



## LongMill V1 Assembly Manual



V1



SIENCI LABS  
IDEAS INTO REALITY

# Table of Contents

Part 1:       **XZ-Axis Gantry**

---

Part 2:       **Y-Axis Gantries**

---

Part 3:       **X-Axis Rail**

---

Part 4:       **Y-Axis Rails**

---

Part 5:       **Drag Chains and Wiring**

---

Part 6:       **Electronics**

---

Part 7:       **Table Mounting**

---

Appendix:   **Unboxing**

---

## Tools you need

Before you get started, here is a list of tools you should have on hand for assembly. Most people will have these tools in their shop:

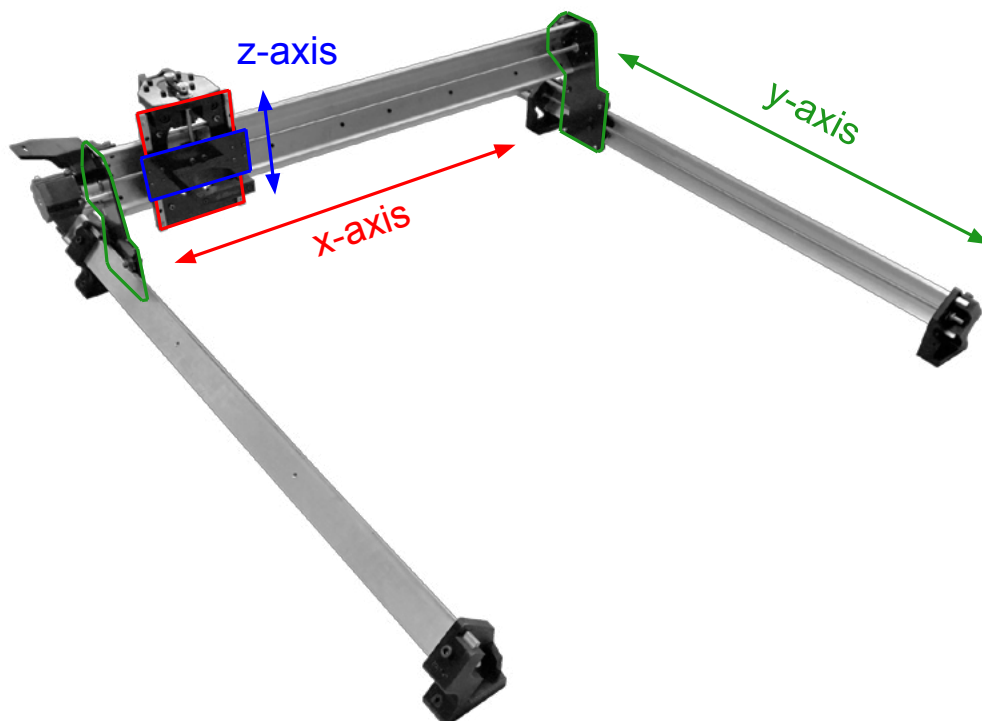
- Metric Allen keys or a drill and Allen driver bits
- Pliers or metric wrenches
- A small flat head screwdriver
- Rubber mallet (optional)

The LongMill comes with a lot of parts, but we've organized them to make it as easy as possible to find and put everything together; each kit comes with several cartons.

For the complete BOM, visit: <https://docs.google.com/spreadsheets/d/1xyy-UfH2HbzT0Ood7SpQlXwkfFexDDYBOZeApSEc3IM/edit>

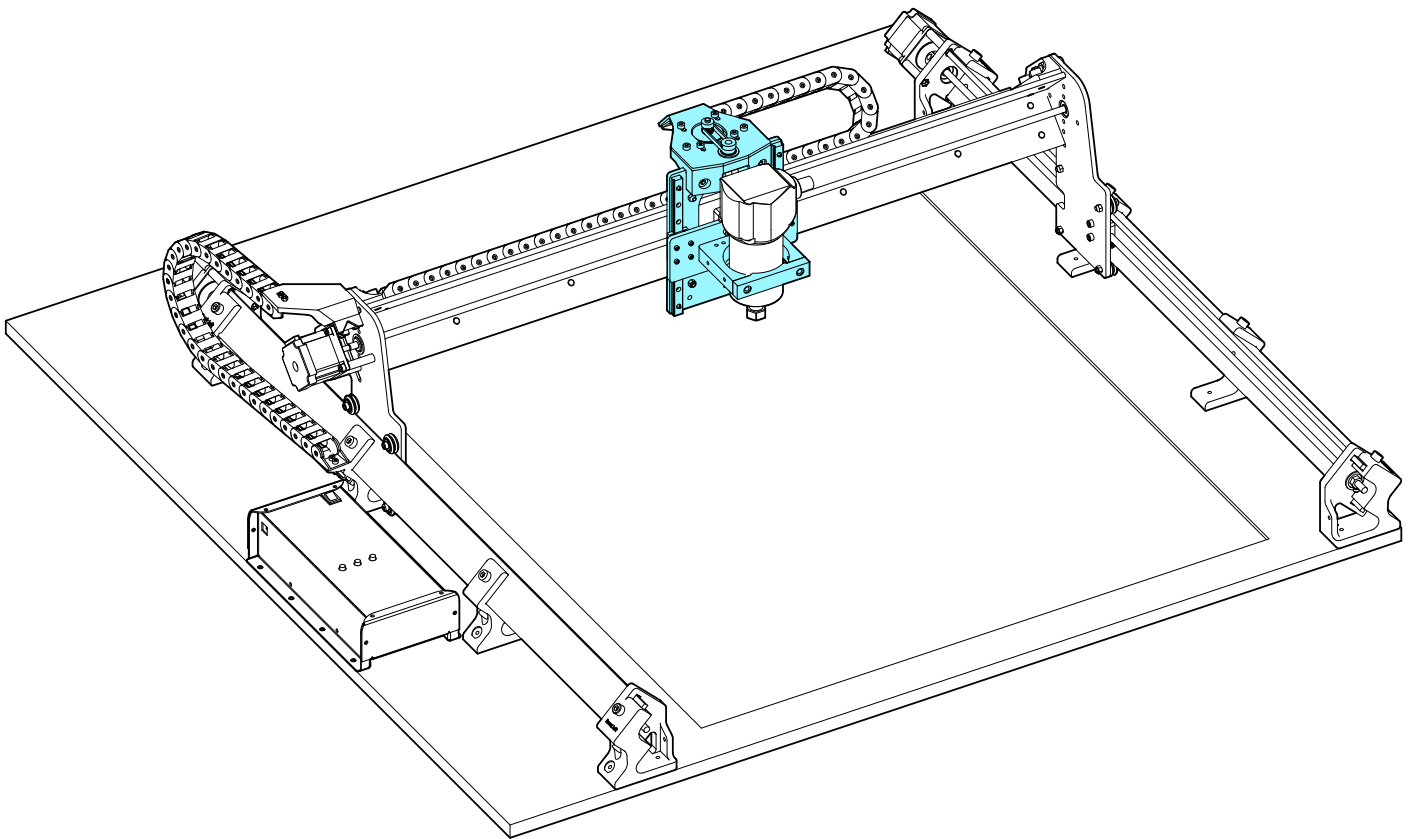
The following pages in the assembly section will guide you through how all these parts will fit together to make your LongMill. You should find that each major step is self-explanatory, but the required parts and quantities will still be written as an additional reference.

The diagram below shows the machine coordinate system of the LongMill. It's able to move in its **x**, **y**, and **z**-directions due to the rails and respective gantries it has on each of those axes. We'll start by assembling the **x** and **z** gantries which combine into a singular assembly; in the diagram these are coloured red and blue respectively.



Part 1

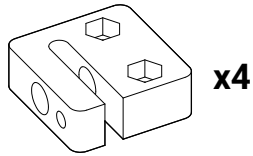
## **XZ-Axis Gantry**



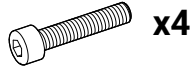


# Nut Assemblies

Parts Needed:



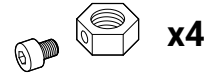
Delrin anti-backlash nut



M5-25mm bolt



M5-nylock nut



Locking ACME nut & set screw

Start by opening up all the large hardware bags and spilling all the contents out onto the table. There should be a bag full of medium-sized, long bolts and another with medium-sized nuts, this is the M5 hardware you need. Another one of the bags will be filled with 4 rectangular plastic blocks, we'll be preparing these blocks for installing onto the XZ-axis gantry and eventually on the Y-axis as well.

Start by pressing the M5-nylock nuts into the hexagonal cutouts. Make sure that you point the round end of the nut towards you, as you want the first part of the thread to be metal before your bolt gets to the nylon locking part.



Your kit will come with a set of set-screws and nuts that are used to tension and reduce backlash; however they're quite short and hard to get to for adjustment when your machine is assembled. For these reasons, we'd recommend that you keep these aside and instead use some of the long M5 bolts. Feel free to install the shorter set-screws in their place once you've got your machine running, if you prefer them instead.



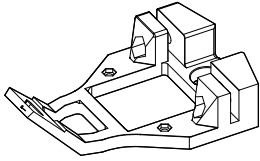
There will be another bag filled with four large nuts, take the contents out and loosely thread all the set screws into the nuts (only do 2.5 turns for now).



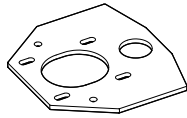
Prepare four set of both these assemblies and set them aside for later.

# Z-axis motor sub-assembly

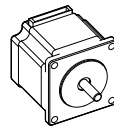
Parts Needed:



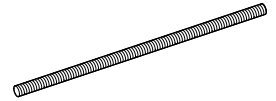
3D printed Z-axis mount



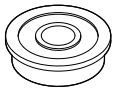
Steel Z-axis motor mount



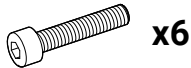
NEMA 23 motor  
(threaded)



200mm lead screw



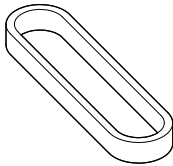
608ZZ flange bearing



M5-25mm bolt



M5-nylock nut



132mm GT2 closed loop belt



20T 6.35mm GT2 pulley



20T 8mm GT2 pulley

Previously Assembled



ACME locking nut  
assembly

Get the paper-wrapped Z-motor plate, the plastic Z-axis mount, and the bags full of medium-sized bolts and nuts from the last step. You'll also need the motor **specifically labeled for the Z-axis**, this one is specially threaded. It will be labeled with a sticker or come with a laser engraved



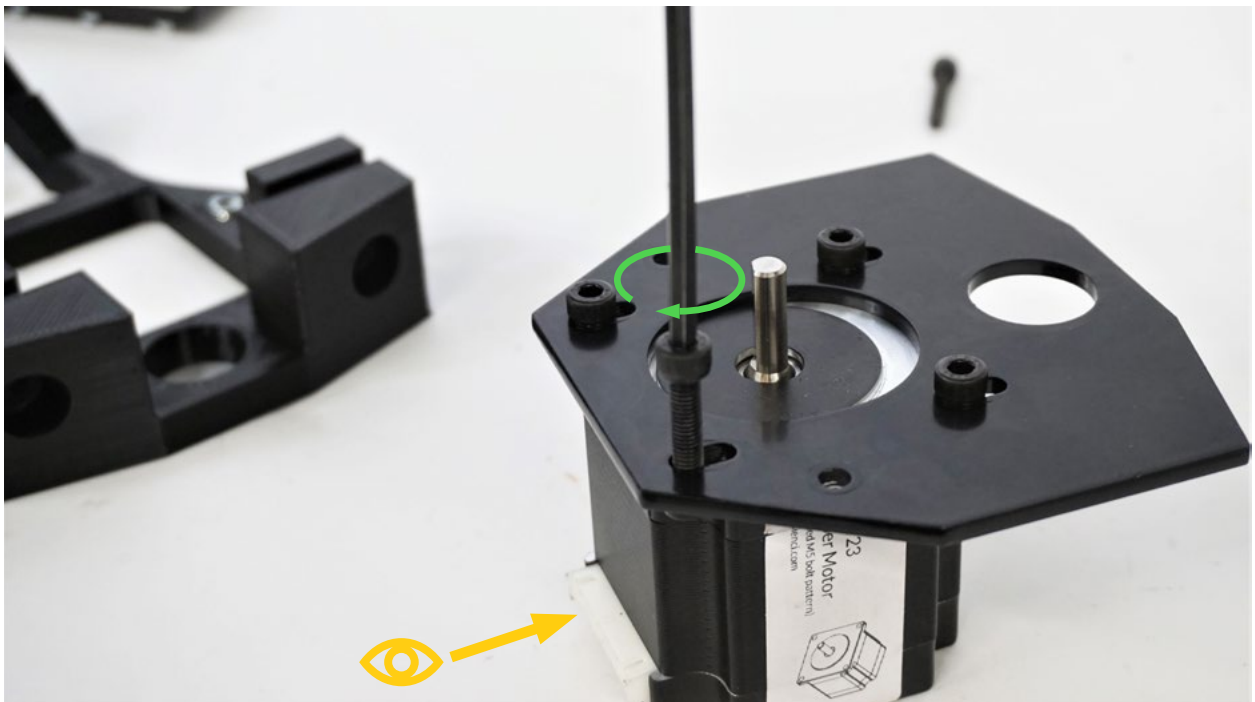
Labeled with THREADED

Start off by pushing in two M5-nylock nuts into the hexagonal holes in the 3D printed Z-axis mount. These will be used to mount the steel Z-axis motor mount.



*Make sure to keep the round part of the nut facing towards you when pushing them in.*

To the side, put the steel plate on the top of the motor, ensuring that its white connector is **facing away** from the middle-sized hole on the plate. Loosely thread four M5-25mm bolts through the slots and the motor, the plate slots may be a little tight but that's fine; we'll be adjusting this part and re-tightening the bolts later in the assembly.



