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The Best
Rotary Attachments
for Your Engraving

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Released **November 1, 2019**
Updated to **All Metal Plates 1 June 2020**
Updated To **All Metal Components 1 Oct 2021**
AutoBoss DIY Kit Added April 2022
Rotoboss and Rotoboss Junior 2.0 1 Nov 2022
Rotoboss Ascend Released April 2023
Rotoboss BOOT Release September 2023
RotoBolt Release September 2023
Talon Chuck Release 1 Feb 2024



INTRO

I want to thank you for your purchase of the last Rotary you will Ever need! My goal has been and always will be to supply you with the very best product that I can and customer service that is second to none.

I have carefully thought of every possible way to make this the very last Rotary you will Ever need, but of course that is just one person's perspective on this. If you have any suggestions to make it better please let me know and I will take every possible measure to implement needed changes and in most cases at no expense to you.

The Complete Line of RotoBoss Rotary Attachments carry a **LIFETIME WARRANTY! from the date of purchase. Warranty covers any mechanical defect, failure of the rotary, and /or its components at no charge to you. Motors carry a one year only Warranty.**

If you have received this product and it is damaged please take pictures of everything and send them to us so we can file a claim with the carrier. I will get replacement parts sent out right away!



Please leave a review/feedback good or bad on my pages:

Contact sources and social media links for the Rotoboss Line of Rotary Attachments.

Email

support@rotaryattachments.com

WEB@

www.rotaryattachments.com

FaceBook Links

RotoBoss Rotary Attachments,
<https://www.facebook.com/Rotobossrotaries>

RotoBoss Rotary Attachments Group,
<https://www.facebook.com/groups/559200807984810>

Tools and Jigs For Boss & AEON Lasers Group
<https://www.facebook.com/groups/540298903199333/>

Turn N' Burn Podcast
<https://www.facebook.com/groups/700655388667441>

Everything Laser Rotary Engraving
<https://www.facebook.com/groups/1024017924597485>



Please leave a review/feedback good or bad on my pages:

Contact sources and social media links for the Rotoboss Line of Rotary Attachments.

Youtube

<https://www.youtube.com/channel/UCzrLYdbjyIXjJM91ulclQhQ>

Like, subscribe and ring the bell to be notified of new content.

Instagram

<https://www.instagram.com/rotobossrotaries/>

TikTok

<https://www.tiktok.com/@rotoboss>

Video Glossary

****Right Click to open link if it does not open normally ****



Video explaining the differences between the RotoBoss models:

<https://www.youtube.com/watch?v=KnjNhZg064k&t=2s>



ALL METAL UPGRADE KITS Install Video:

<https://www.youtube.com/watch?v=3RAAg0gFZuU&t=631s>



Rotoboss Rotary Attachments Accessories Video:

https://youtu.be/P7Gb_nHm8eM



Low Roller Placement & Setup Video for Thunder NOVA 24:

<https://youtu.be/Z347Oe2bhKU>



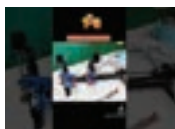
RotoBoss and RotoBoss Junior Quick Slave Wheel Adjustments:

<https://youtu.be/FZsqaixqSsM>



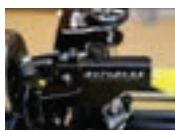
RotoBoss and RotoBoss Junior Setup and install for Thunder NOVA 24-63:

<https://youtu.be/ehcZF9LSWkk>



AutoBoss (for RotoBoss Rotary) in Action:

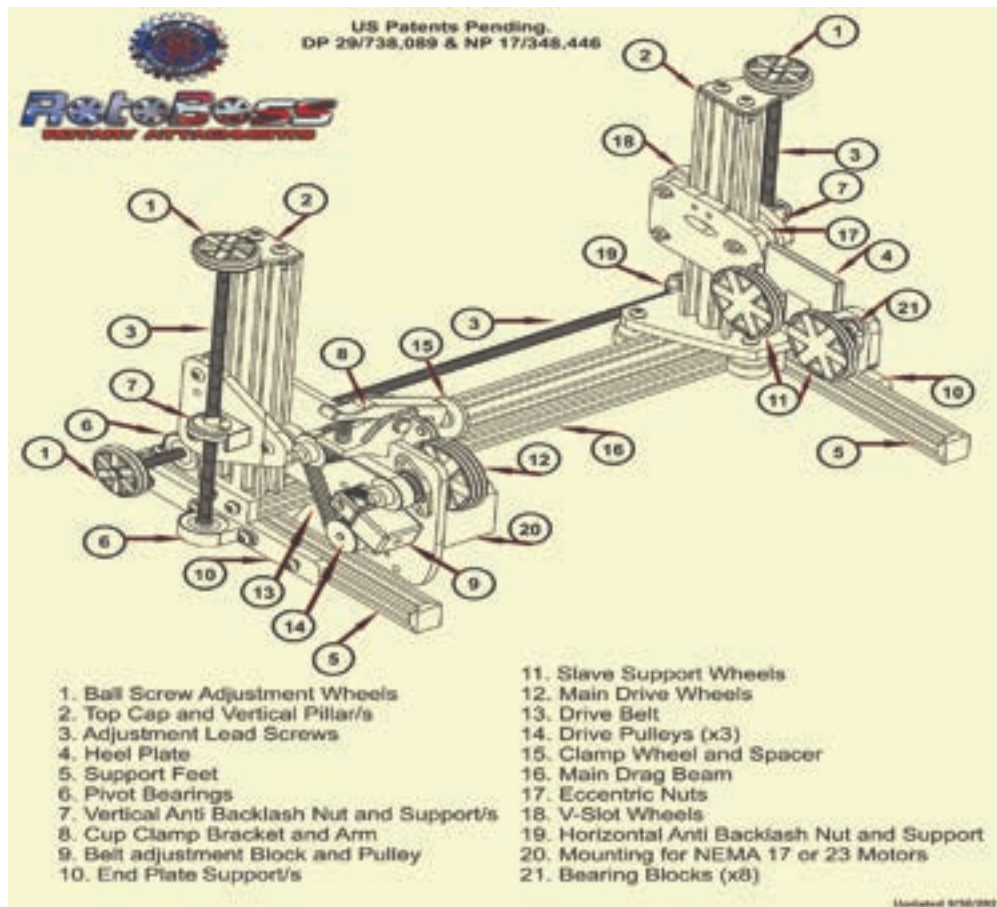
<https://youtu.be/QJTMaI-Y6l8>



Spring Loaded heel Wheels Install/Use

https://www.youtube.com/watch?v=CyDu1r_E-PM&t=91s

ILLUSTRATED PARTS BREAKDOWN (IPB)



Why the RotoBoss Rotaries?

Video explaining the differences between the models:
<https://www.youtube.com/watch?v=KnjNhZg064k&t=2s>

RotoBoss Rotary Attachments are my creations out of necessity. I was tired of the same old rotary on the market, and for the past several years I have been making parts to improve the existing China rotary supplied by many laser manufacturers. After making parts, I decided to make my very own Rotary that addresses all the issues I have seen and dealt with. These Rotaries are unlike any on the market today and hands down the last and only Rotary you will ever need.

