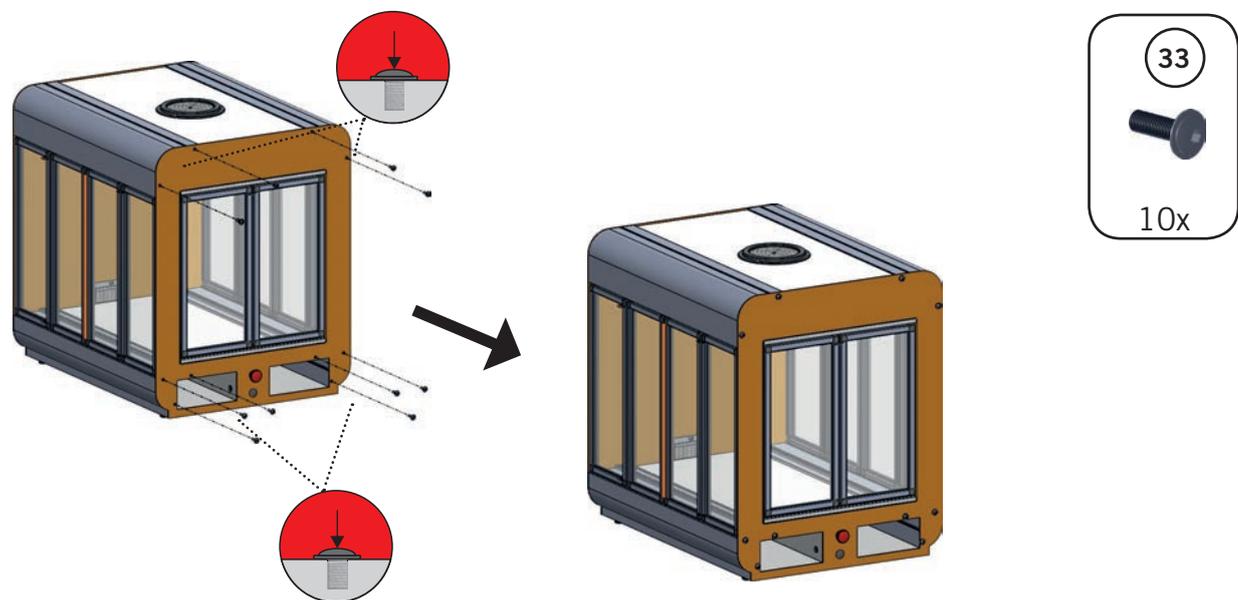
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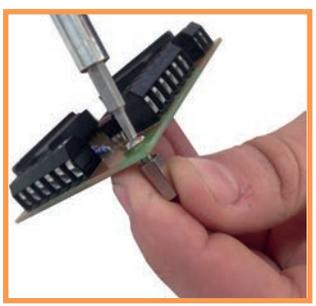
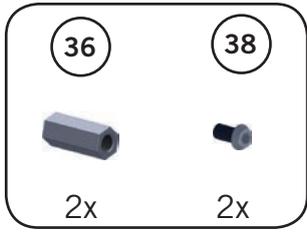
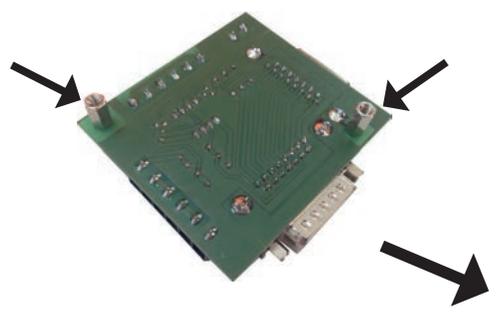
6.4