*Screw the four M5 screws into the motor. Ensure that the connector is facing the correct direction to make wiring easier later.*



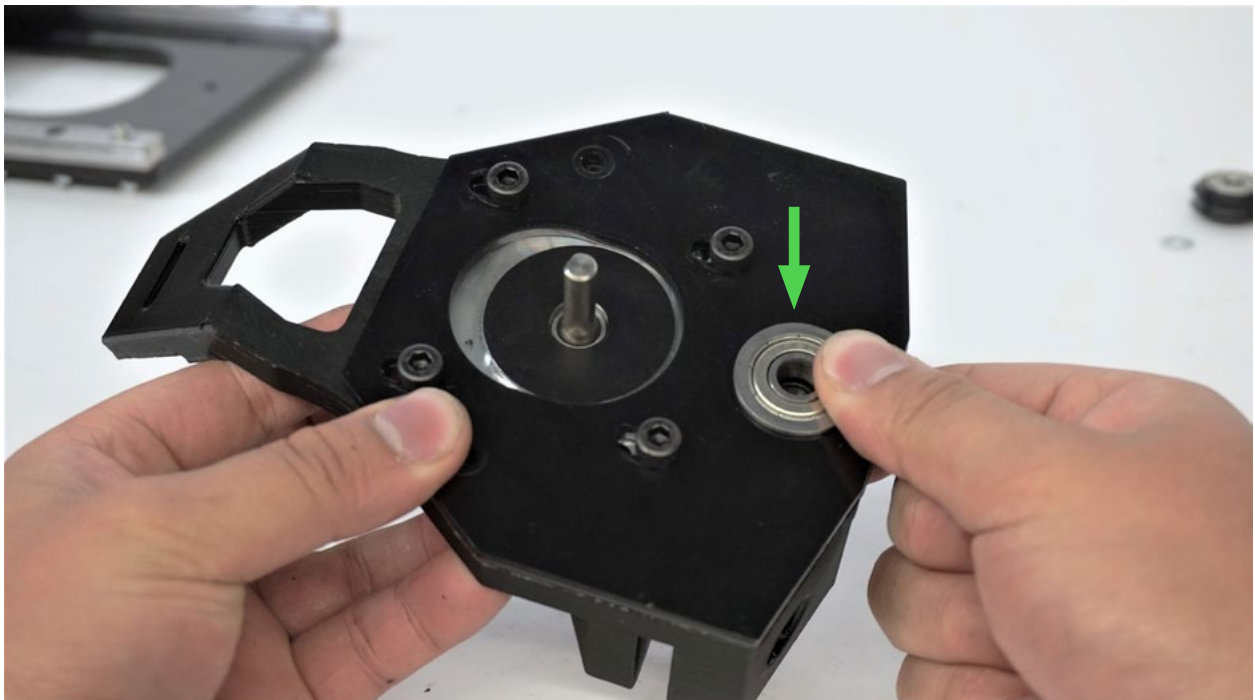
Fit the motor and plate assembly into the 3D printed Z-axis mount. If it doesn't slide in easily, try sliding the motor all the way forward, and tilting the plate back slightly. You'll know they're aligned when their profiles match and they lay flush against each other.



*Moving the motor back and forth, and tilting the plate and motor back and forth can help get this part in place.*

Get the bag with bearings in it and use two when pressing them into the top and bottom bore on your assembly. You should be able to get them on easily with your thumbs. If you find resistance, try adjusting the steel plate so that the bores on the plastic and steel line up.

Both flanges of each bearing should sit flush with no gap.

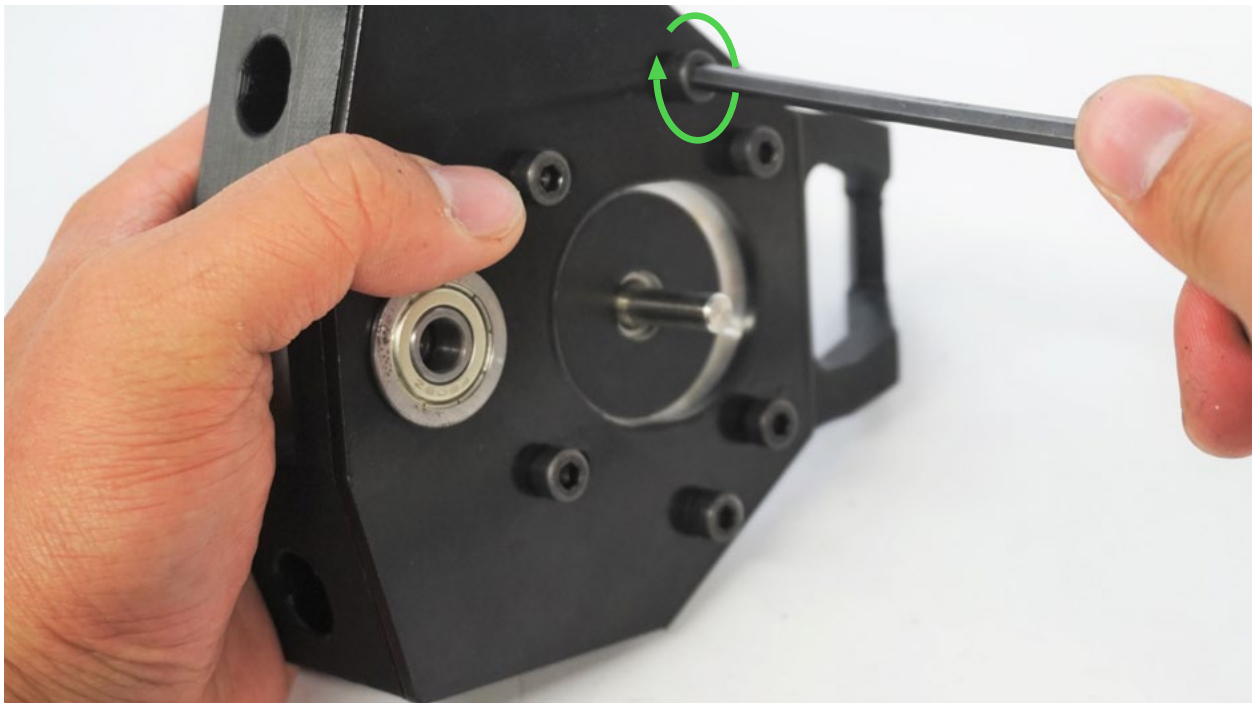


*Bearing on the top*



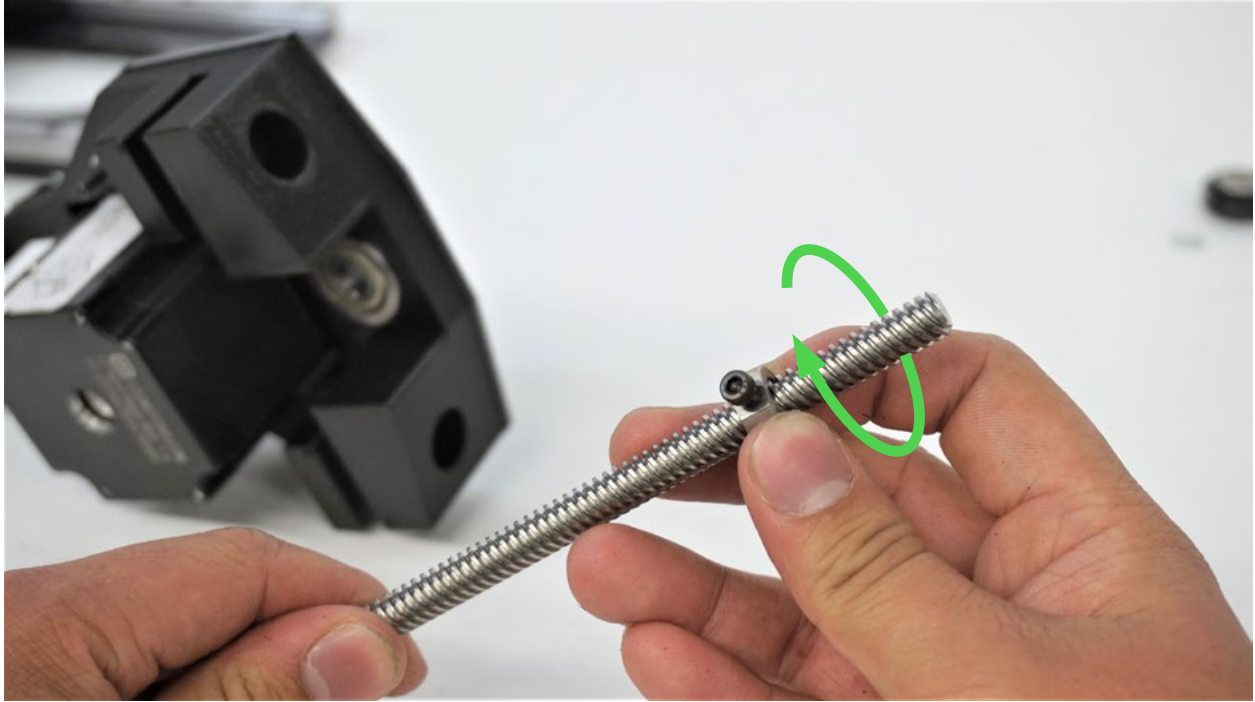
*Bearing on the bottom*

Using two more of the same bolts, secure the plate and the 3D printed part together. These should thread all the way through to the nuts that you placed earlier in the plastic mount.

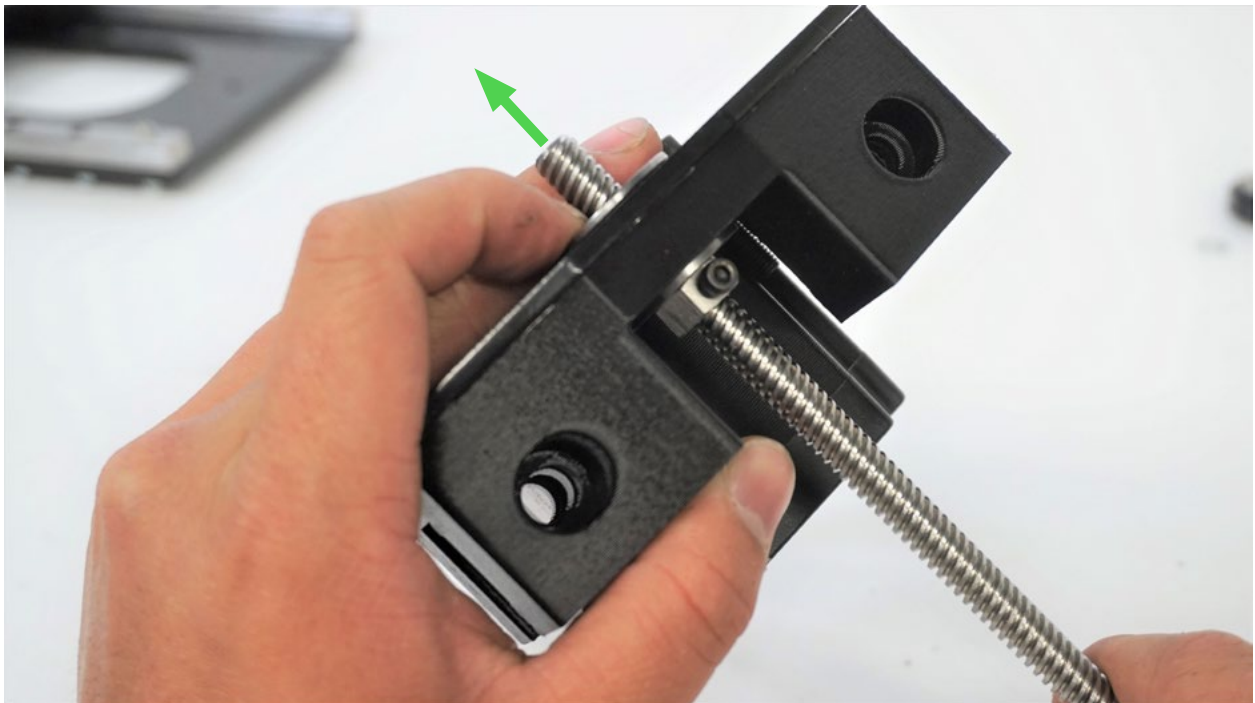


*Mount the steel plate to the 3D printed part.*

One of the long boxes is lighter than the other, it will contain the drag chains, lead screws, and the motor cables (wrapped in paper). The drag chains and motor cables can be set aside until the end of the assembly. Get the shortest lead screw that's hiding in the paper wrap on one end, as well as an ACME locking nut assembly from before. Thread the nut about an inch and a half down the length of the lead screw. Make sure the nut still has the M3 screw for later locking it in place.

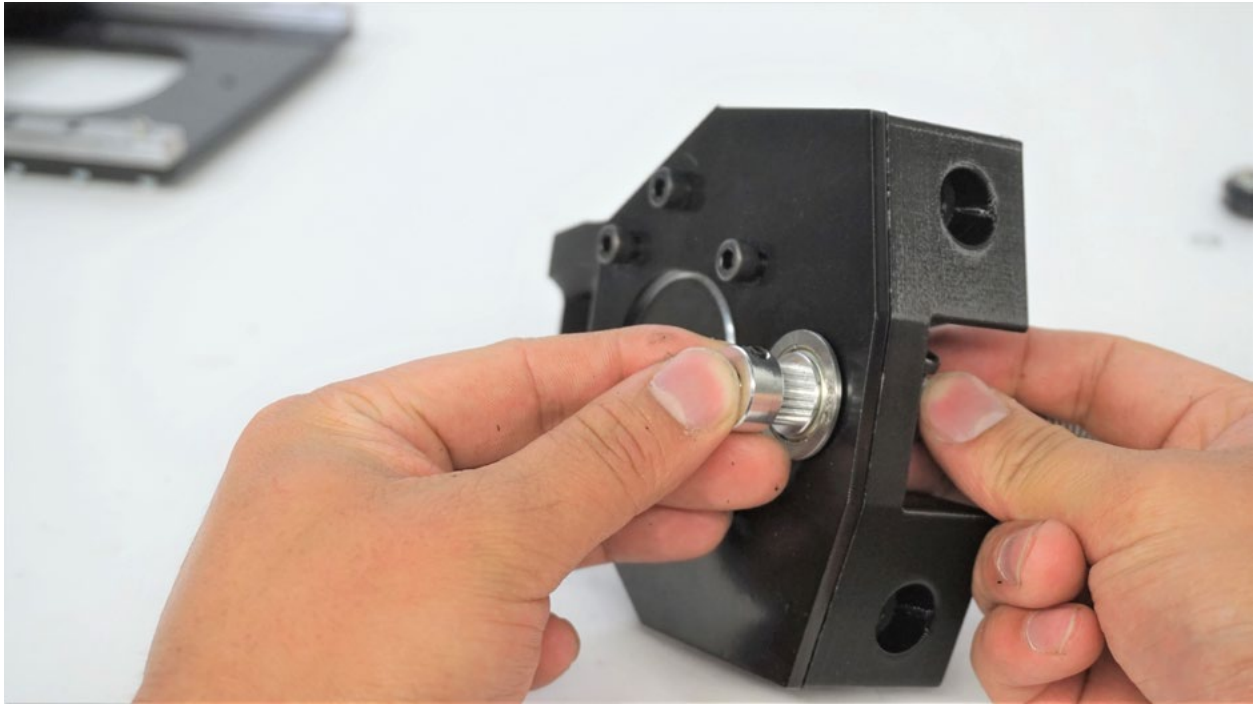


Next, slide the short end of the lead screw up through the flange bearings. It should slide in with little force; if you're having trouble then try wiggling the lead screw back and forth gently.