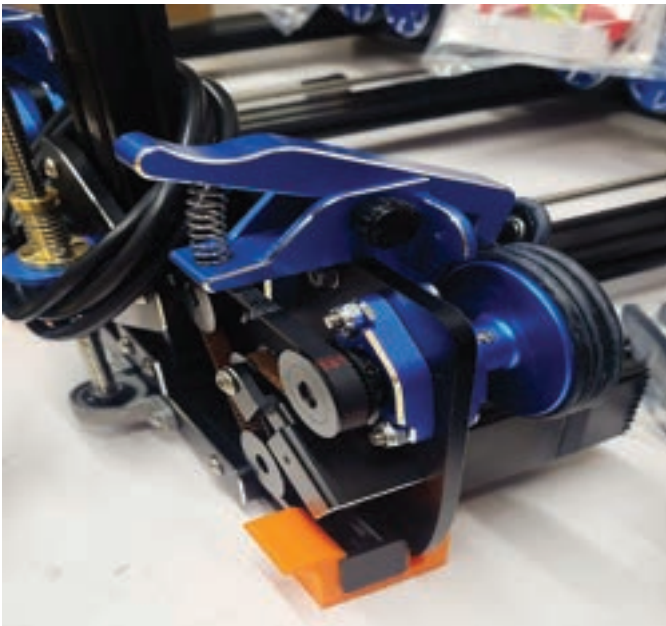
If you see anything similar to my rotaries under a different name they are clones or copies of the one and only.



I have made this **Rotary universal** for use on many different machines running on Light Burn, RdWorks and EzCad With: Nema 17 and 23 with stepper and servo motors so there is a rotary for every machine.

ROTOBOSS Shipping Bracket Removal.

CAUTION!!!!!!!!!!



Remove this **Orange or Red** shipping bracket before use. Failure to do so may result in damage to your Rotary.

General Information:

All of the RotoBoss Rotary Attachments will Currently work with ANY laser using a Ruida or Trocen Stepper motor controller Utilizing any NEMA 17 or NEMA 23 Motors, by just simply swapping out motors with no modifications needed, because the mount has mounting holes for both types of motors.

Your rotary comes equipped with a top of the line 2 or 3 Phase stepper motor in the form of a NEMA 17, 23 or Integrated stepper motor that properly suits your application. Your Rotary will come pre wired for use on your machine as needed and that is Plug and Play with your machine.

The RotoBoss Rotary attachments can be purchased at one of two stock lengths based on your laser size and configuration.

- ✓ The Full Size 22 inch wide (side to side) is suited for most machines with bed measuring over 16x20in
- ✓ The 15.5 inches wide (side to side) is suited for most machines with bed measuring Less than 16x20in
- ✓ Available now is an extension kit allowing you to quickly and easily add up to an additional 19in of length or more depending on current rotary length and setup

System checks prior to use!!

- ✓ Check and make sure that your machine was received in good condition IE. any broken, bent or busted pieces and parts.
- ✓ Ensure there are no loose or missing bolts, screws etc.
- ✓ Check Tensioner pulley block bolt for tightness to make sure it didn't loosen after initial setup and shipping (most common issue)

Consumable Materials Listing

Drive/Slave Wheel O-rings = 4mm x 45mm(ID)

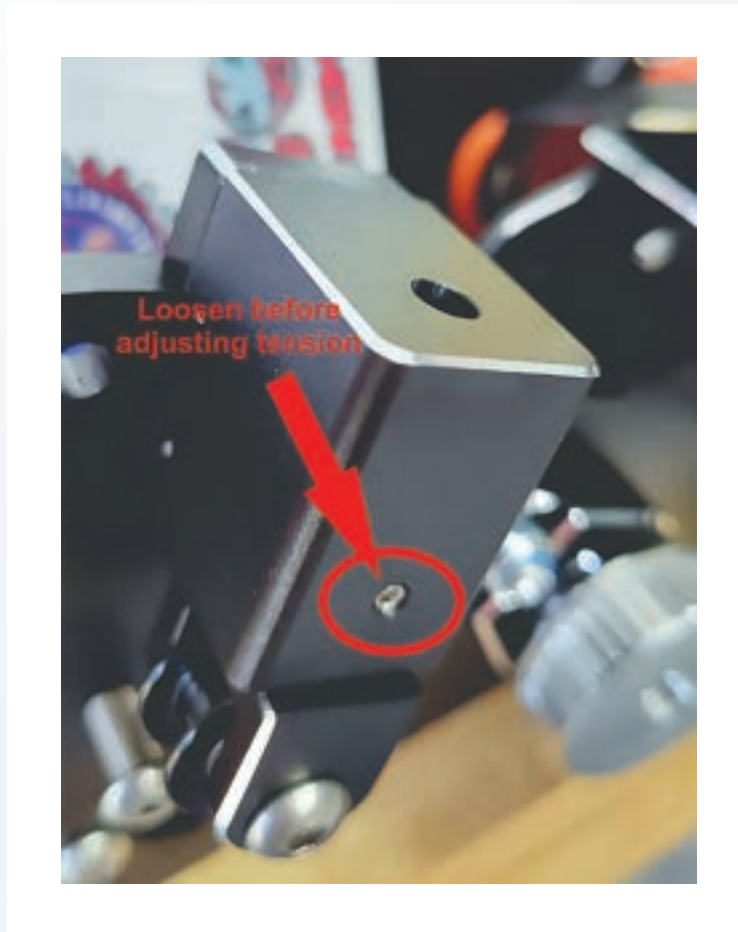
Small Clamp Wheel = 4mm x 12mm(ID)

Large Clamp Wheel = 4mm x 20mm(ID)

XL Clamp Wheel = 4mm x 24mm(ID)

Ball Screw/Low Roller Drive Wheels = 4mm x 32mm(ID)

BELT TENSION ADJUSTMENTS “ONLY”



Make sure to loosen the set screw before making adjustments to the tension block.

****Do not over tighten the belt as it may cause damage.****

Set screw is 1.5mm

Adjustment screw is 3.0mm

Rotary Placement in your Laser:

NOTE Since these rotaries work in a wide range of lasers the placement in your laser may vary based on the Laser and Rotary combination you have. Below are recommendations and common practices for placement of the rotaries in machines unless expressly written below.

***** Remove the Honeycomb bed and blades if installed** "as needed" to fit the rotary into the laser machine. Place your rotary into the machine firmly on the Honeycomb bed, (if clearance permits) bottom of the machine, on the crossbars in the bottom of the bed with the **motor on the left** side looking into the machine (with exceptions below). This placement is key to the proper rotation and orientation as it is how the rotary was designed.

***** ONLY For Thunder laser users** with a machine that has a 5 Pin Plug for the rotary and All AEON lasers, your rotary will sit in the machine with the Motor on the right as you look into the machine. The 5pin Thunder can be used either way around by swapping dip switch number 5 to off on the motor if you prefer a different orientation.

***** Due to the homing of different kinds of lasers and clearance issues** with the head and or gantry Thunder Laser Odin and AEON Users Please note your Rotary is set up from the manufacturer to run and should be placed with the motor on the right for all the AEON lasers to prevent gantry from potentially contacting the rotary tower/s.

******* If you receive a rotary and you place it in the machine as directed above and your image comes out mirrored all you have to do is turn the rotary around 180 deg and then flip artwork 180 deg and it will engrave fine. This is a rare occurrence and may have been wired incorrectly for your machine to run the motor on the left side (excluding AEON) Simply turn the rotary around, you will not lose any function of the rotary because they are made to work either way.

Rotary Placement in your Laser:

The best way to line up your rotary (in most cases) is to draw a line down the middle of a cup and move the red dot over one side and then shift it to the other. You will adjust the rotary placement until it is straight. The center of the motor side of the rotary can be found by placing the red dot over the clamp arm and centered. You may also line it up with the X axis gantry by sighting down the bar to line up the rotary cross bar.



Machine and Software setup

NOTE: These settings are based on testing of said machines and are only baseline numbers that may need to be tweaked for your machine/setup

Setup instructions on the next 2 pages.

Ruida Controllers settings for Lasers:

Settings below are for Rotoboss, Junior and Ascend Rotaries. Low Roller uses the same steps but with 44mm Rotary diameter.

