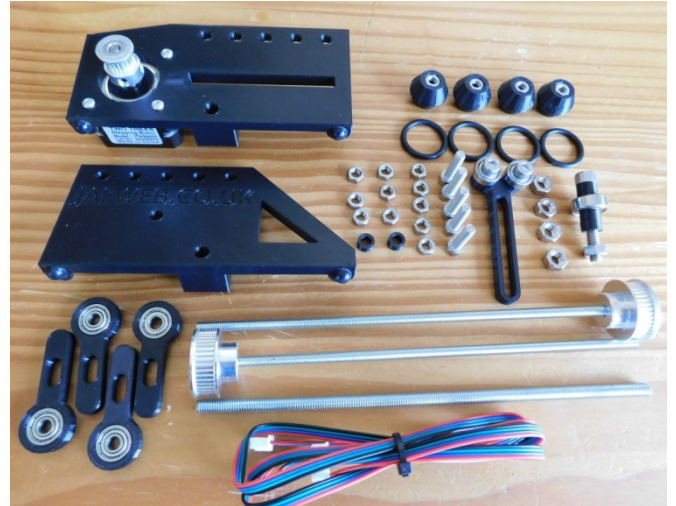


## Jafweb Rotary Jig Assembly Guide (Tool Free)

### Kits Contents

- 1 x Front frame with attached stepper motor
- 1 x GT2 Motor Pulley (20 / 16 teeth, attached to motor)
- 1 x Rear frame
- 1 x Stepper Motor Cable
- 1 x Pre-Assembled Lifter
- 4 x Pre-Assembled Bearing Mount
- 2 x 5mm Axle with attached GT2 40 tooth pulleys
- 4 x Pulleys and Tyres
- 1 x Pre-Assembled Tensioner
- 1 x 6mm Link bar and 4 M6 Nuts
- 12 x M5 Nuts
- 6 x M5 x 20 Bolts
- 1 x Belt – (not pictured)
- 2 x Tiny 6mm spacers©

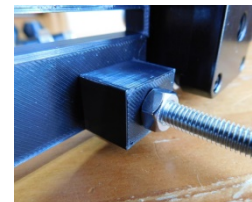


### Frame Assembly

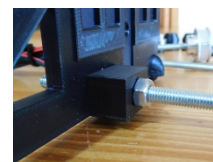
Grab the 6mm bar and roll a nut on both ends to about 30mm.



Push the axle through the block on the front frame and attach an M6 nut until it is flush with the bar. Tighten the rear nut up.

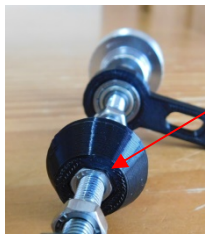


Push the bar through the block on the rear frame part and attach a nut. Spacing not critical here as the jigs length can be adjusted depending on the item you are engraving. Ensure the jig is sat on a flat, level surface and tighten the nuts.



### Assemble the Axles

Slide the parts onto the axles as indicated in the photo →

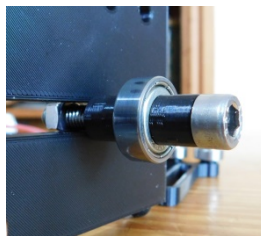


Ensure the embedded nuts in the pulley are orientated correctly – towards the rear of the rotary.



### Attaching the Tensioner

Remove the nut and push the tensioner through the slot on the front frame. Attach the nut on the rear.

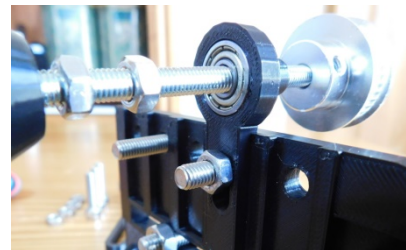


### Attaching the Axles

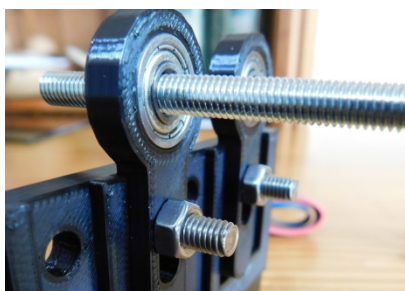
Push two 20mm bolts through the holes on the front frame.



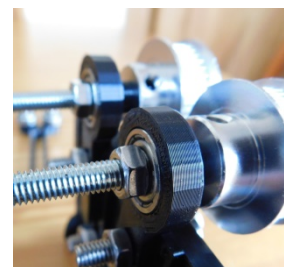
Slide the bearing holder closest to the big pulley over the bolt from the rear and fasten with one of the nuts. Ensure the bearing holder is seated in the slot.



Tighten the first nut on the axle up to the bearing – nice and tight on this one ;-)



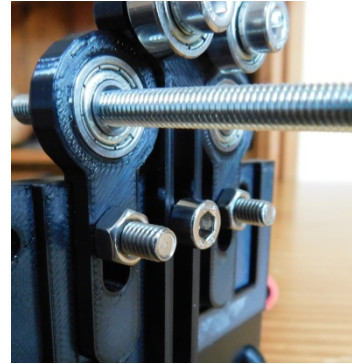
Same process for the rear frame. Push a couple of bolts through, slide the bearing holders over the bolts and attach a nut on the rear.



Again ensure the holder is fully seated in the slot.

## Attaching the Lifter (Optional)

Depending on the item you are engraving the lifter can be attached to the rear frame between the two bearing holders. This can be adjusted vertically to suit your workpiece. I find this easier to install with the bolt pushed through from inside the frame.

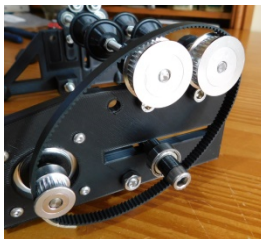


## Pulleys



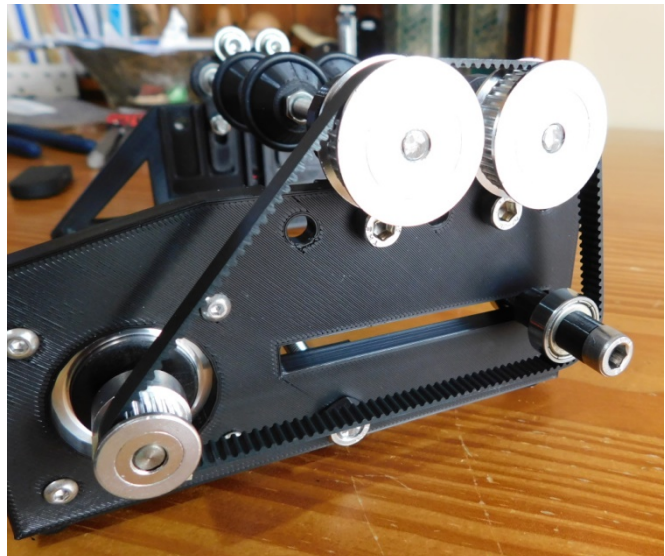
Push the tyres onto the pulleys and ensure they sit in the groove all the way around the pulley. Positioning is dependent on the workpiece. Just roll them into position and secure with an opposing twist of the locknut.

## Installing the Belt



Loosen the rear nut on the tensioner and slide towards the motor. Hook the belt over the gears and tensioner.

Slide the tensioner away from the motor until the belt is tensioned correctly. Lock the tensioner in place with the nut.



## Finally

Pull the plug out of your engraver 'Y' axis motor and attach to the socket on the supplied cable. Plug the other end of the supplied cable into the stepper motor on the rotary and go...