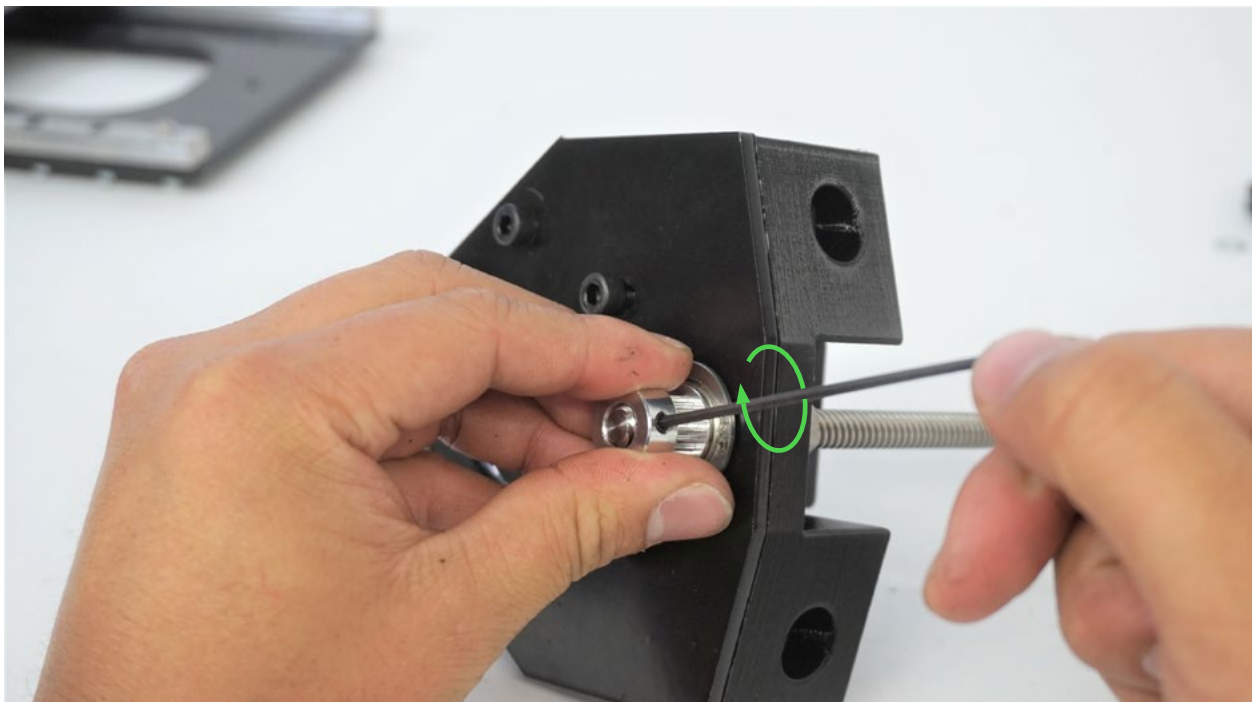




Get the bag with a belt and two pulleys. You'll find that only one of the pulleys will be able to fit over the lead screw but you'll first have to unscrew the set screws a little with the included Allen key. Orient the pulley so that the base is flush with the end of the lead screw then tighten the screws into place.



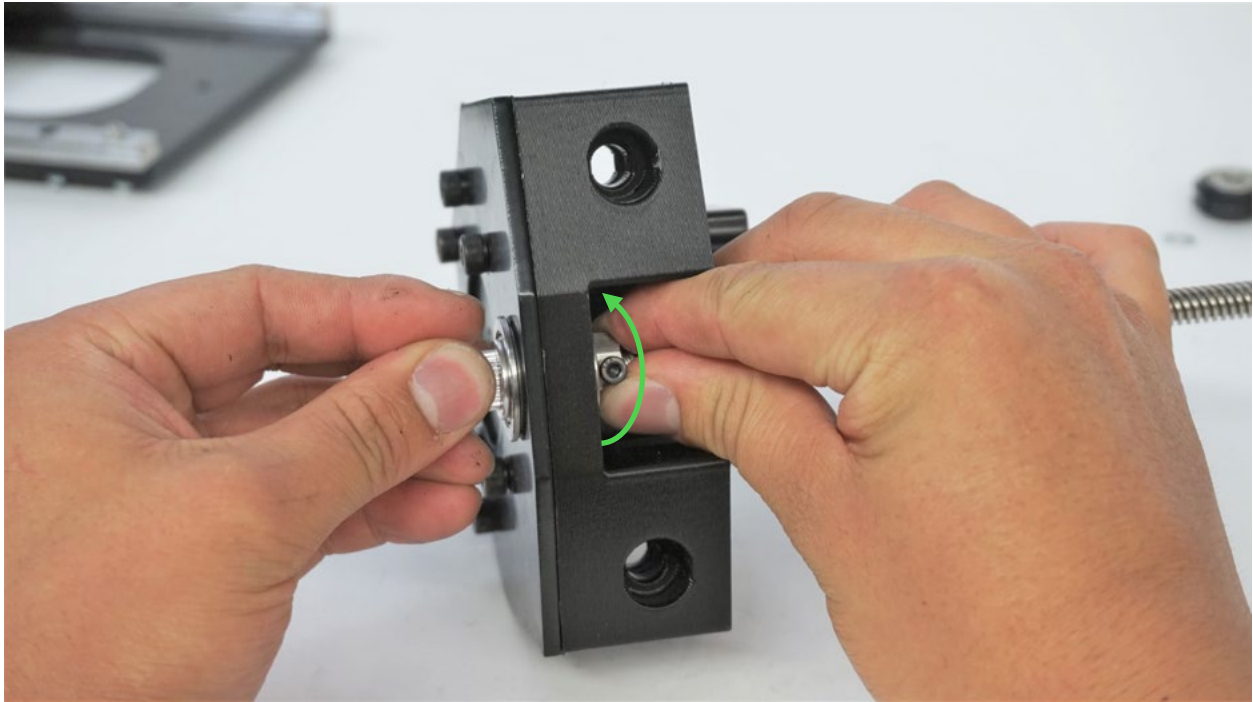
*You might have to adjust the locking nut to make the lead screw and the top of the pulley flush.*



*Use an Allen key to tighten the set screws to hold the lead screw.*

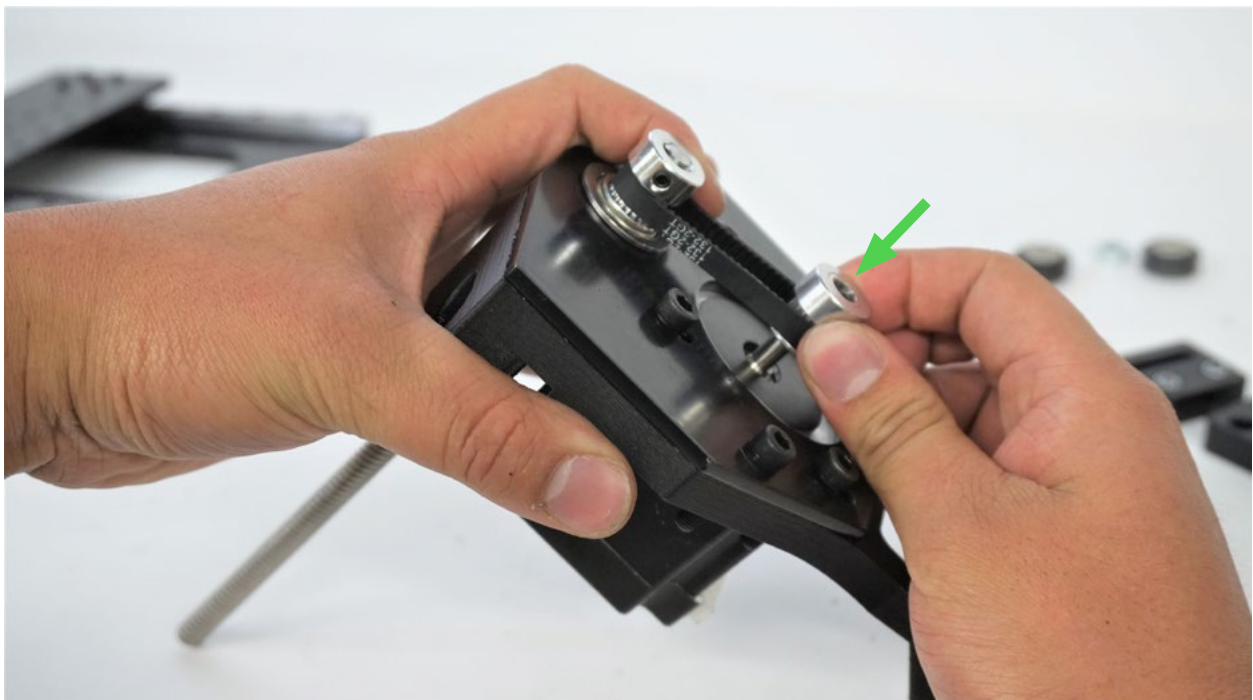


Once the pulley is secure, twist the ACME locking nut in from the other side so that the pulley and the nut are sandwiching the two bearings. Once in place, tighten the M3 screw on the nut to hold it in place and ensure there's no play up and down. Adjust and tighten if necessary.

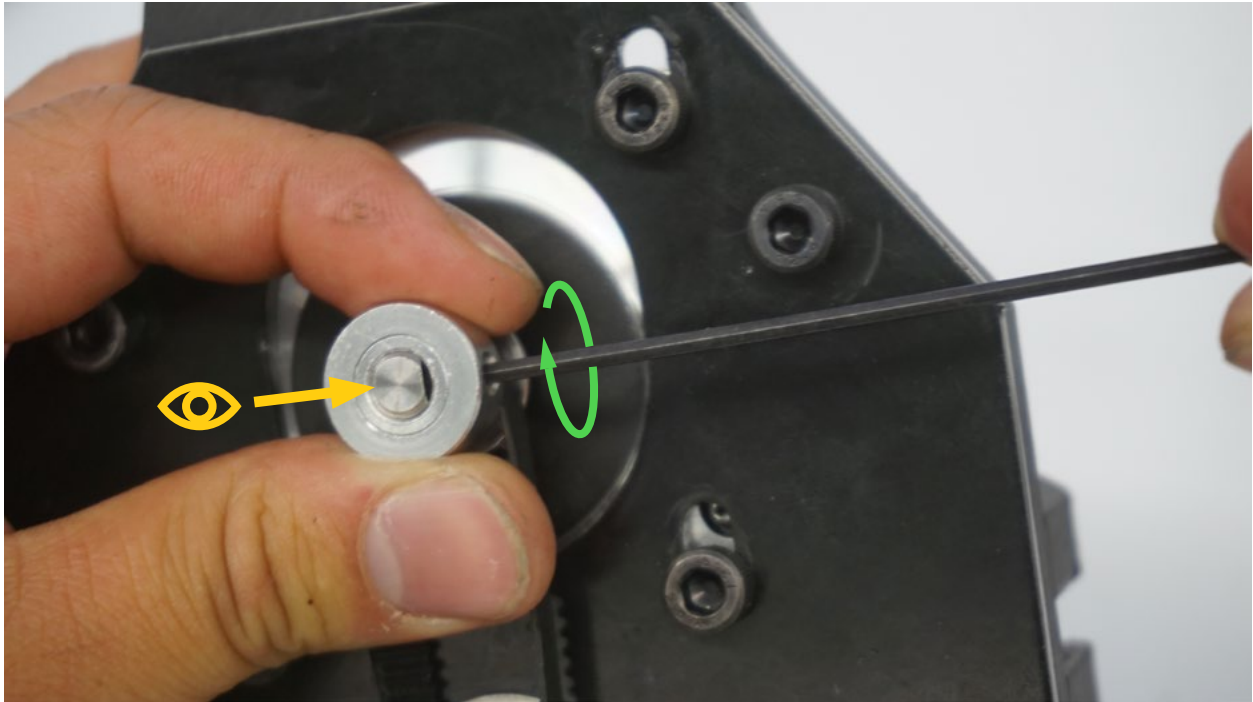


*This step keeps the lead screw constrained in the z-axis.*

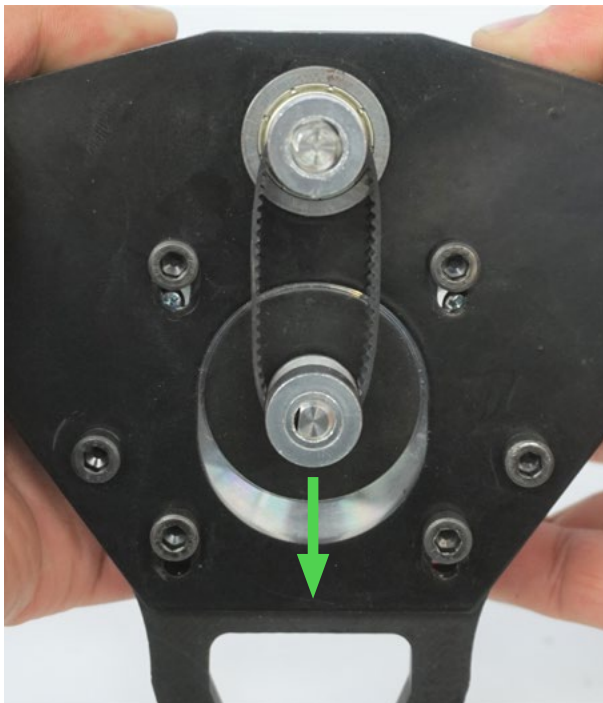
To put the belt into place: loosen the second pulley set screw, wrap the belt around it, slide the motor toward the lead screw, then wrap the belt around the first pulley and install the second pulley onto the motor shaft.