Pre 2020 Boss Laser LS 1416 and 1420: Circle Pulse/Step per rotation is set to = 6100
Roller Diameter is set to = 56mm/2.20in. These settings gave good results for all size objects tested from a shot glass to a large beer mug.

Post 2020 Boss Laser LS 1416 and 1420: Circle Pulse/Step per rotation is set to = 3400
Roller Diameter is set to = 56mm/2.20in.

Boss Laser LS2436 thru 3655: Circle Pulse/Step per rotation is set to = 5,650
Roller Diameter is set to = 56mm/2.20in.

Boss Laser LS 16 series: Circle Pulse/Step per rotation is set to = 5,210
Roller Diameter is set to = 56mm/2.20in.

AEON Laser Nova series: Circle Pulse/Step per rotation set to = 10,200
Roller Diameter set to = 56mm/2.20in.

Thunder Laser: Circle Pulse/Step per rotation set to = 4400
Roller Diameter set to = 56mm/2.20in.

Aurora Low Roller Circle Pulse/Step per rotation set to = 4400
Roller Diameter set to = 44mm/1.73in.

Rotobolt Circle Pulse/Step per rotation set to = 4300
Roller Diameter set to = 24mm/.94in.

AP Lazer 1812: Circle Pulse/Step per rotation set to = 6450
Roller Diameter set to = 56mm/2.20in

Orion Motor Tech (OMTech) 50W CO2 Laser Circle Pulse/Step per rotation = 2300
Roller Diameter 56mm/2.20in.

LAGUNA EX/MX Laser: Circle Pulse/Step per rotation = 4650 and
Roller Diameter 56mm/2.20in

Yorahome 40W Diode Laser: Circle Pulse/Step per rotation = 41.5mm
Roller Diameter 39.12mm/1.57in

Light Burn Setup

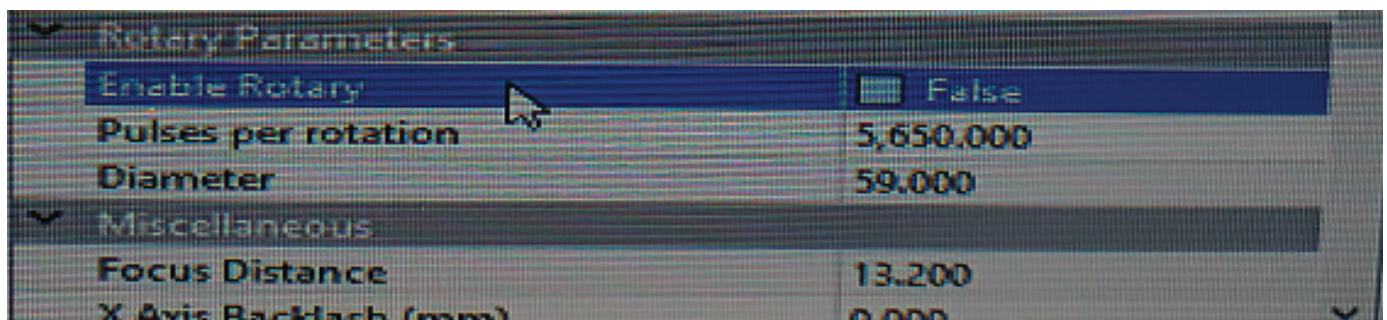
Using Lightburn, setup your settings as follows:

Example photos only!

Rotary Manufacturer recommends only using Machine setting to make changes to rotary setup.

From the main screen, click on the Edit tab and scroll down to the Machine settings tab (make sure the laser is on and connected to your PC) Scroll down to the Rotary parameters and fill in as shown below. **In the rotary settings make the change as required to the “Rotary Diameter” and “Steps per Rotation”** Your numbers will differ based on the machine. You can also use this screen to turn rotary on or off or with the button shown below on the main screen of Lightburn. I have found that If you use the rotary setup screen it will not function properly and the extra info they can ask for that is not applicable to Roller rotaries..

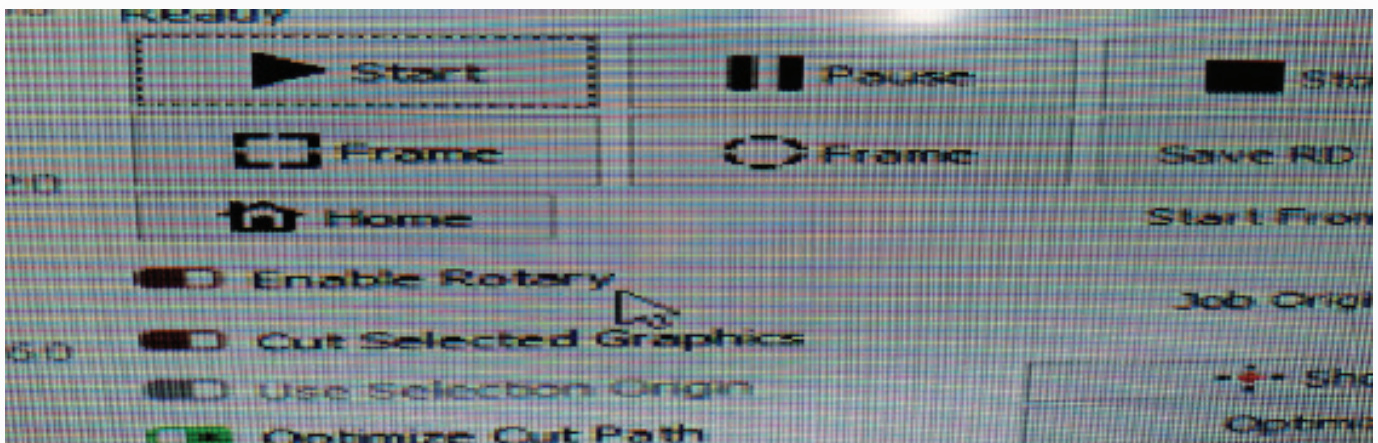
Example Photo, not particular to any laser



Light Burn Setup

Using Lightburn, setup your settings as follows:

Example Photo, not particular to any laser



For Lightburn, if you do not have The Rotary enable switch on your main screen do the following. Go to the Edit tab, scroll down to settings. Look for the tab that says show rotary enable and click it green. Hit ok and it will exit to the main screen, you should now have the enable rotary button under the las

Software Setup prior to running your machine:

Once this setup is complete you should be able to do everything from small mugs to 30oz cups with little to no adjustments required of the Steps per Rev. outside that steps should be used to make corrections based on the type of object you are using.

With a 20oz tumbler (preferably for best results) Complete the setup as follows:

Create a 25.4 x 25.4 mm or 1in x 1in box and fine tune setting from there. If the image is stretched lower your Steps per rev and vice versa for too small.

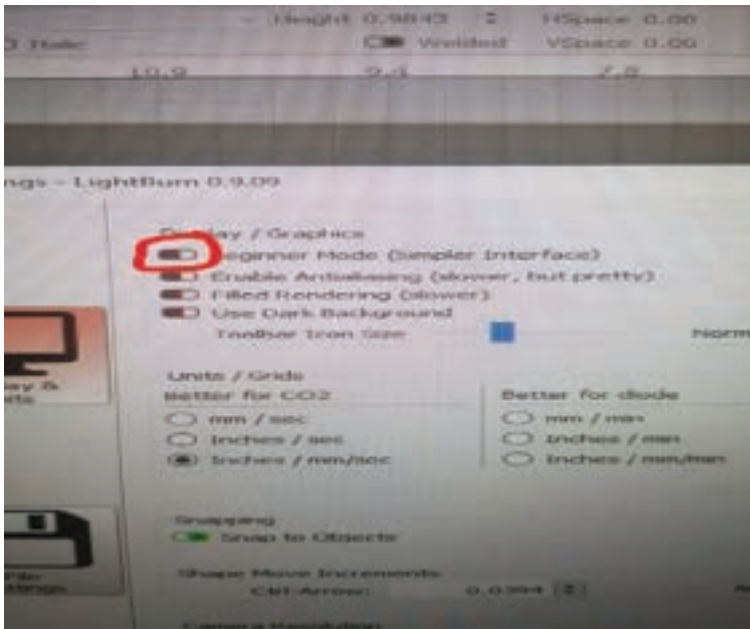
“Do Not” Change the object diameter, it should be at 88mm and left alone (setup was designed with these numbers although not applicable now). The only changes should be made to the Steps per rotation as needed for your given object.