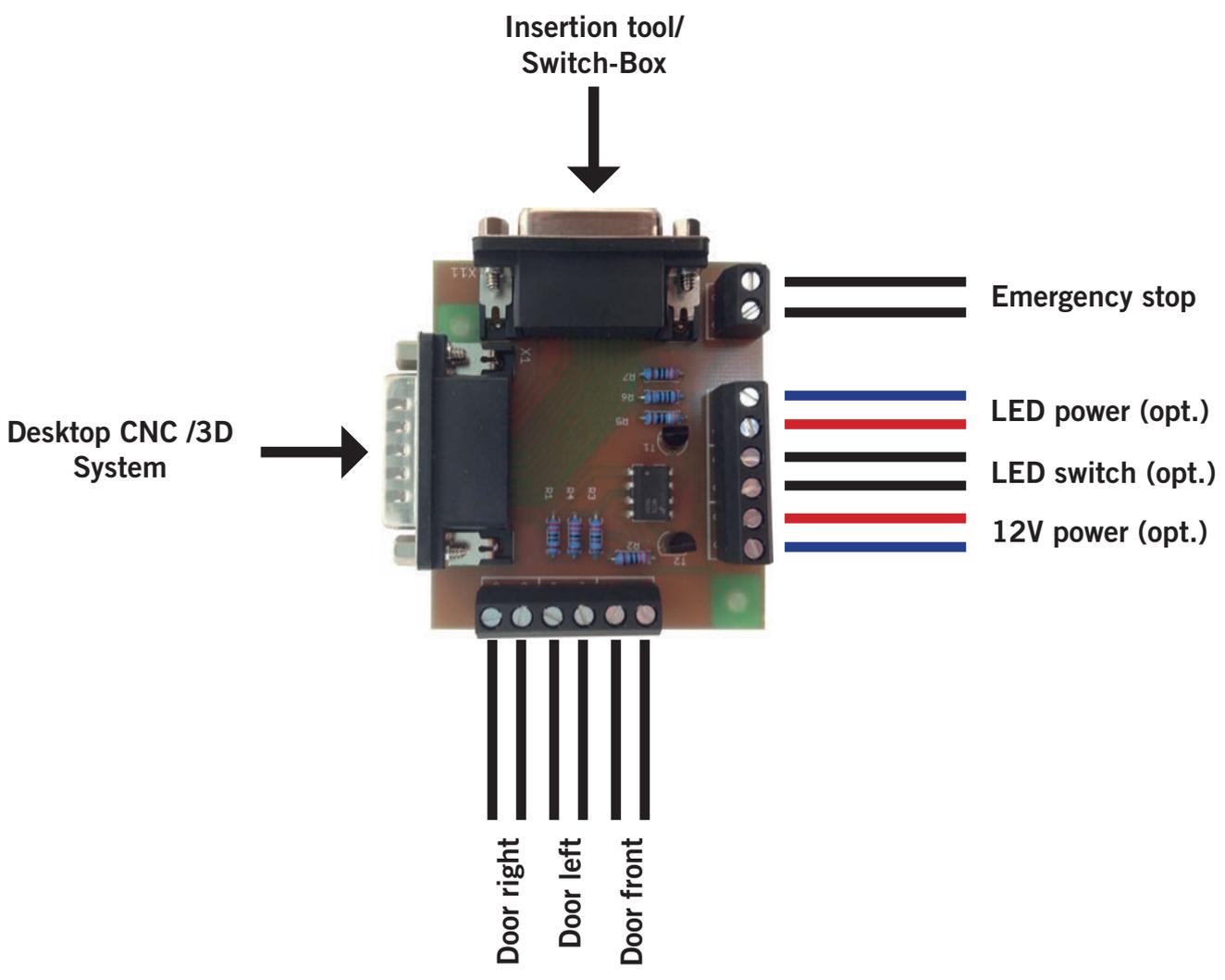
6.5



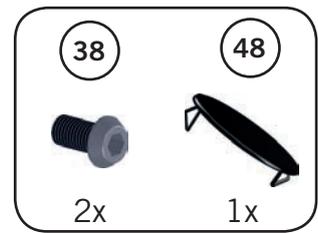
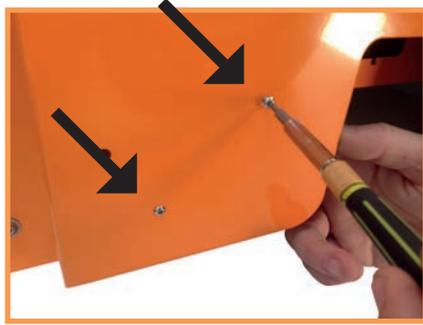
6.6



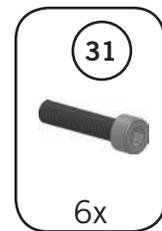
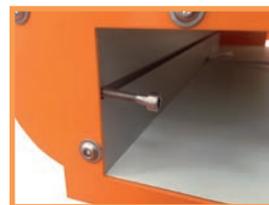
6.7



6.8



6.9



With the socket head screws M5 x 30 mm the **STEPCRAFT** Desktop CNC /3D System, control devices or the Switch-Box and drawers can be fixed in their final position in the enclosure.





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