The base of the second pulley should be flush with the top of the motor shaft when tightened. Make sure to line up one of the set screws with the flat part of the motor shaft to provide extra holding strength (as shown in the photo).



Next, make sure that the belt is tight around the two pulleys by pulling back the motor in the slot then tightening the M5 bolts that are holding it in place.



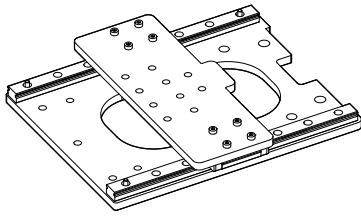
*Loose belt*



*Tight belt*

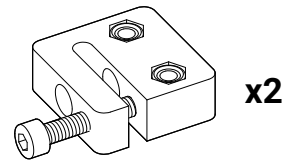
## XZ-axis gantry sub-assembly

Parts Needed:



XZ-gantry assembly

Previously Assembled



Anti-backlash assembly

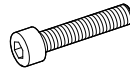


**x12**

V Wheel

**x12**

M5 washer



**x12**

M5-25mm bolt



**x2**

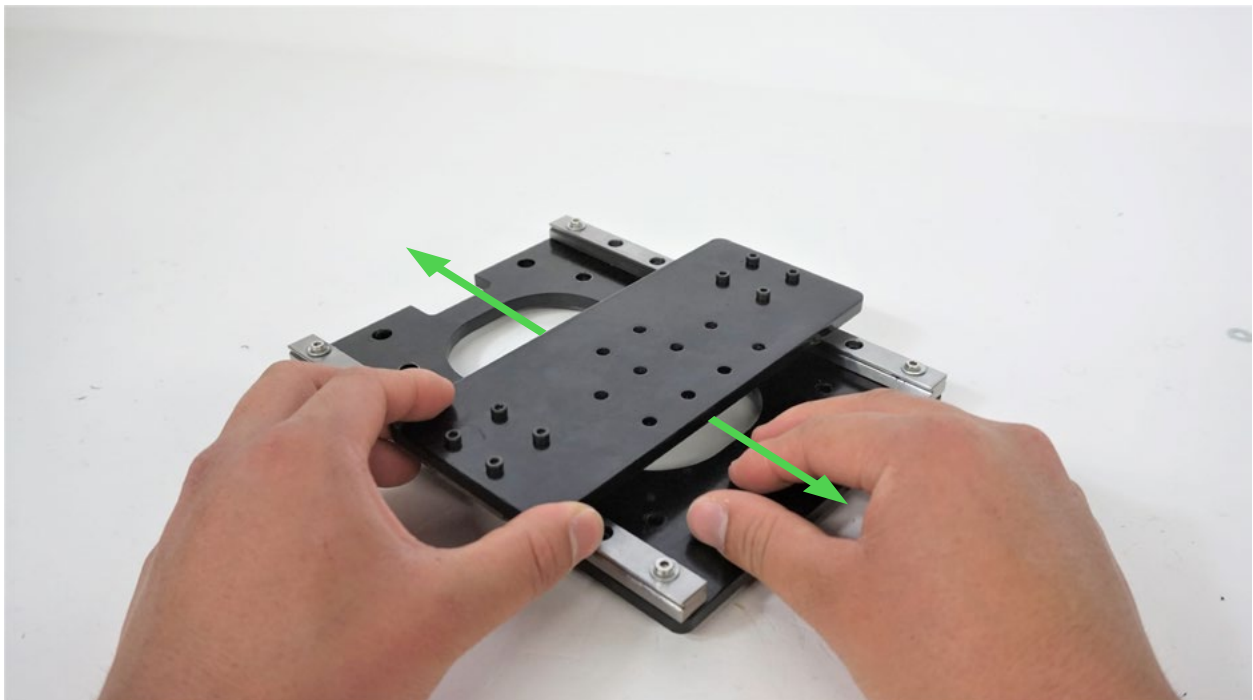
Eccentric nut



**x2**

M5-nylock nut

You should find the XZ-gantry assembly in a labelled bubble mailer. Once you take it out, you'll see there's a small steel plate (z-gantry) attached to big steel plate (x-gantry) via two sliding rails. First, check that the movement of your z-gantry is smooth by moving it up and down by hand. There should be no binding and the gantry should move relatively smoothly.

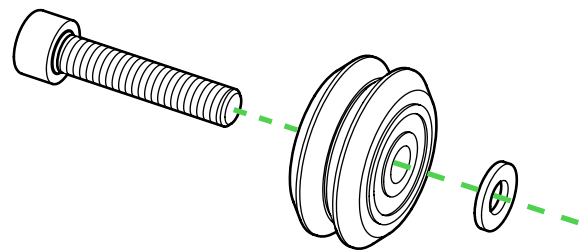


*Gantry should move smoothly with no binding. Move up and down for a minute if tight.*

Set the assembly to the side and get the bag full of medium-sized bolts, washers, and the v-profile wheels. Spilling out the wheels, if you look down the center-hole you'll notice that they have a bronze-coloured inner ring which can sometimes off-center (pictured). Use the included small Allen key from the belt assembly to move the inner ring back into the center.



After this, make a small assembly with the wheel going onto the bolt, followed by a washer (pictured). There will be 12 of these sets total. It's very important that the washer is in the correct place, as it keeps the wheel from rubbing against the gantry, as well as providing the correct spacing between the gantry and the lead screw. You'll need four of these assembled sets for now.

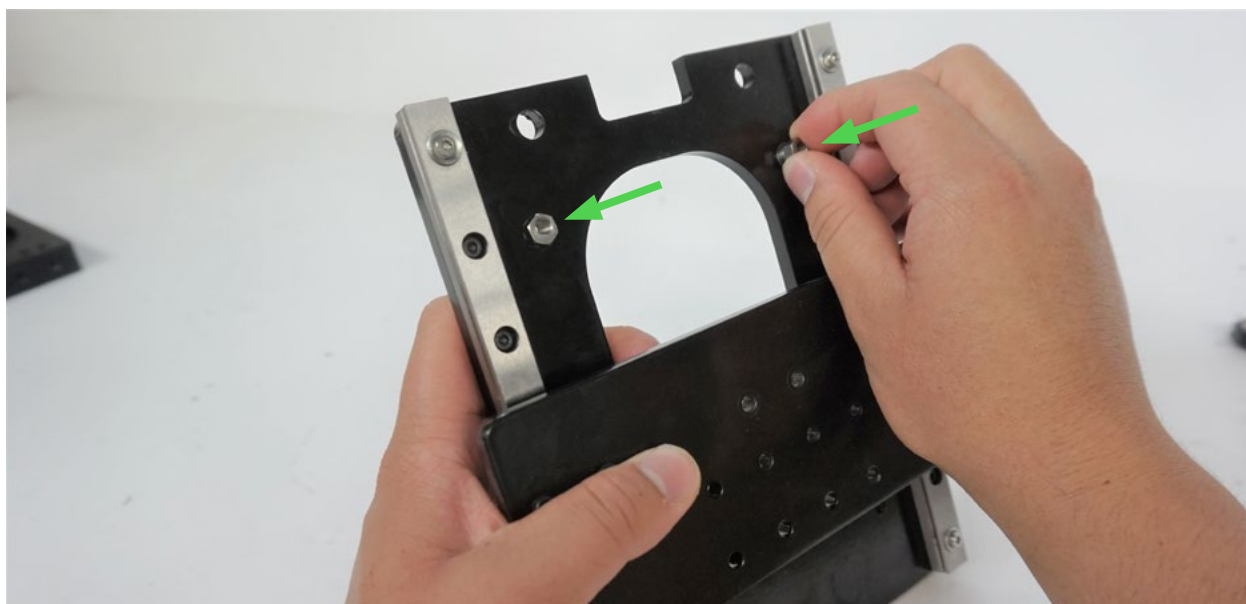




You'll also need two of the medium-sized M5 nuts from the last step and you'll also need to grab the bag of eccentric nuts. These come in a small bag of 6 and are very odd looking so they should be easy to identify.

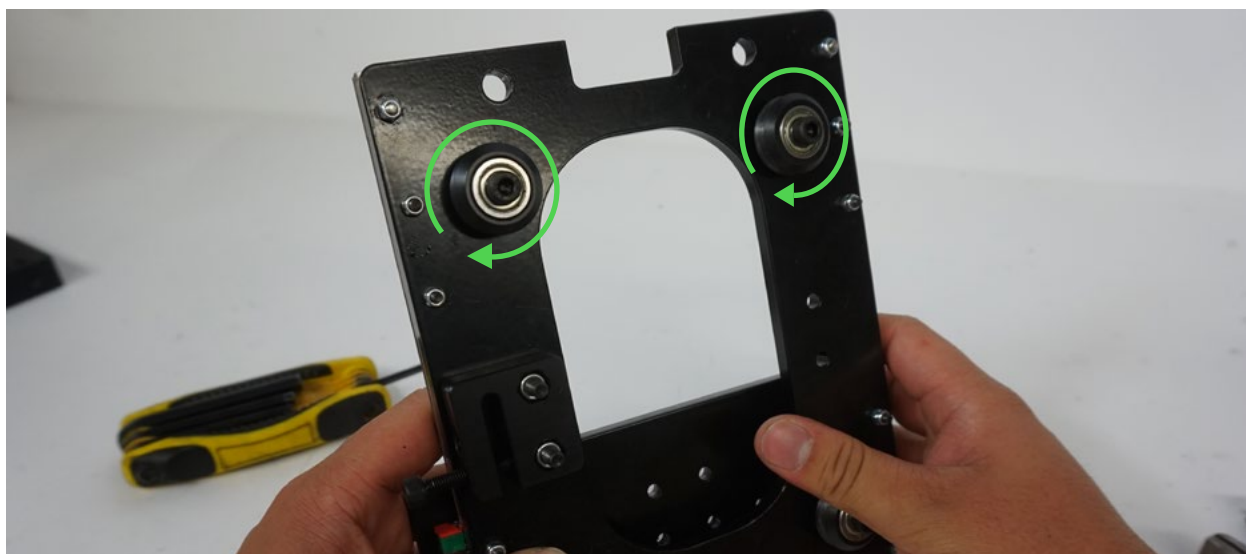
If you move the z-gantry to the middle on the XZ-gantry assembly, you'll notice 4 holes in a rectangular formation on the large steel plate. The 4 sets of wheel assemblies go into these holes from behind, the bottom two using a regular nut and the top two using an eccentric nut. Start by fitting the eccentric nuts into the top pair of holes. The round part of the bore should sit inside of the hole, with the hex part facing out.

If you have a hard time getting the nuts in, we recommend tapping them in with the back of a screwdriver or other dull object. This will help clear the excess paint that might still remain in the hole.



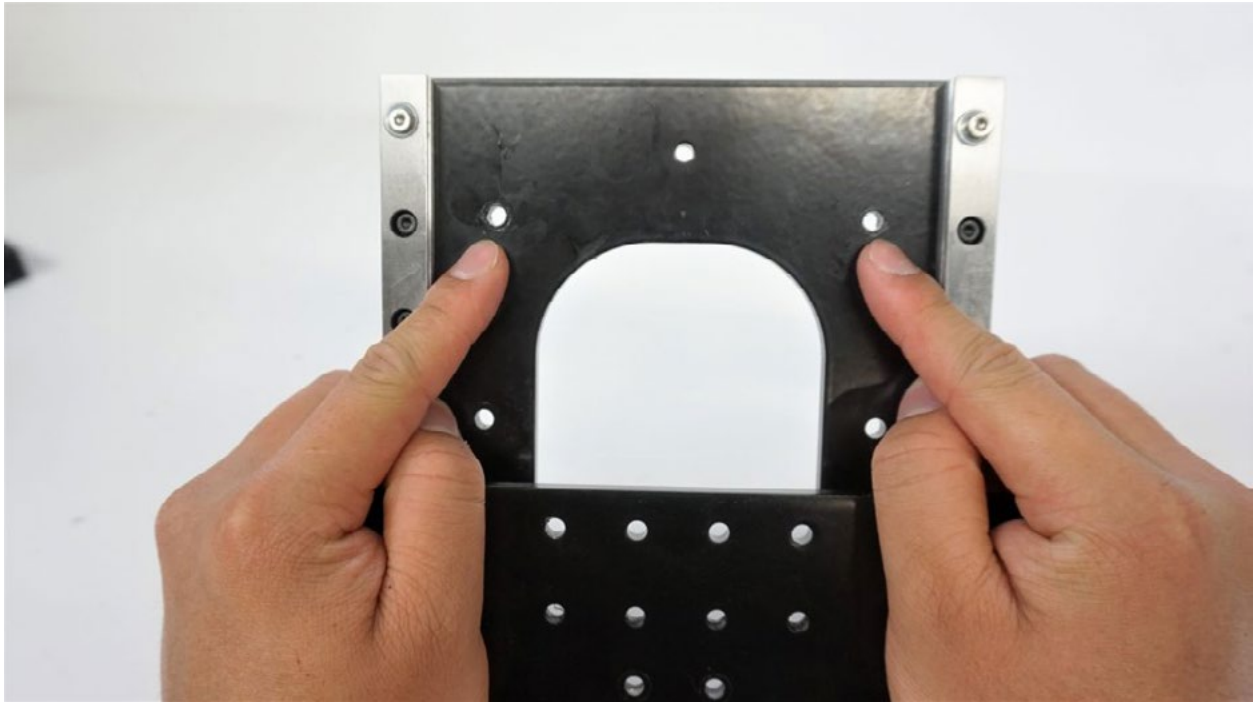
*Make sure to have the eccentric nuts in the right holes, and that the bore is sitting inside the hole.*

Twist two of the v-wheel sets into the eccentric nuts from the other side. These don't need to be tight yet, so just attach them by hand for now.