“Do Not” Use absolute coordinates when using the rotary or you will get an error. You should use either “User Origin” or “Current Position” when using the Rotary and always hit origin on the Laser control panel once you position the Rotary and head to insure proper operation.

If you choose to do the 360 deg test in lightburn it will alter the true 1 to 1 scale that the above instruction set you up with and should be two separate setting files for when doing engraving based on your project (standard logo or wraps)

When trying to enable the rotary button for Y axis driven machines, for the main screen follow previous instructions and search for beginner mode(circled below) and make sure it is disabled as well.

Software Setup prior to running your machine:



From **RDWorks** take your image and rotate it 90 Deg (top of image should face left)

From **LightBurn** take your image and rotate 270 deg For Boss, Full Spectrum, Thunder, Xtool, K-40(top of image should face left) or 90 deg for AEON and some Laguna (top of image should face Right)

Below pictures are

(EXAMPLE PICTURES ONLY!!!!!!!!!!!!!!)

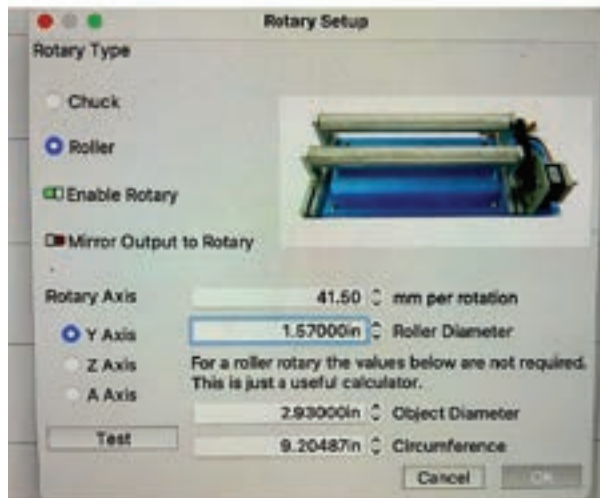
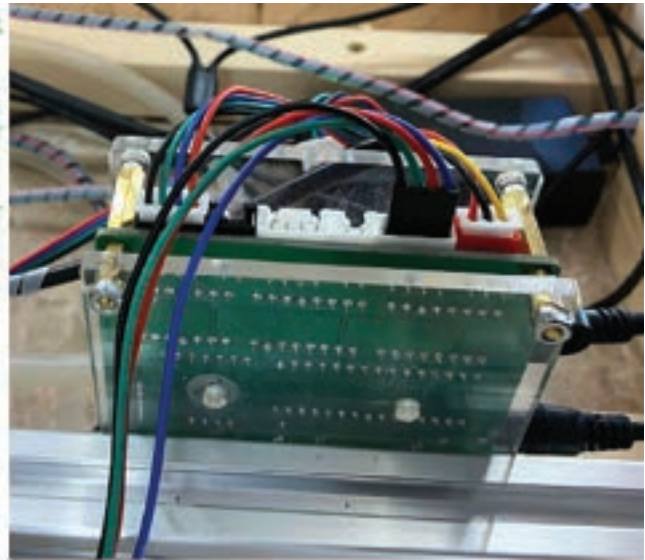
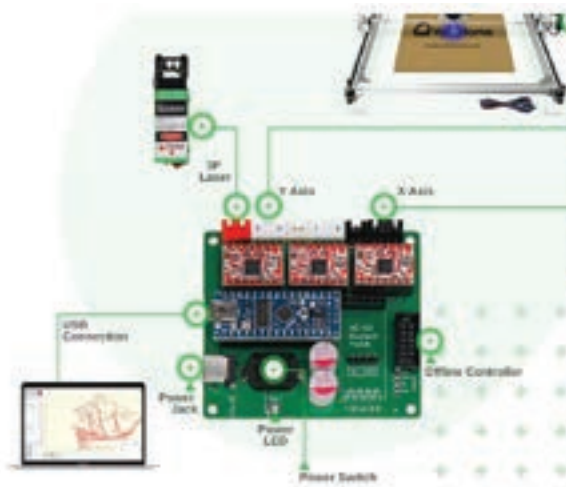
If the above numbers do not work check your Y Axis controller to see what the Pulse/Revs are for the given DIP Switch positions. (see below) These charts give you a good baseline to work from, but with so many different gear ratios it is hard to say if these are 100% accurate. The trend indicates for my rotary, your Pulse/Rev is about 1.5 times the number on the chart (example 4000 on chart is 6000 in software settings) Again, every machine can vary and these are ONLY suggested settings based on testing and may need fine tuning.

**For Thunder Laser's Nova Series Lasers on,off,on,off,on,off, on,off
Odin and Bolt on,off,on,off,off,off**



If you have trouble with your settings please feel free to contact me and I will assist as needed. If you get your numbers dialed in, I ask that you share those settings with me so I can update this manual to aid others with their like machines.

Yorahome 40W DIODE Laser Setup



ALL METAL UPGRADE KITS

Install Video: <https://www.youtube.com/watch?v=3RAAg0gFZuU&t=631s>

(Black or Blue)

<https://rotaryattachments.com/shop-2/Metal-Rotary-upgrade-kit-for-current-owners-with-metal-plate-rotaries-p385613164>

O-rings May Vary

RotoBoss Metal Upgrade Kit



RotoBoss LOW ROLLER Metal Upgrade Kit

O-rings May Vary

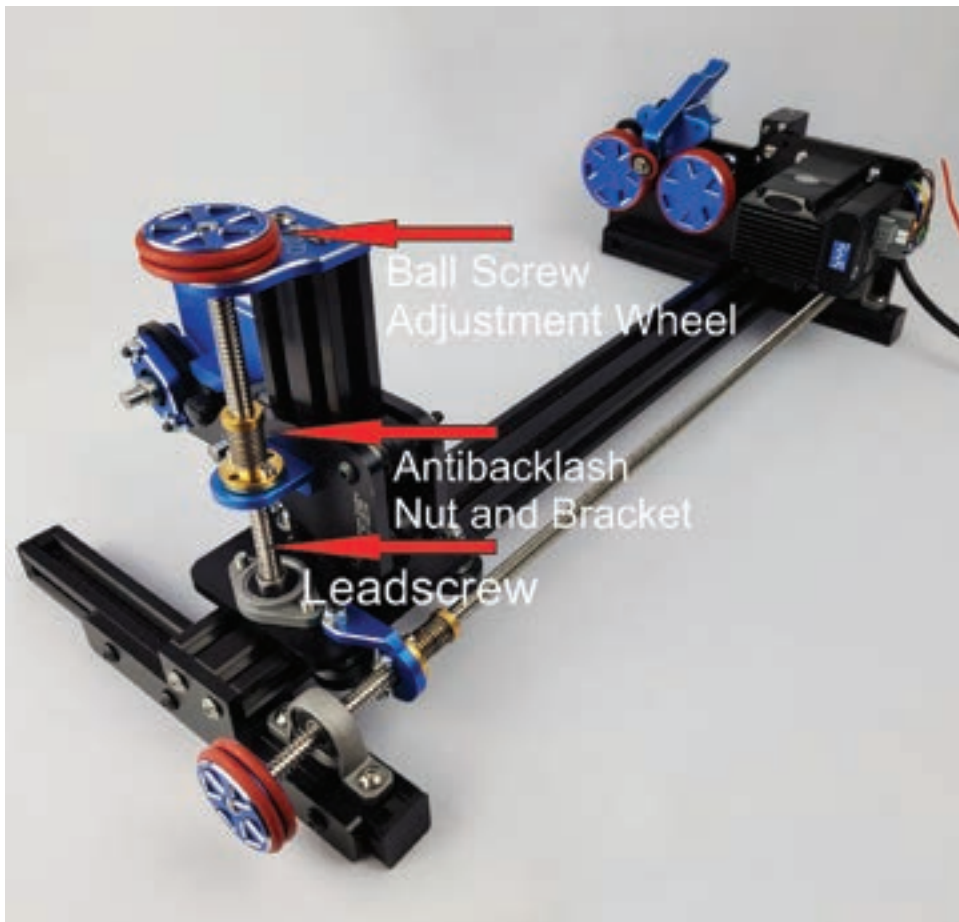
<https://rotaryattachments.com/shop-2/Metal-Rotary-up-grade-kit-for-current-owners-with-metal-plate-rotaries-p385613164>



