

Roland PNC-2300A/EGX-300 Bed-Leveling Kit

Thank you for purchasing Roland's EGX-300 Bed-leveling Kit. Enclosed is a list of the accessories and the instructions of how to best use the included items.

Accessories List

The following items are included in your Bed-Leveling Kit:

- 5 - Self-adhesive 2" x 8 3/4" Corian® Strips
- 1 - Engravers Tool 1/8" Shank (.090 tip dia.)
- 1 - 3.25" Floppy Disk (containing surface.plt file)
- 1 - Instruction Set

Tools Needed

The following tools which come bundled with the EGX-300 will be needed to complete this task:

- 1 - Red-handle Allen wrench
- 1 - Depth-nose gauge
- 1 - Dust collection hose (optional)

NOTE: Please read this instruction set thoroughly for a better understanding of the described procedure.

Instructions for using the EGX-300

Bed-Leveling Kit

Step 1: Working with one section at a time, peel the liner from the back of each Corian® strip.



Step 2: Align each strip over the existing table and apply one section at a time.



Step 3: Be sure to leave the T-Slots uncovered for future use.



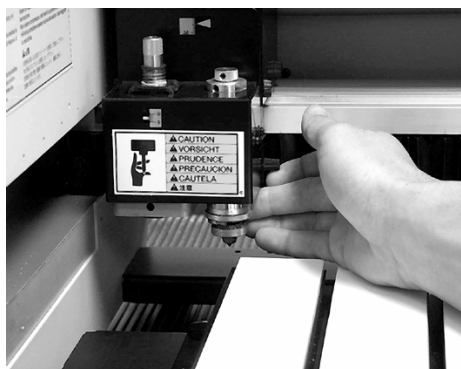
Step 4: Using the engraving tool provided with the Bed-Leveling Kit (.090"), load it into the brass tool holder.



Step 5: Secure the cutting tool into the Spindle Unit.



Step 6: Adjust the depth-nose gauge so the cutting tool is flush with the bottom of the gauge (or just slightly inside).



Step 7: Using the arrow keys of the keypad on the EGX-300, position the cutting head somewhere over the center of any of the strips.



Step 8: Again, using the keypad, press the **-Z** key to lower the spindle head so the bottom of the depth-nose gauge rests directly on top of the Corian® strip.

Step 9: While the head is resting on the strip, press the Enter/Pause key on the keypad. This will put the controller in the X Y Z axis set mode. Now, press the right-facing arrow of the keypad and the letter Z of "Z axis set" will be blinking. Press the Enter key once again.

Step 10: The controller will now display the Z-axis coordinates (usually a negative number). Press the Enter key one more time and brackets will now appear around the displayed value. The EGX-300 has now been set at Z-zero (Z0).

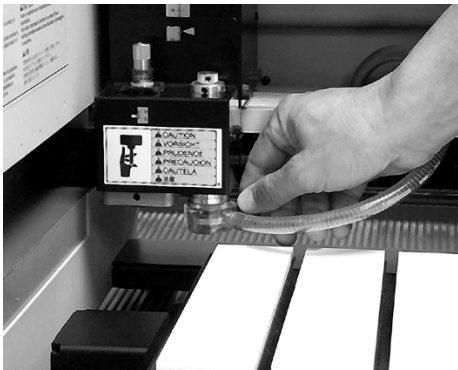
Step 11: Press the Menu key until the control panel displays the current X, Y and Z position values. Press the **+Z** key until the cutting head is in the upper-most position. Now press the left arrow key until the cutting head is in the far left position and then press the forward arrow key until the head is all the way forward.

Step 12: Again as in steps 9 and 10, press the Enter/Pause key on the keypad. This will put the controller in the X Y Z axis set mode. Press the Enter key once again and the current X/Y position will be displayed (usually 0,0). Press Enter once again and the EGX-300 is now set to the home position for leveling the Corian® strips.

Step 13: Before sending the leveling cut file to the EGX-300, dial the depth-nose gauge to expose the cutter from the bottom (at least .125" to .25" of the cutter blade should be showing and close the plastic front cover.



Step 14: (This step is optional but can save time in the cleaning process). Slip the vacuum-hose adapter around the depth-nose gauge and secure it by tightening the thumbscrew. Also set the Spindle speed to the Max speed for cutting.



Step 15: Using the floppy disk provided, insert it into the floppy drive (A: Drive) of your computer. If your computer does not have a floppy drive installed on it (legacy free PC), you can download the files from the support page of the website (www.rolandasd.com) and copy the files to your local (C:) Drive.

Step 16: If using Windows® 95/98/Me, click the START button on the task bar, highlight Programs and scroll down to MS DOS Prompt. If using Windows® 2000/XP, click the Start button on the task bar, All Programs, Accessories and click on Command Prompt. This will take you to the DOS prompt screen.

Step 17: Making sure the disk is installed into the floppy drive or file is copied to the root drive of C:\ and the EGX-300 is connected to the Printer port, type the following line at the DOS prompt:

copy a:\surface.plt lpt1: (if using the floppy disk)
copy c:\surface.plt lpt1: (if running from C Drive)

Step 18: Now press the enter key on the computers keyboard and the machine will begin the leveling process that should take approx. 20 - 30 minutes to complete.