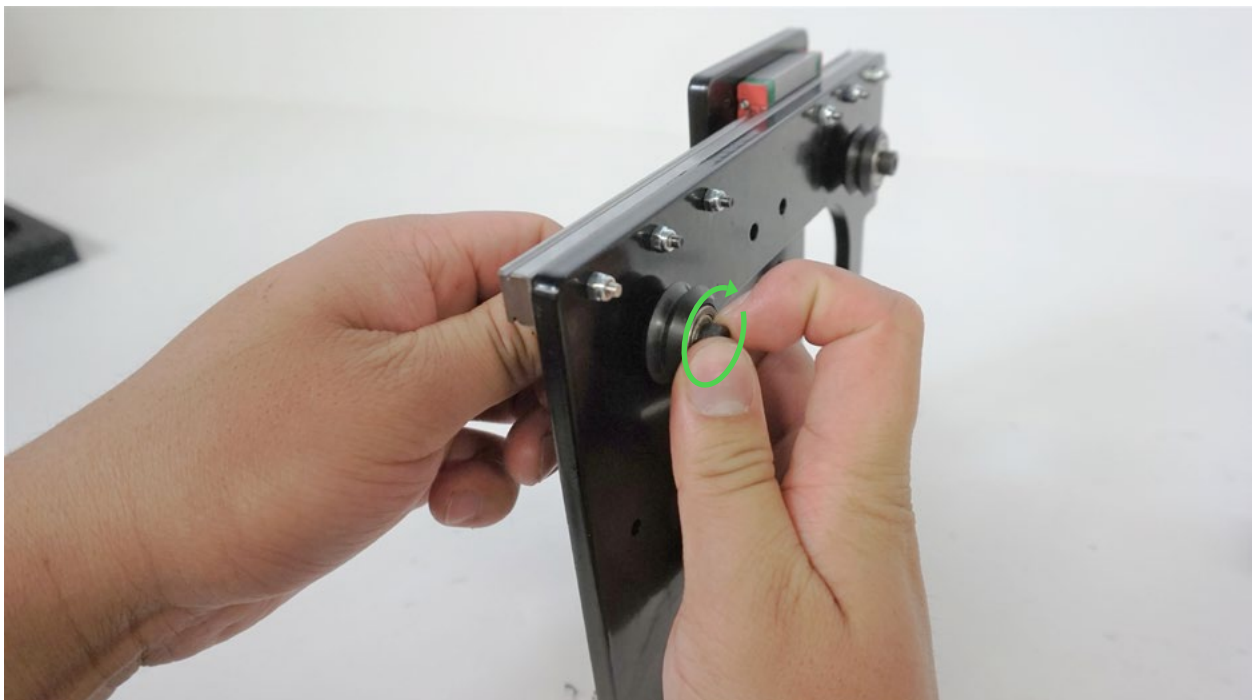


*Install the first two v-wheels from the other side.*

Now attach the bottom two v-wheel sets. These attach with regular M5-nylock nuts and need to be tightly fastened into place. You can do this with a size 4 Allen key and an 8mm wrench or pliers.



*These are the two holes which we'll put the next two v-wheels into.*

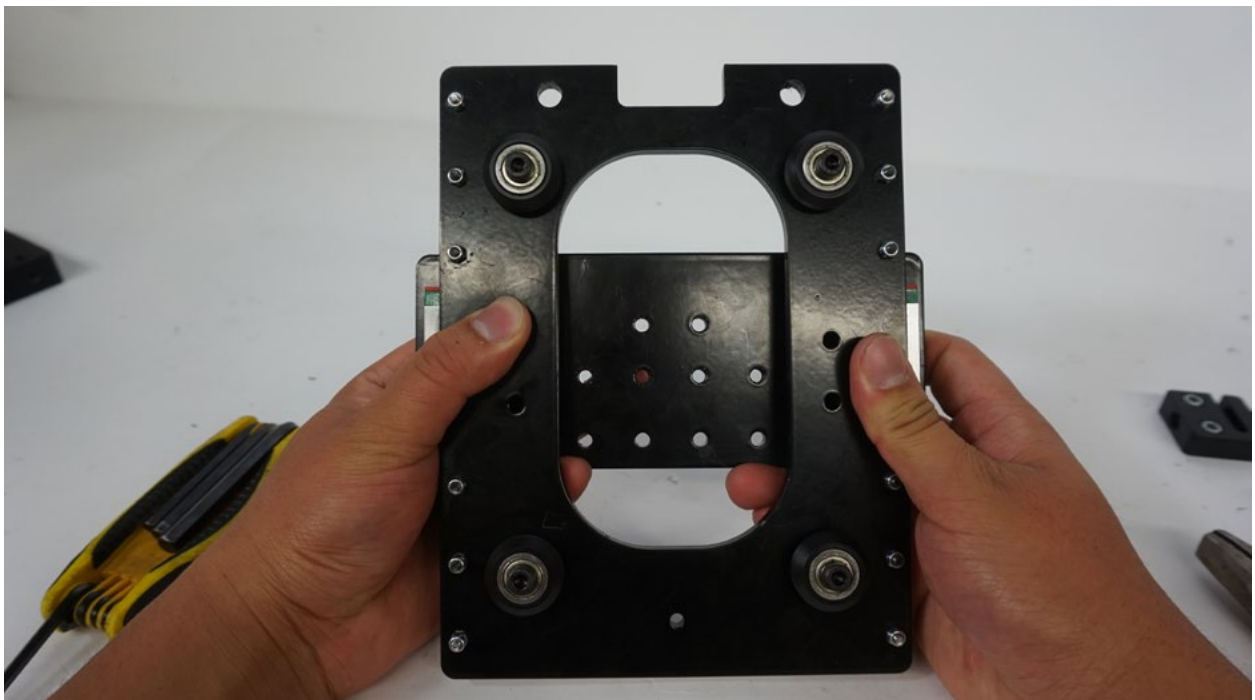


*Install the v-wheels, ensuring that the washers are in place as well.*



*Tighten the wheels until snug.*

Once complete, all of your wheels will be facing the backside of your gantry.  
Check to make sure that each wheel turns smoothly.



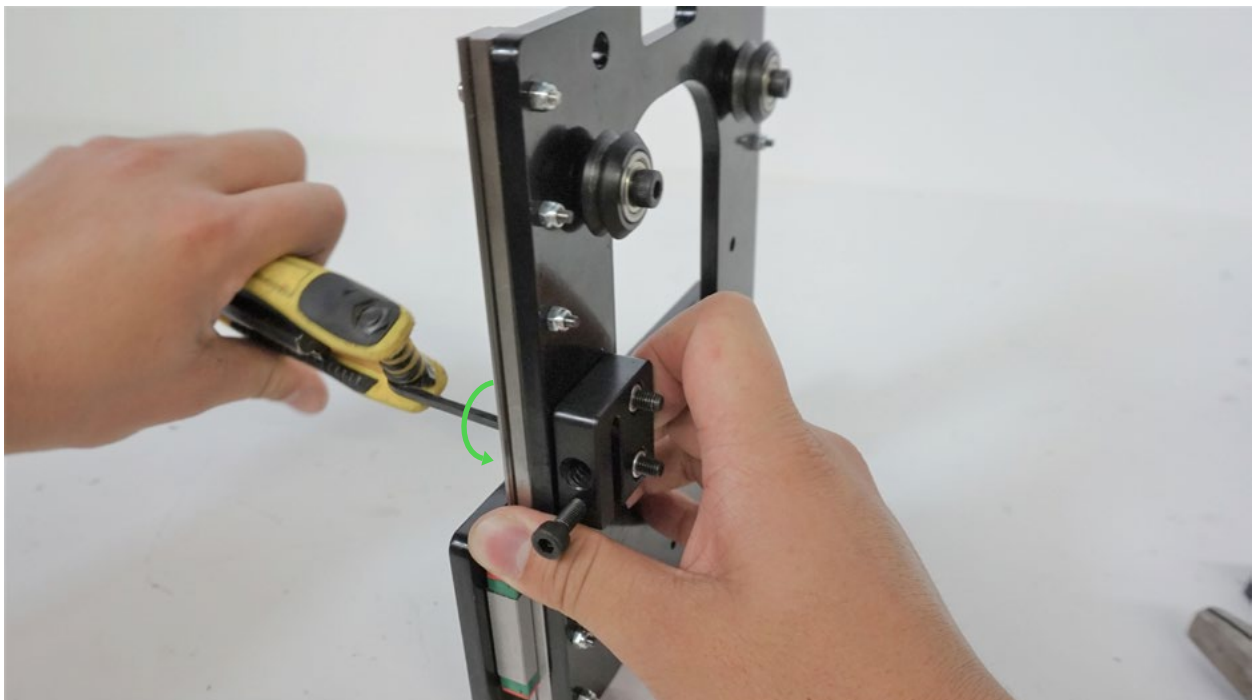
*All of your wheels should be facing the same way.*

There are two anti-backlash assemblies that attach to the XZ-gantry assembly.  
The first one we will assemble goes on the X-gantry.



*Two holes for mounting the anti-backlash nut block.*

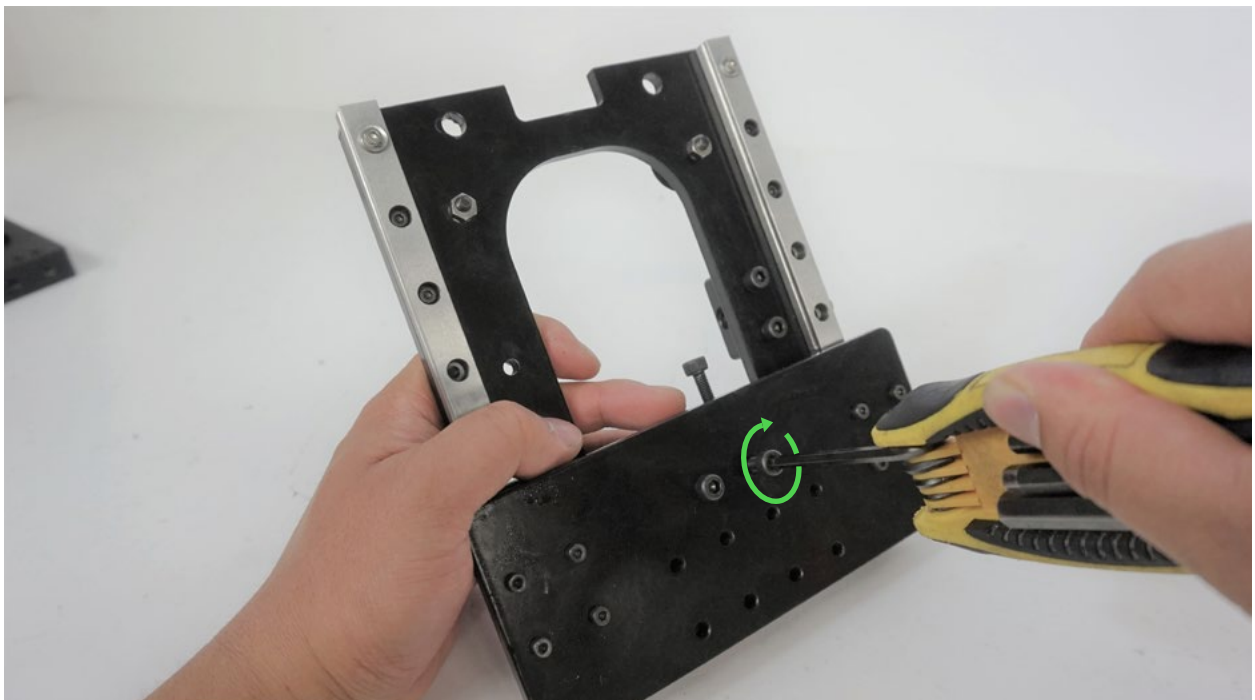
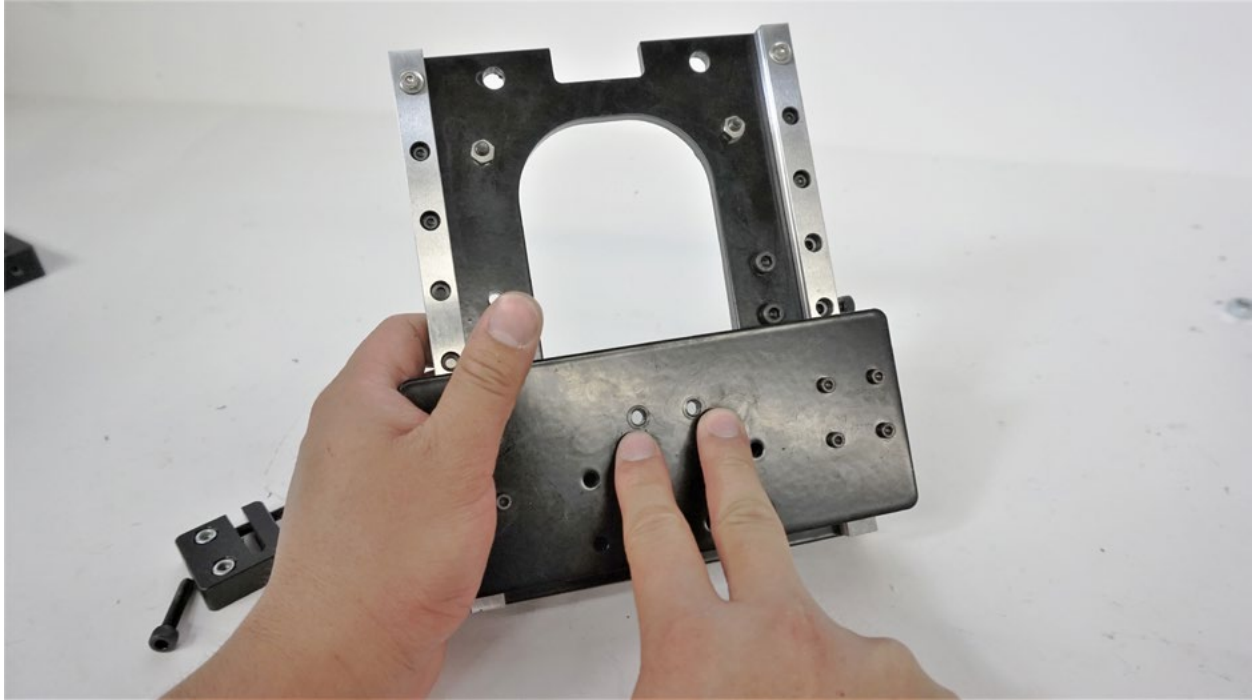
Use two M5-25mm bolts (the same ones used to make the v-wheel sets) to mount the nut block. Make sure that the M5 nuts are facing outwards (pictured) so that you can see them. The block **shouldn't** be tightened down really hard, just fasten it until it's snug.