Vertical Adjustments:

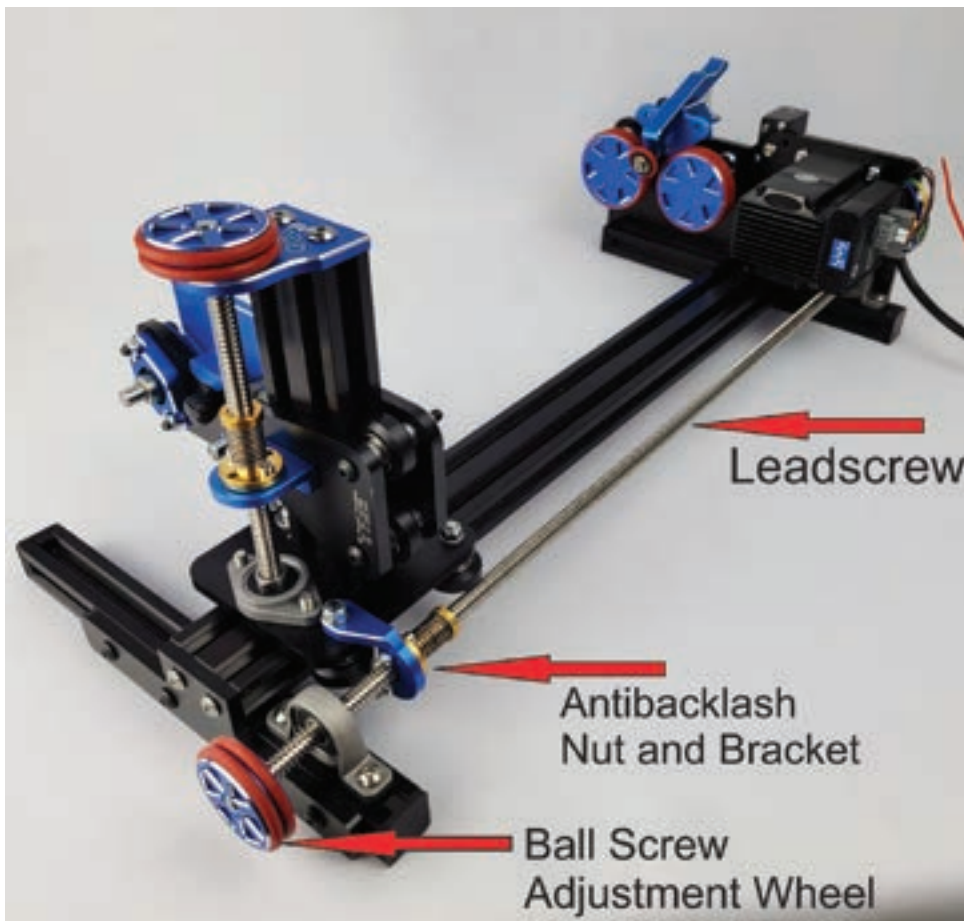
The most unique feature for the **Rotoboss Rotary Attachments** is that NO other Rotary has a Precise mechanical adjustments and holding on both sides of the rotary machine to allow perfect and consistent vertical adjustment of both the Motor and Slave wheel side to accommodate those awkward and otherwise hard to engrave items such as bottles, vases, wine glasses and more. Pictures below show the two adjusters, one on either end.

The use of lead screws and anti-backlash nuts allows for simple, quick and efficient adjustment by just turning the knob until the desired height is reached. They will hold and maintain position nearly eliminating the need for locking thumb screws.



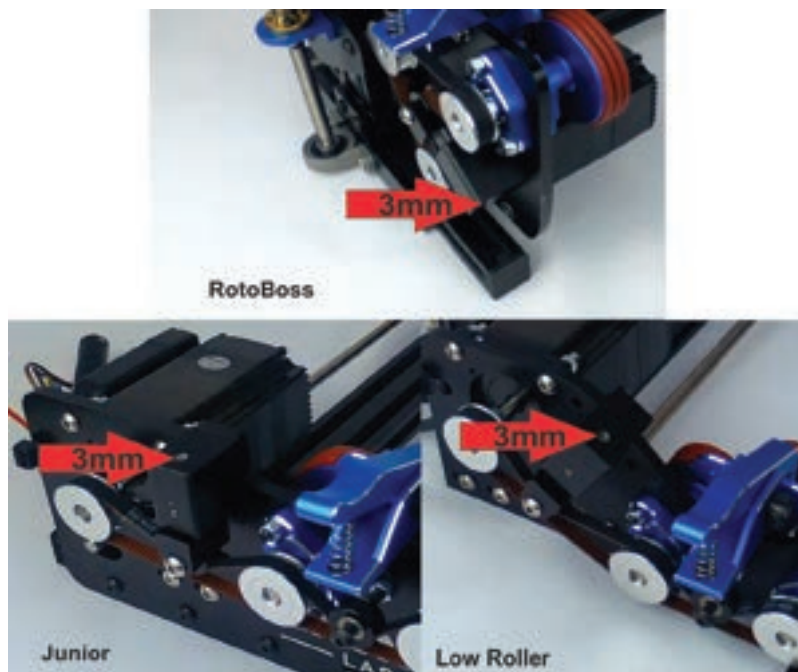
Adjusting horizontal sled:

Another One of a kind horizontal Lead Screw for adjusting the gap distance between rotary wheels can be adjusted by simply turning the knob or (as I do) just twist the rod with your finger for quick and accurate adjustments that hold their position. Lead screw can be removed to allow for adjustments without the lead screw.



The Drive Side Assembly: (some components may vary based on model)

This side has the block and pulley tensioner (Red Arrow) to quickly and firmly adjust the belt tension as needed to maintain proper contact or loosen to change belt. **(do not over tighten belt, could cause damage)**

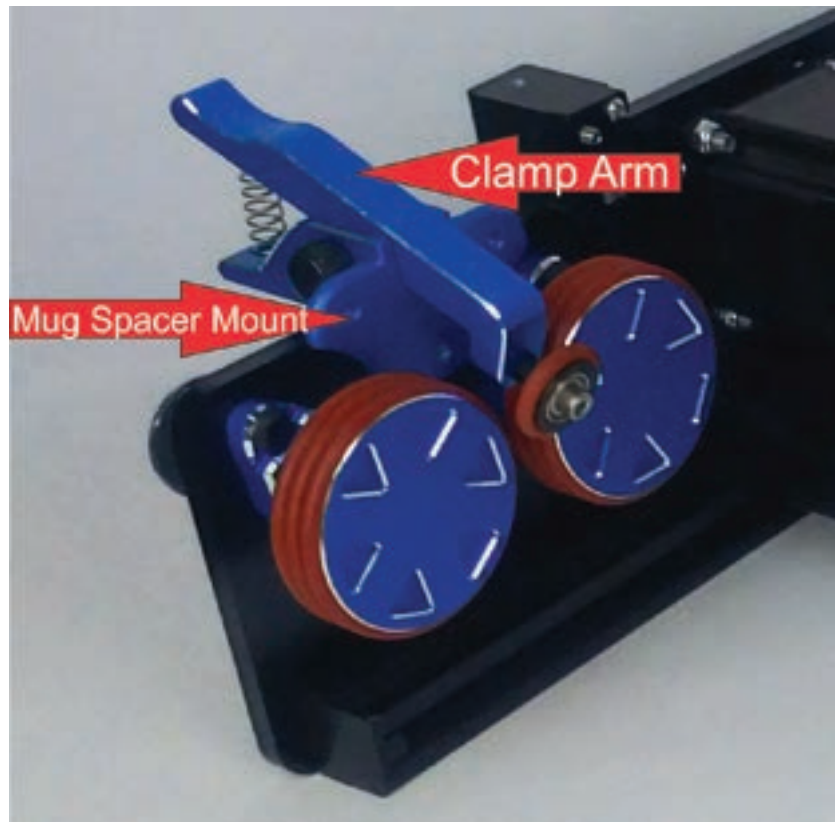


On top of that is the forward backstop that holds the cup clamp bracket and optional mug spacer attachment and bottle clamp arm. If the cup clamp is not needed for the job, simply remove the thumb screw and take off the clamp arm. If you use the optional bottle clamp arm, simply remove the cup clamp arm and install the bottle clamp arm in its place. **Be careful of the spring, make sure it doesn't fly out.**

The Cup Clamp/Mug Spacer:

The clamp arm mounted to the left side or motor side of the Rotary is used to provide downward pressure on the inside of the cup and sandwich the object between the drive wheels and clamp. This assembly is shipped with a small wheel (attached) and one Larger wheel. **If you find yourself needing more pressure on heavy or odd shaped objects, try using the supplied Large Wheel provided to do so.**

NOTE Mug spacer (Pictured below) is only used for doing mugs and but may be suitable for use with other non handled objects. Please remove the spacer if not needed to ensure proper fitting of cylindrical objects.



Bottle Clamp and Mug Spacer Attachments:

Accessories Video: https://youtu.be/P7Gb_nHm8eM

Bottle Clamp (For the RotoBoss only) is for clamping bottles and smaller cylindrical items that are too small for the cup clamp to hold. Simply remove the thumb screw securing the cup clamp to the bracket and replace it with the bottle clamp.

Mug Spacers: Rear spacer slides over the heel plate two different ways depending on the need. Front mug spacer mounts to the cup clamp arm bracket with supplied hardware allowing you to safely distance and secure handled mugs so they do not make contact with the drive wheels.



Rear Mug Spacer, Slides over the Heel Plate. (reversible)

Front Mug Spacer, Attaches to the face of the cup clamp mount bracket



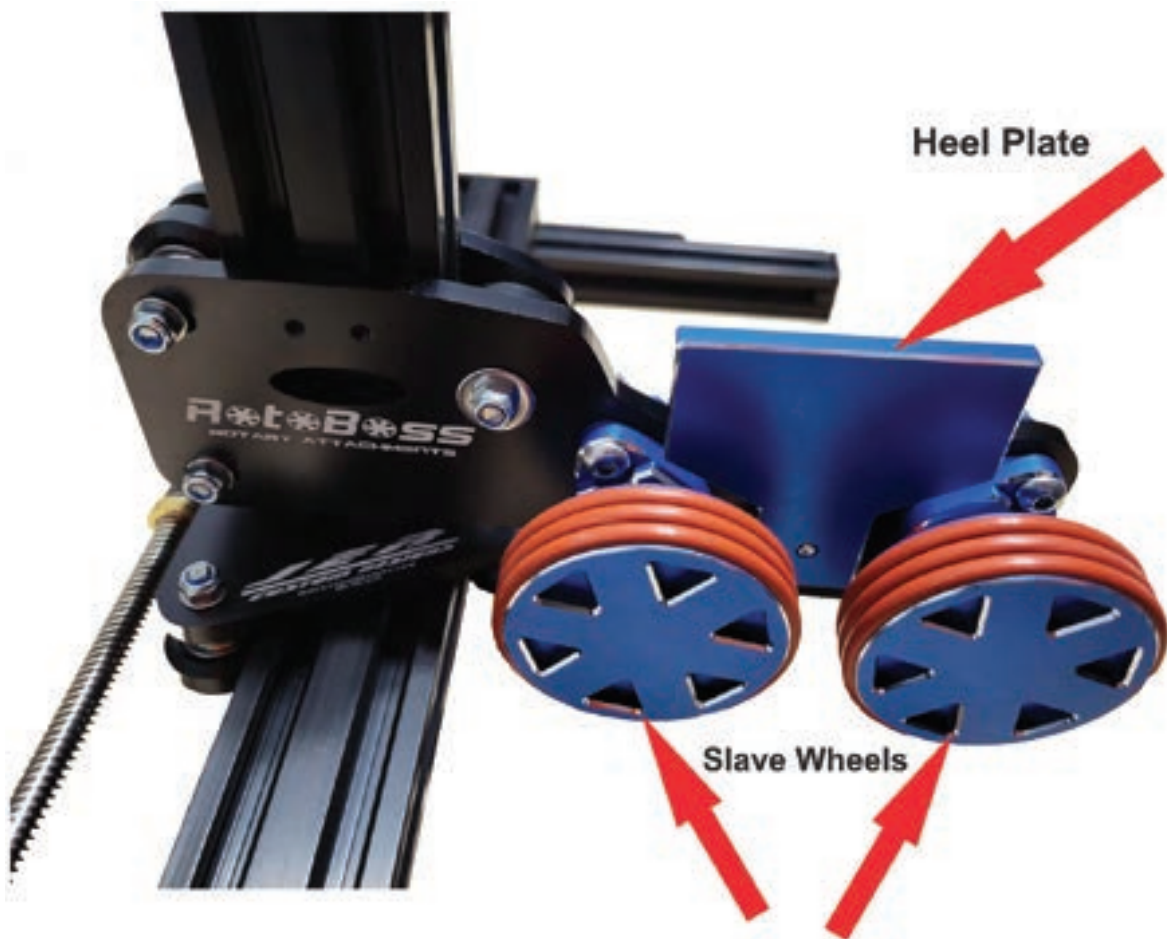
Bottle Clamp Arm

Slave Wheel Assembly:

You will notice the heel plate (top center of picture). This is used to prevent any walking of the cups away from the motor end of the rotary.