*Tighten until snug, but do not overtighten.*

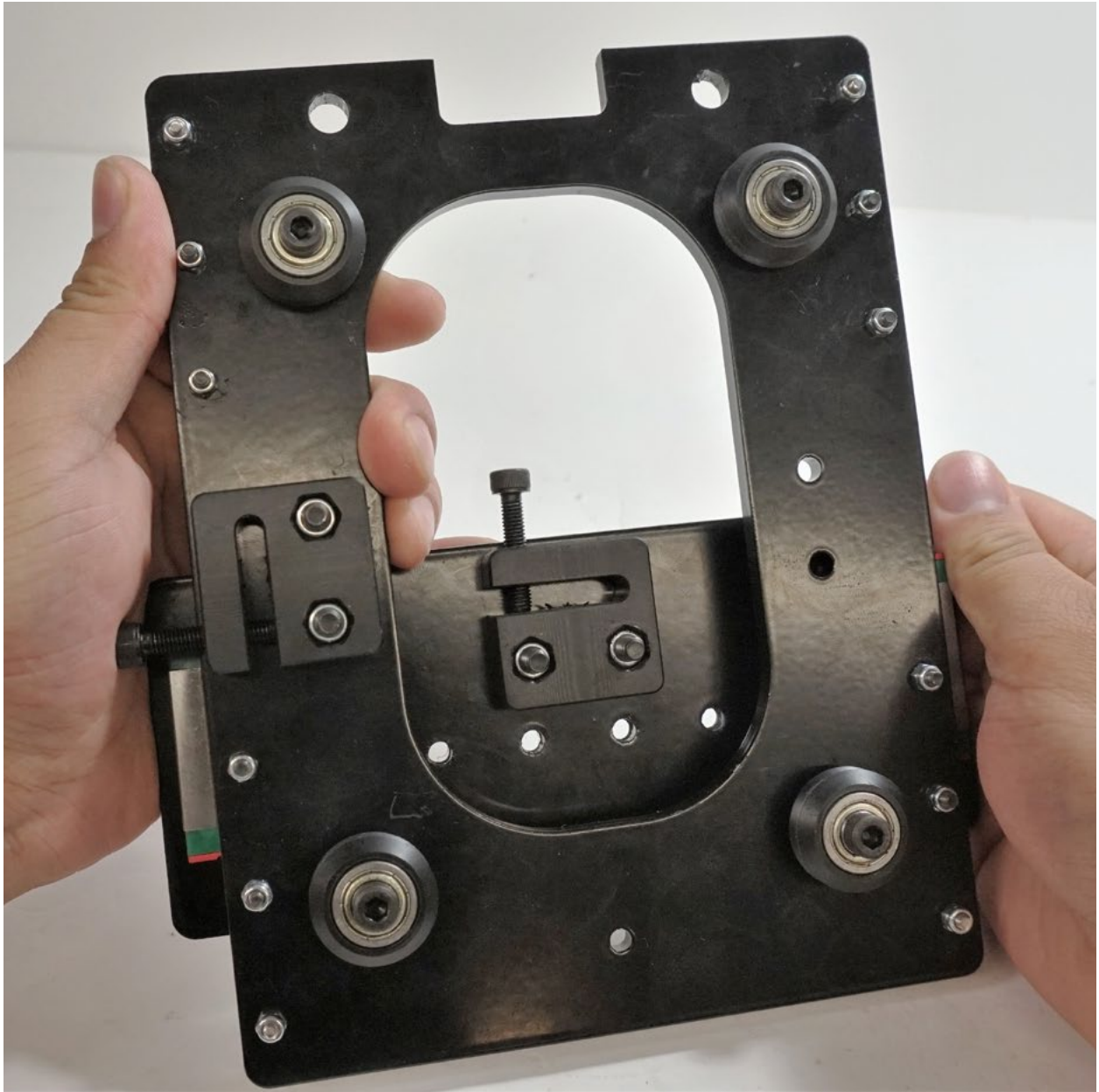


Now we'll do the same process on the Z-axis on the two holes shown.



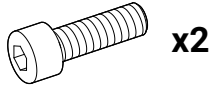
*Screw in the next nut block, making sure not to overtighten.*

The completed assembly should look like this.



## Connecting the two major sub-assemblies

Parts Needed:



**x2**

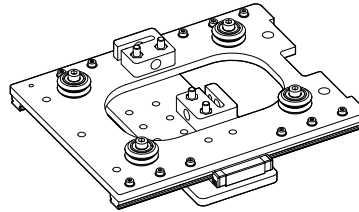
M8-25mm bolt



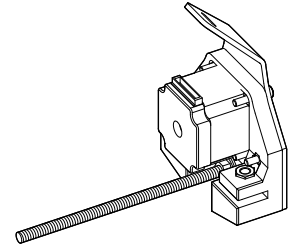
**x2**

M8 nut

Previously Assembled

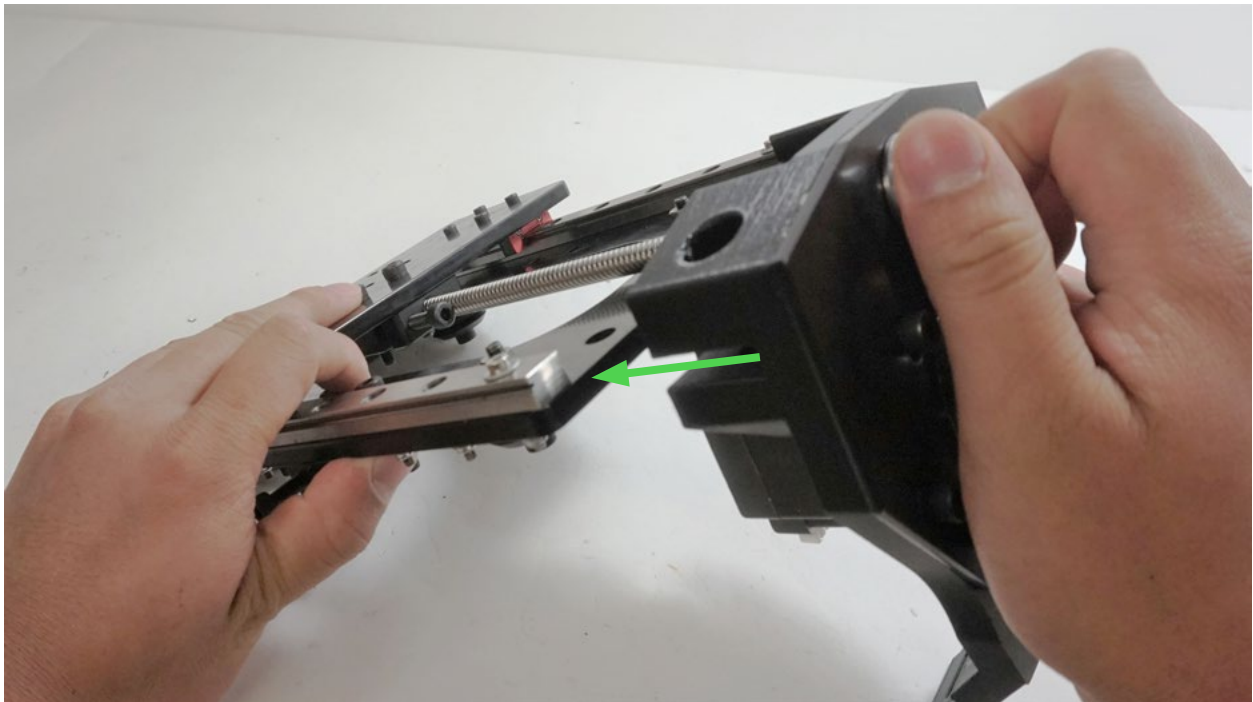


XZ-axis gantry sub-assembly



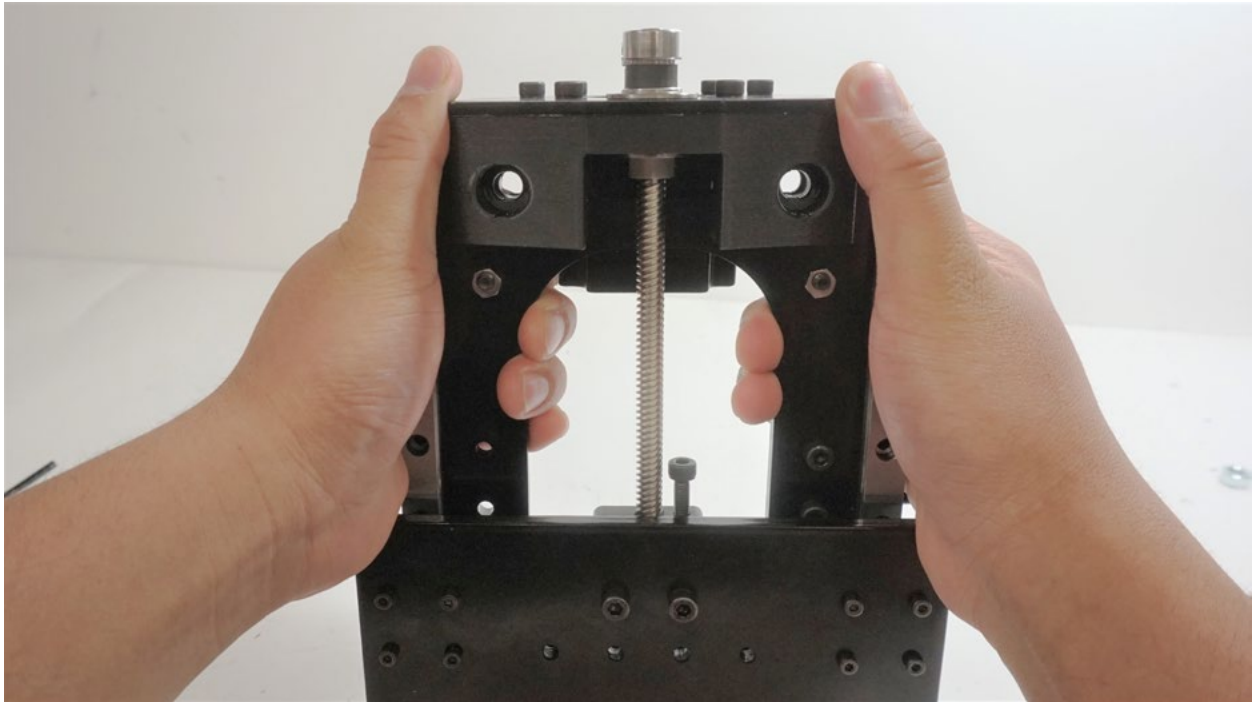
Z-axis motor sub-assembly

Get the motor sub-assembly from before. Holding it in one hand, and the gantry sub-assembly in the other, line up the lead screw from the motor assembly with the nut block of the gantry assembly. If you use your fingers to turn the lead screw, it will go into the nut. The plastic mount should be coming in from the side of the steel plate which has a rectangular notch cut out.



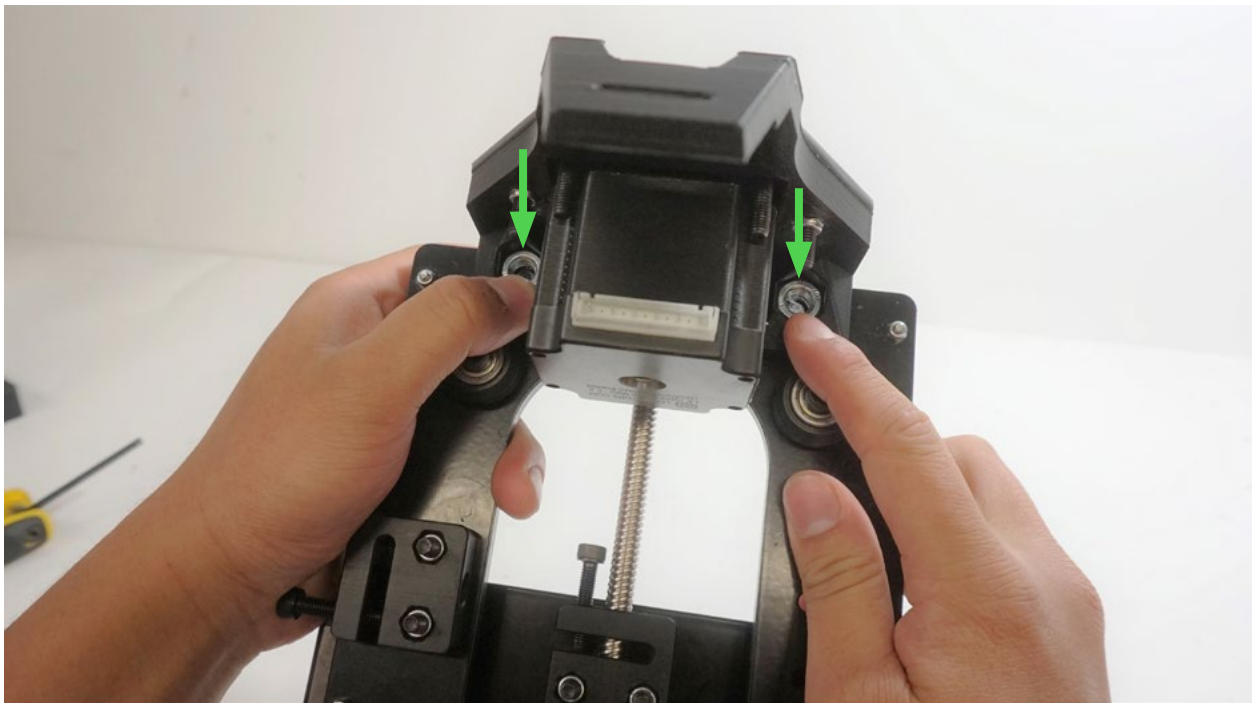
*If you have trouble turning the lead screw into the nut, try loosening the bolts holding the nut to the plate. Also, be sure that the tensioning bolt (sticking upwards) is completely loose.*

Continue turning the lead screw until the plastic, Z-axis mount is fully seated into the top of the plate and you can see the holes lining up.