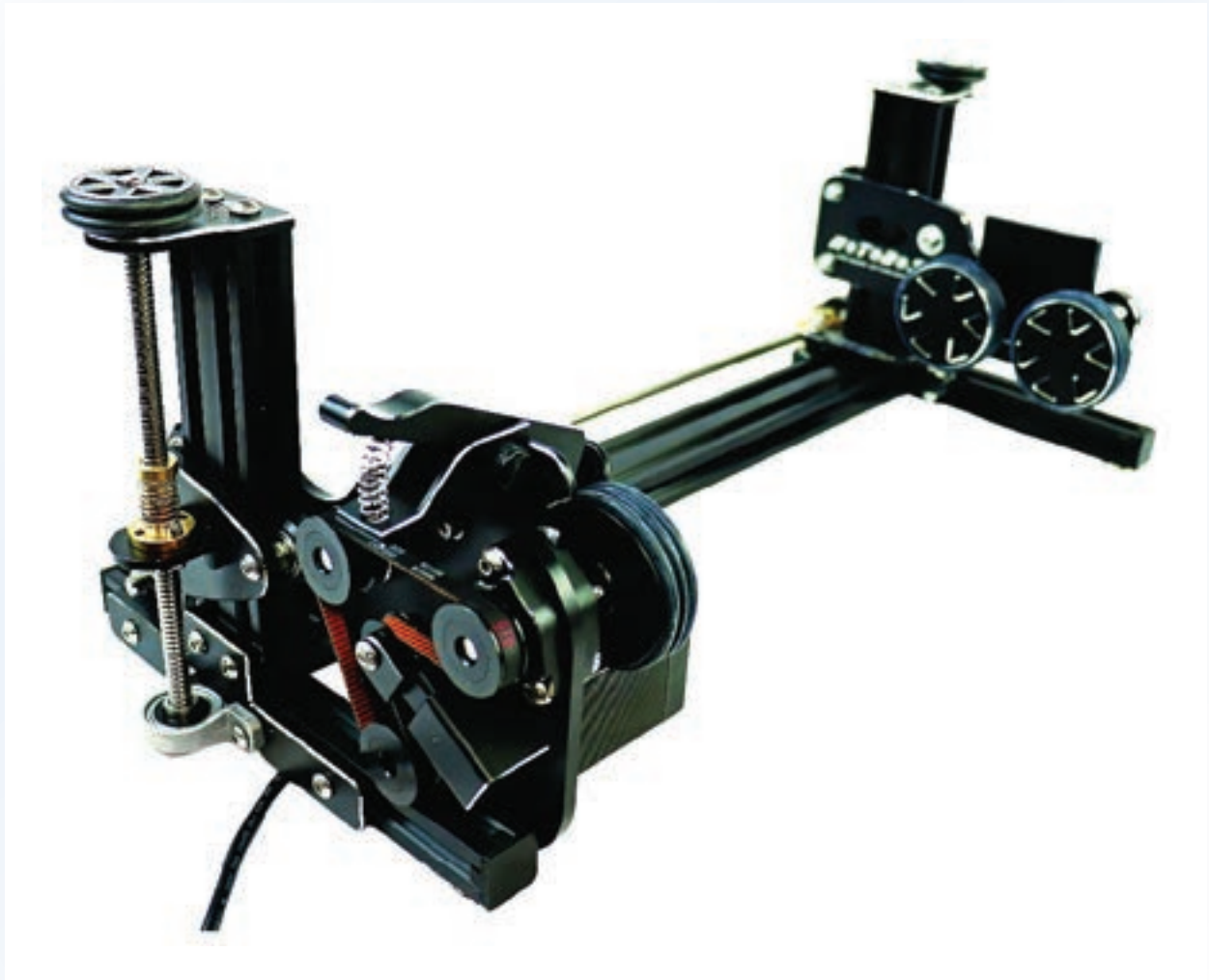
****Note you should leave about 2mm of clearance between object and heel plate to prevent binding during operation****

This plate is simple and easy to remove by removing the thumb screw holding it into place. When the plate is removed it gives you an unobstructed path for longer objects to protrude past the rotary.



The Rotoboss

Rotoboss rotary attachment is the First of its kind full spectrum Rotary that has dual adjustable sides for those odd objects that are otherwise hard to engrave without some ingenuity with current rotaries on the market. Giving you endless options to engrave nearly any round object, eliminating the need for a chuck or any other rotary.



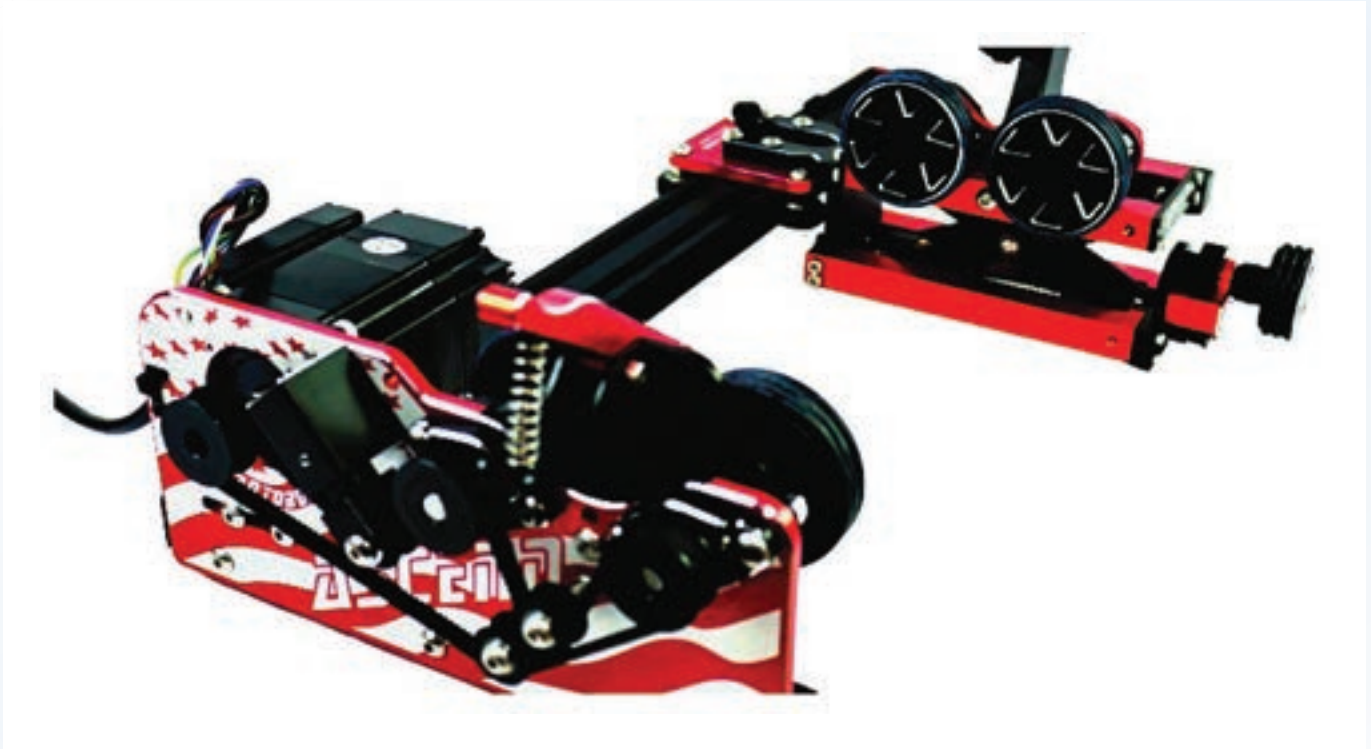
RotoBoss Jr.

The RotoBoss Jr. was my attempt at a simpler and more budget friendly Rotary to compete in the current market. This rotary has all the same functions as the RotoBoss with the exception of the adjustable Motor side assembly. On the RotoBoss Jr. the drive side is fixed in place and only the Slave wheel assembly is vertically adjustable. The Jr. also sits a little lower to the ground than the RotoBoss does.

NOTE: the Rotoboss Jr. is sold in a configuration so it can be easily converted to the full RotoBoss rotary (at a later date) This option will allow you to purchase the upgrade later and simply install the upgrade components and you will now have a fully functioning RotoBoss rotary.**



The Rotoboss Ascend



Yet another one of a kind Rotary with the quality and features found on no other rotary on the market. We have taken some of the old and blended with the new to create this one of a kind Rotary.

- ✓ This rotary has the advantage of a complete unobstructed pass through.
- ✓ With the clamping system and rear wheel stop system removed you can now rotate and engrave longer objects that go beyond the length of the rotary without the need for clamps and a balancing act.
- ✓ The Tower was scrapped for a modified scissor lift that will remove the concern of striking the tower with the head. Built with the same precision and control as the other RotoBoss Rotaries.

The Rotoboss Ascend

- ✓ With a "no tower setup" it lends itself as a better fit for lasers with smaller heads as well as the average laser head design.
- ✓ Allows you to do a wider variety and size of objects while never worrying About hitting the gantry or head on a tower.
- ✓ This unique and innovative wheel stop will allow the rear of the object to rest against a spring loaded and adjustable support wheel assembly. The stop can be set in a fixed depth position or left to ride on the spring tension to absorb any movement due to objects having imperfections. The design of this stop will reduce friction, help prevent binding while also holding your object secure.

Here is some info to get started for the “**RotoBoss Talon 4 Jaw Chuck**”

RotoBoss™ TALON 4 Jaw Chuck

Please visit for videos about and how to use the Talon rotary

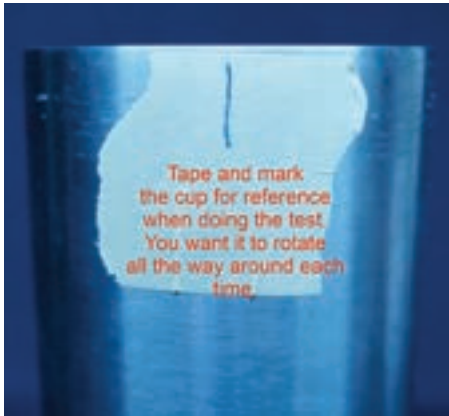
https://www.youtube.com/playlist?list=PLYkJ_L4UZaCy0v6acETyxNuwYepShpRBq

NOTE: These are just a baseline to get you in the right area for setup, results may vary depending on your machine type and size.



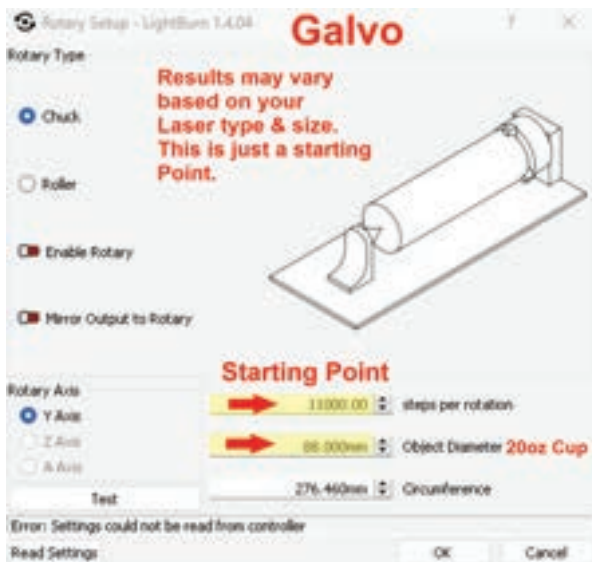
When doing your setup make sure you have an accurate Diameter for the object you are doing (The diameter measurement is from the top of the object) ie.

30oz is 101mm and a 20oz is 88mm.



- └ - Place a piece of tape on the cup and mark a vertical line for reference.
- |
- └ - Line the red dot up with the line before starting the test.

During the test if the rotary fails to rotate a full 360 and comes up short you will want to **increase your steps per rotation** and if it overshoots the mark you want to **lower your steps per rotation**.



Once the steps are set the only thing you need to do is correct for the **diameter of the cup you are doing**.

The Rotoboss BOOT



This is our Entry level and budget friendly version of our
top selling Rotary (Rotoboss Junior)

With its very compact and low profile it is suited for nearly any laser, CO2 or Galvo.
This rotary has all mechanical adjustments and allows for a great deal of objects
you may need to do when starting out.

The same great quality you come to expect from the Rotoboss brand at a fraction of
the cost. This rotary will work with any laser running Light burn or RdWorks software
with a NEMA 17 or 23 motor.

The Rotoboss BOOT

Starting setup is the same as all other rotoboss rotaries with the following info:

****Roller Diameter in
44mm or 1.73in**

****Steps per rotation
(starting point) is 4400**

**Once these settings are imputed to light burn adjustments may
need to be made to dial it in.**

The Roto Bolt



This exclusive **Thunder Laser RotoBolt** designed and built for the all new Thunder Bolt RF desktop laser. This rotary is the lowest cost, most compact and capable rotary on the market.

This rotary will get your foot in the door as an entry level rotary. This will allow you to do non handled objects from about 70mm to 101mm in diameter and possibly more based on the capabilities.

The Roto Bolt

Starting setup is the same as all other rotoboss rotaries with the following info:
https://www.youtube.com/playlist?list=PLYkJ_L4UZaCwOUC3M58VpMt4AK7Ud98No

Rotary installed with the motor on the right hand side as you look into the machine.

****Stock Roller Diameter is
24mm or .98in**

****Steps per rotation
(starting point) is 4300**

****Medium Wheel kit is
44mm or 1.73in**

****Steps per rotation
(starting point) is 4300**

**Once these settings are imputed to light burn adjustments may
need to be made to dial it in.**

The RotoBoss Low Roller



The RotoBoss low Roller is my attempt at a simpler and a more bang for your buck Rotary for the smaller desktop Laser machines. This rotary is designed for use on blade beds and has all the same functions as the RotoBoss Jr. with the exception of the adjustable Motor side assembly. On the RotoBoss Low Roller the drive side is fixed in place and only the Slave wheel assembly is vertically adjustable. The low Roller. also sits substantially lower to the ground than the other RotoBoss rotaries. This machine comes stock with smaller wheels to get the most out of your close quarters machines and still be able to do as tested fit up to a 4.5in Dia beer mug. In this configuration it will stand 5.5 -5.75 in high with a 30 oz cup on it. And can go down to must shot glass size items. If you need a little smaller diameter for pens and such or you need a little more motor height you can purchase the Full size wheels used on the other rotaries as a set of 2 or 4 depending on your needs.

Installing Low Roller Side Support Bracket.

Low Roller Placement & Setup Video: <https://youtu.be/Z347Oe2bhKU>



After removing the supplied screw and nut slide the support bracket onto the rotary and insert the nut and bolt back into the support and leave loose.

Once you place the rotary in the machine, firmly push down on the crossbar on the rotary and then slide the side support down over the blades so that the blade tips rest inside the grooves on the side support. Once it is in place go ahead while holding down on the rotary tighten the bolt to secure the support in place.

After the side support do the same to the cross bar end support (wedge shaped piece at the end) just loosen the two bolts (half turn) then while holding pressure down on cross bar slide the end support down over the blades as you just did for the side support once you have it in place tighten up the two bolts and you will be ready to use.

Contact me for any questions.

***ENJOY YOUR SNACK WHILE YOU
ENGRAVE AWAY!!!***



********Disclaimer:********

JER Custom Designs Inc. and Affiliates are not liable for damage to equipment or bodily injury due to improper use of these Rotaries. Careful thought and design have gone into these products to limit the potential for obstruction which could lead to damage to you or your machine. Make sure to always check your clearances to ensure there is no danger of impact prior to operating these rotaries.

Due to the nature of the manufacturing process Rotaries may have some sharp edges that may cause injury. Take a moment to familiarize yourself with the rotary and take note of such areas. Every effort is made to mitigate the risk to the end user.

Not recommended for anyone under the age of 16.