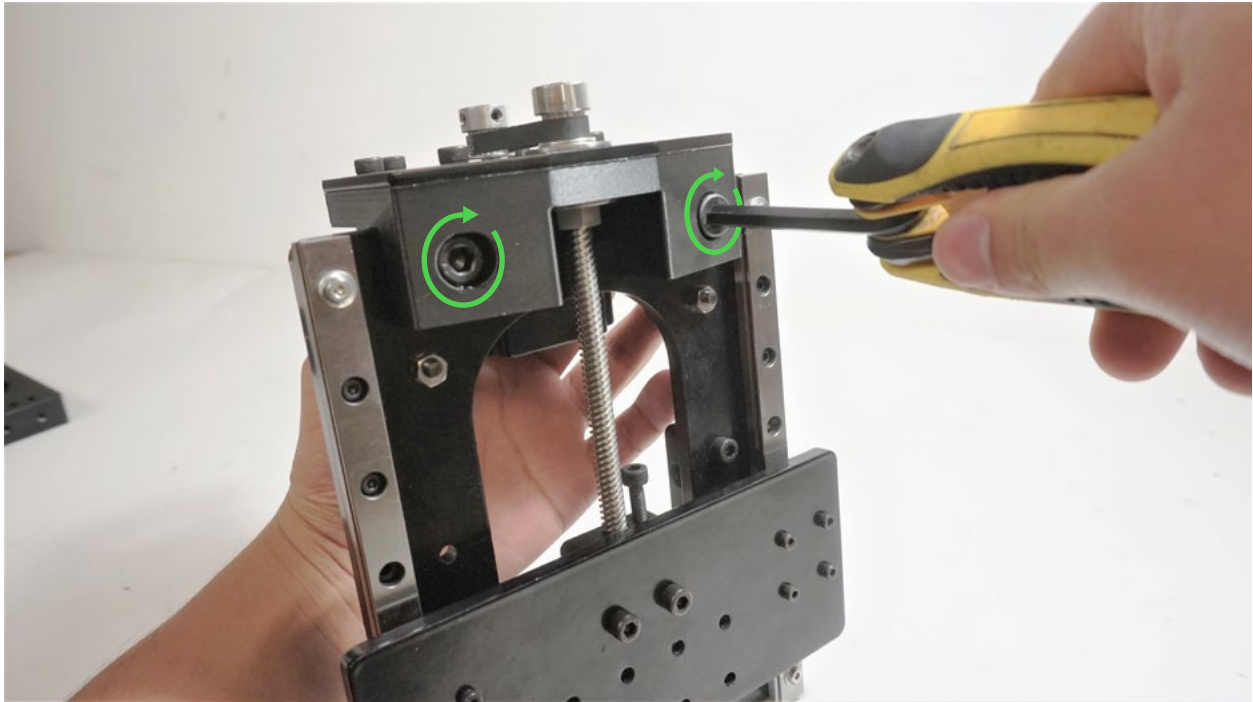
*Shuffle the mount side-to-side or push it further into place to align the holes*

Get the bag of large nuts and the other with the largest and longest bolts; you'll use a pair of each to fasten these two assemblies together. Take the two large, M8 nuts and push them into the back of the plastic Z-axis mount. If the nut fit is a little tight, then you can use a size 6 Allen key or other tool to press it into place.



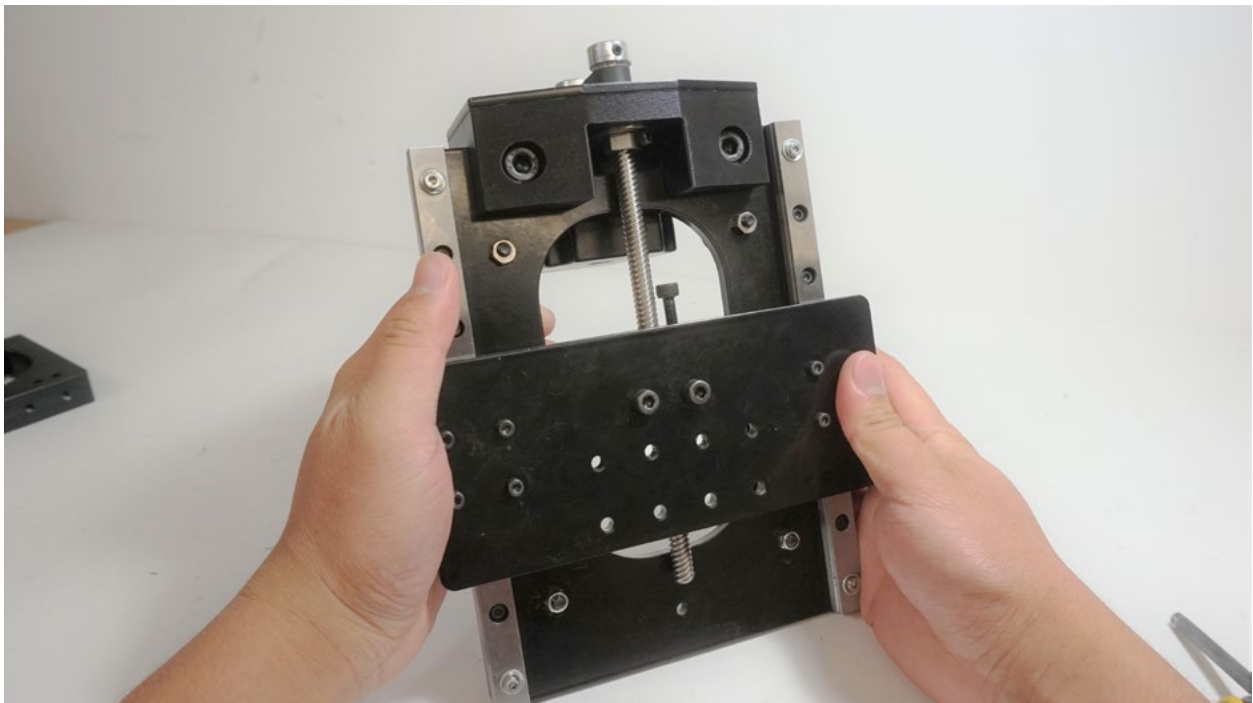


Now with the two long bolts, slide them in from front through the two holes in the plastic mount. Turn them into place with a size 6 Allen key to secure the two assemblies together; the bolts should be reasonably tight.



*Fasten the M8 bolts. Keep a finger on the M8 nuts if you are finding they pop out when you first start tightening the bolt.*

Your assembly should now look like this.



*Completed assembly (up to this point).*

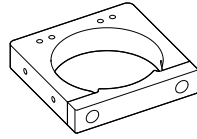
## XZ-axis gantry sub-assembly

Parts Needed:



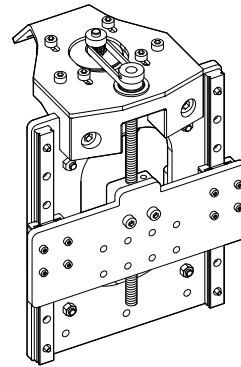
**x4**

M5-12mm bolt



Aluminum router mount

Previously Assembled



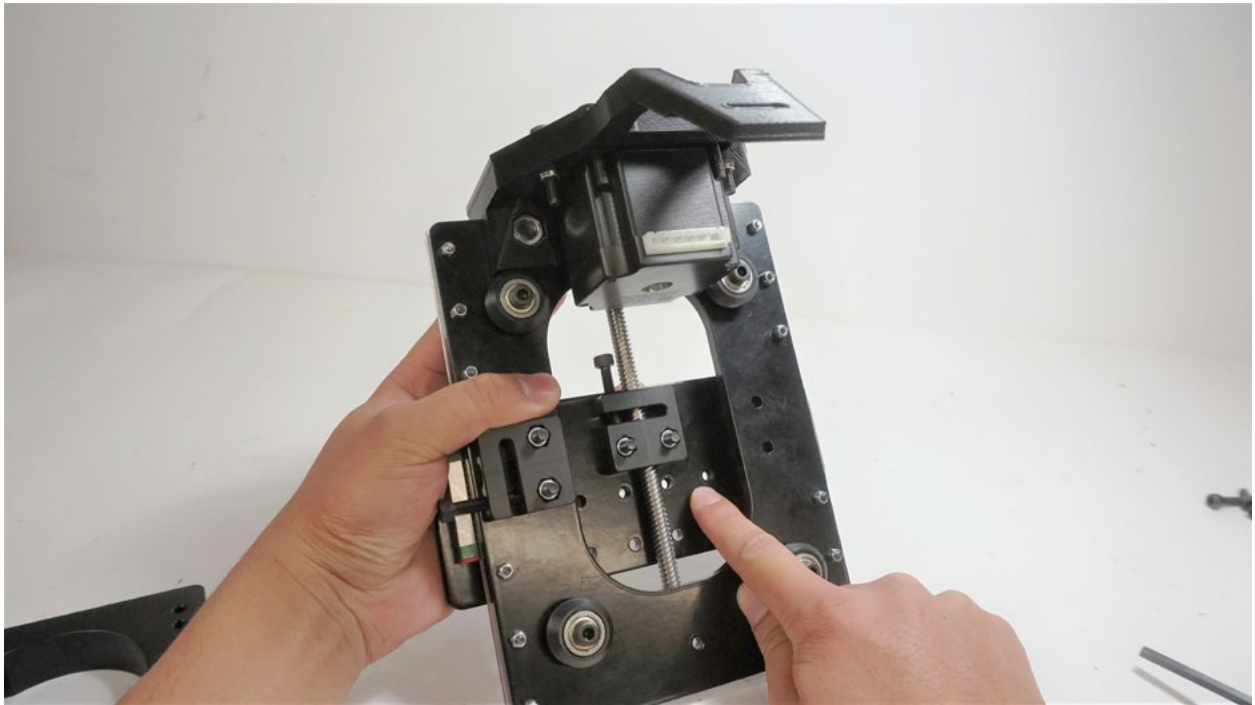
XZ-axis gantry  
assembly

Notice that the Z-axis gantry plate has two sets of four holes; these are positioned for mounting the aluminum router mount at two different heights. The lower set of holes will allow your router to gain more cutting depth, whereas the upper set will mount the router more rigidly and allow for the full height clearance. Use the upper set of holes to start.

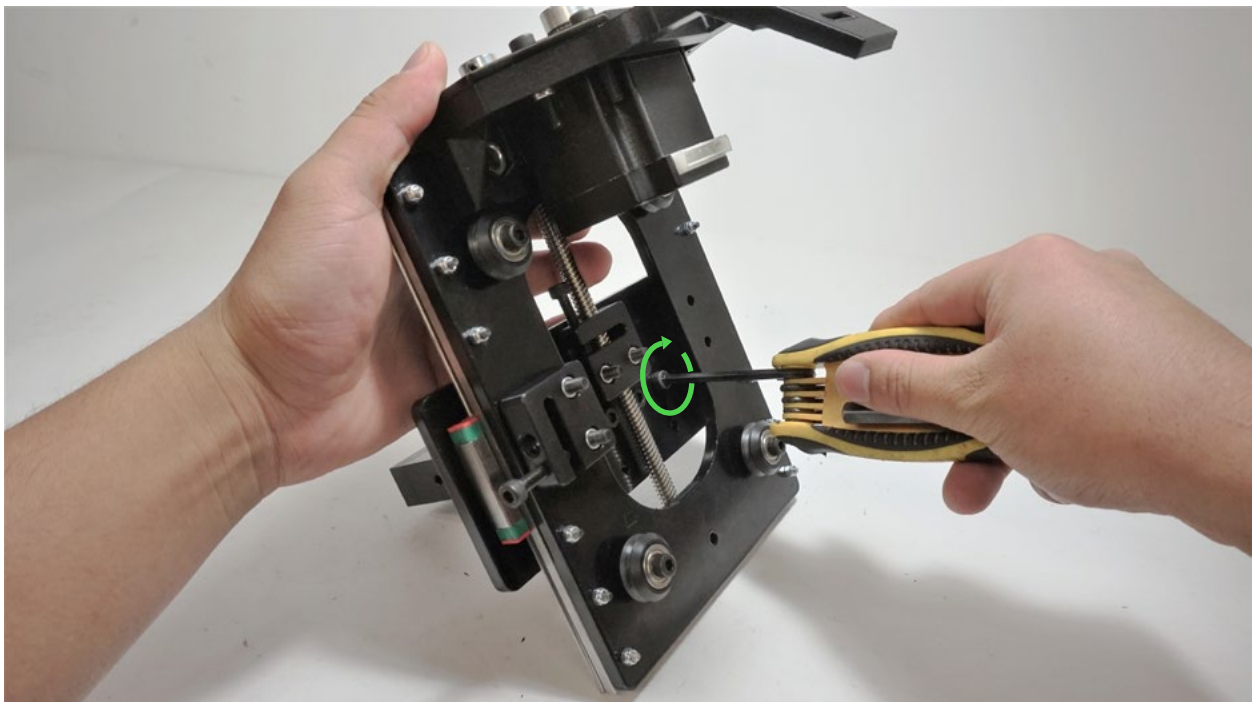


Find your machine's included aluminum router mount, it will be individually wrapped in paper and labelled appropriately (mount pictured). Also, find the bag with very few, medium-sized bolts which are also short, these will be use to attach the aluminum mount.

With the current assembly turned around (looking in from behind) you'll be able to place the four shorter bolts into the upper set of holes. Holding the router mount up to the bolts, you should be able to fasten it into place with a size 4 Allen key.

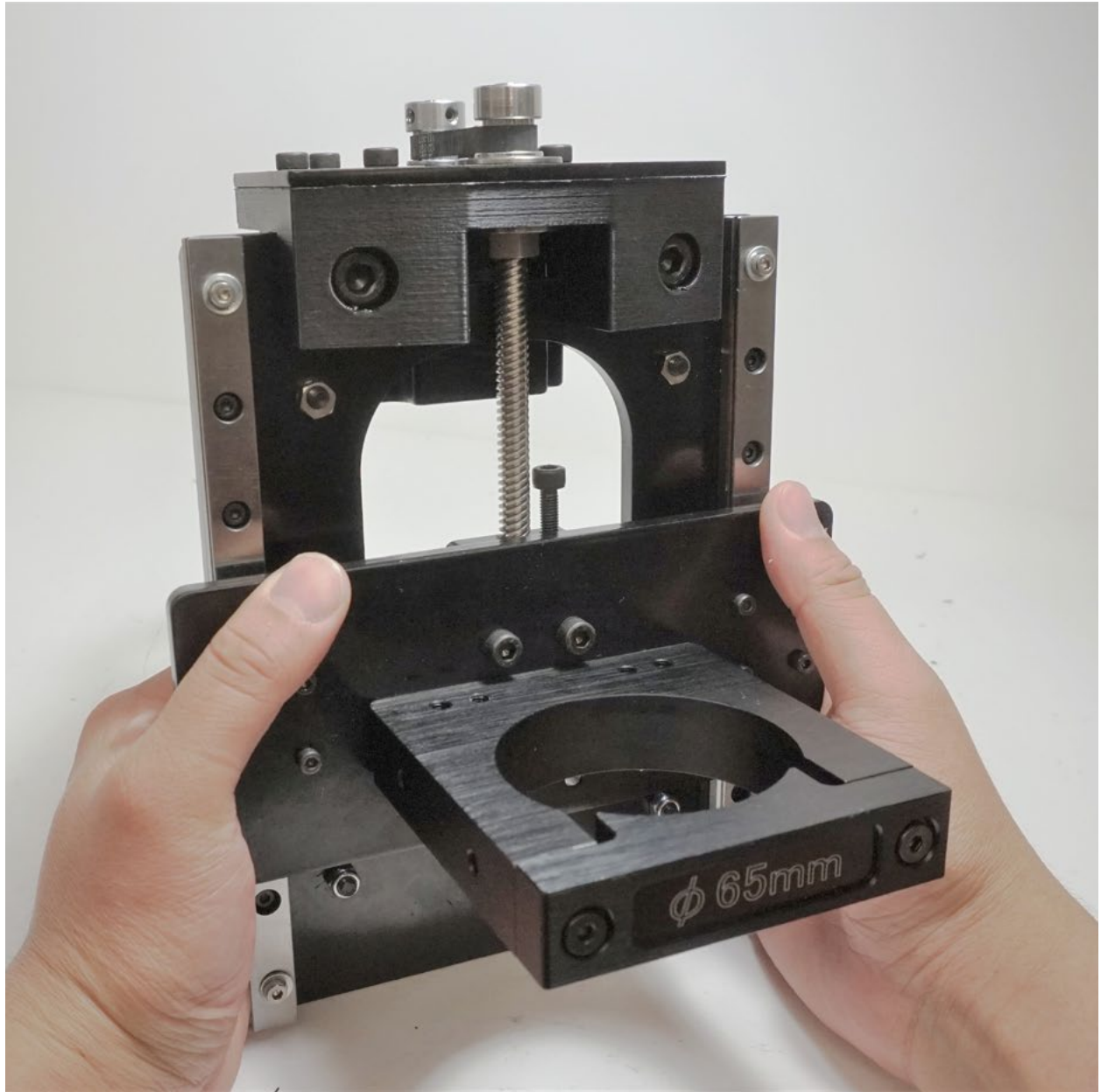


*The top set of holes in the Z-gantry looking in from behind the current assembly*



*Use the four M5-12mm bolts to mount the router mount.*

Your final assembly should look like this. Congrats, you've completed the assembly of the XZ-Axis Gantry!

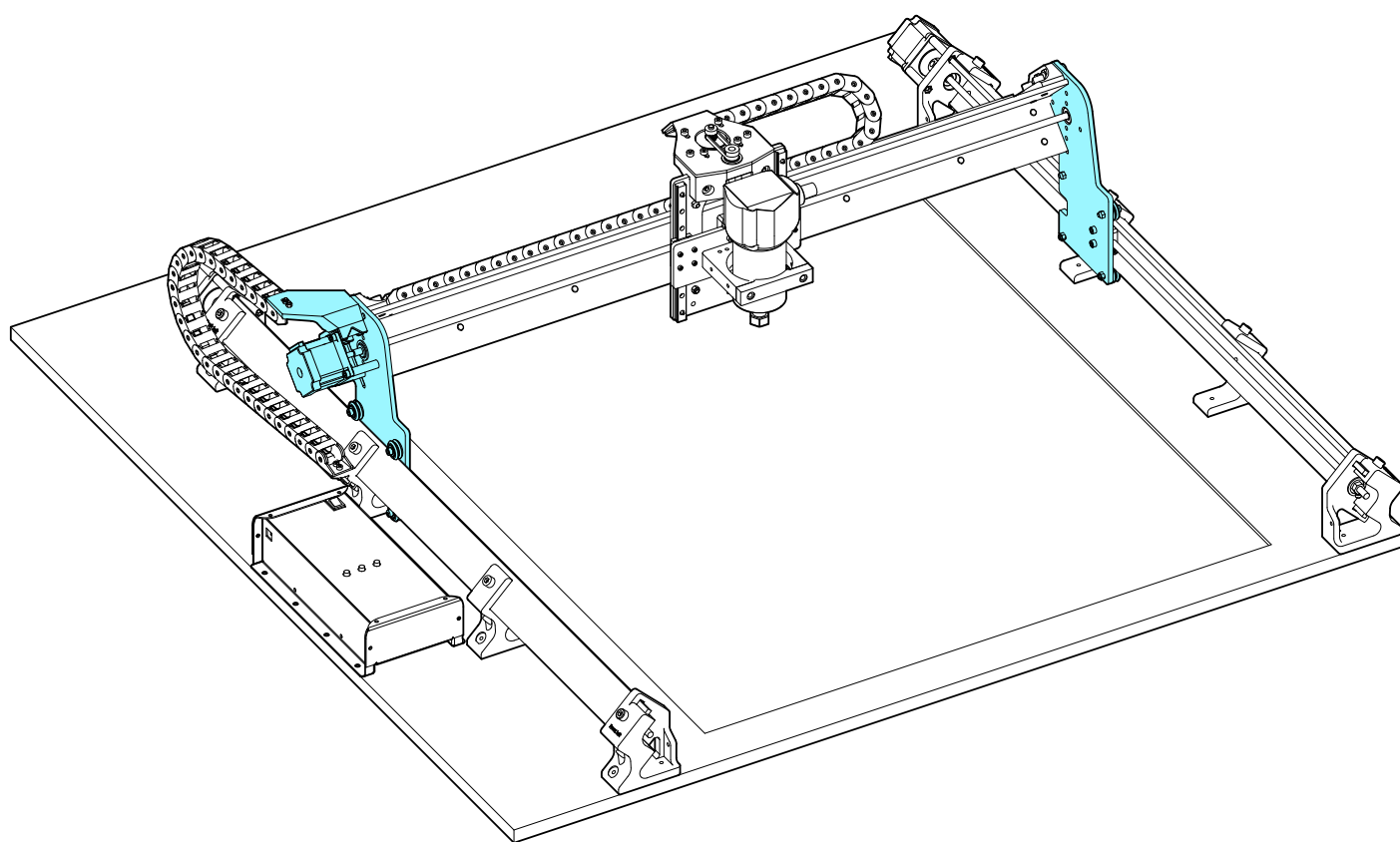


*That was fun, wasn't it?*



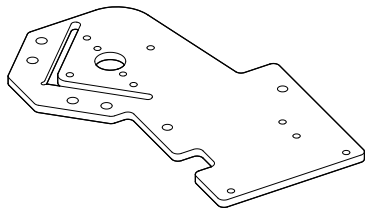
## Part 2

# Y-Axis Gantries



## Y-axis gantries (wheels)

Parts Needed:



**x2**

Y-axis gantries



**x4**

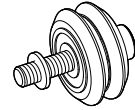
Eccentric nut



**x4**

M5-nylock nut

Previously Assembled



**x8**

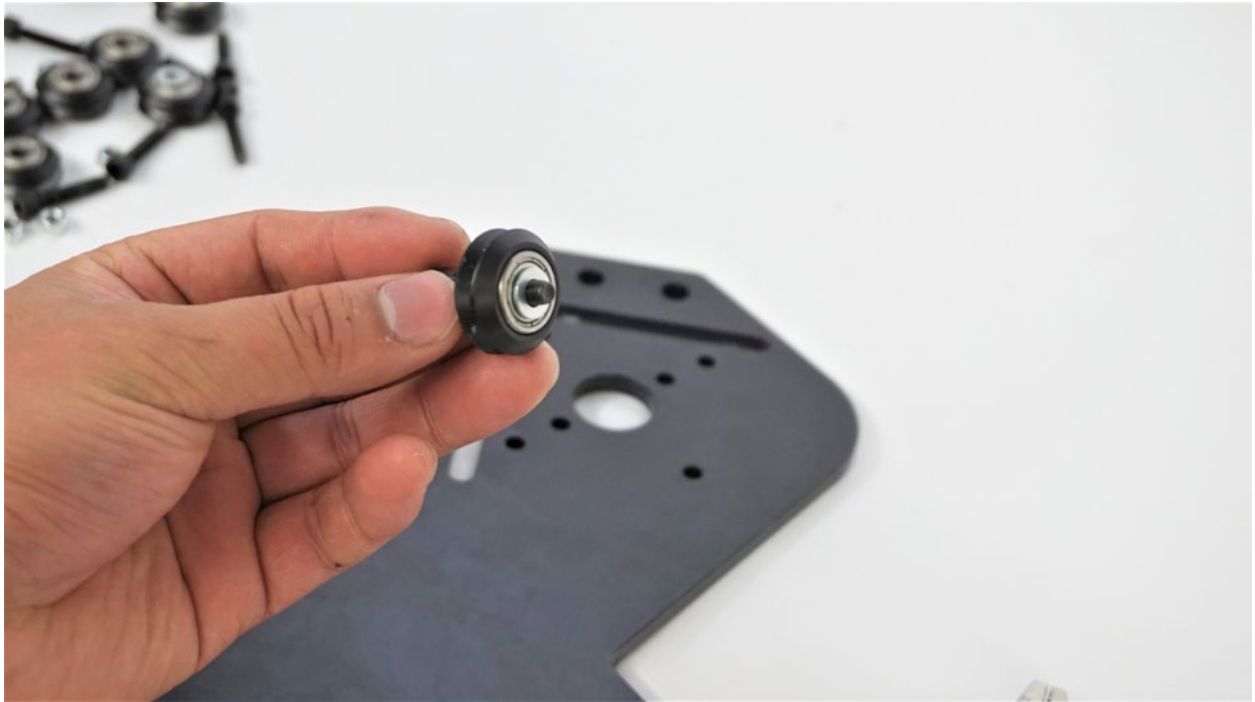
V-wheel set

Grab the Y-axis gantries (wrapped in paper) and you'll see four holes on each steel plate in a square formation. Add the wheel sub-assemblies to these holes just like how you did before, with the eccentric nuts placed as pictures and the nylock nuts on the two lower holes; make sure that one is assembled as the mirror of the other. Use a size 4 allen key and 8mm wrench or pliers to tighten everything down, but leave the eccentric nuts slightly loose for now.

If you have a hard time getting the eccentric nuts in, we recommend tapping the nuts in with the back of a screwdriver or other dull object. This will help clear the excess paint that might still remain in the hole.



*Install the eccentric nuts into the top two holes.*



*V-wheel sets with a washer to keep the v-wheel spaced from the gantry plate*



*Fasten the wheels to the eccentric nuts, leave these slightly loose for now*



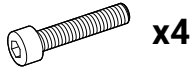
*Assemble the bottom two wheels with M5-nylock nuts and tighten all the way*



*Make sure you have both plates done, but with the wheels on opposite sides.*

## Y-axis gantries (anti-backlash)

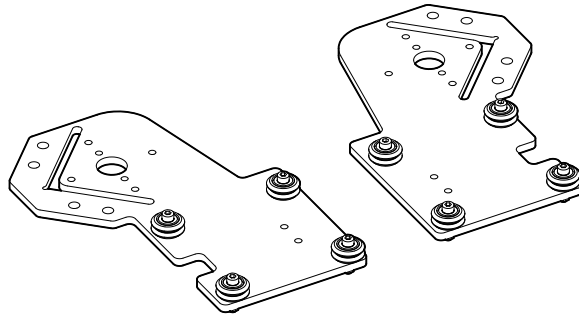
Parts Needed:



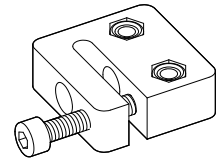
**x4**

M5-25mm bolt

Previously Assembled



Y-axis gantries (with wheels)



**x2**

Anti-backlash assembly

On the Y-axis plates, there are two holes for the anti-backlash assemblies to mount. Line up the plastic blocks and secure them to the plate using the same medium-sized bolts that were used for the wheels. The blocks should be mounted on the same side as the v-wheels, and have the tensioning screw facing outwards.



*The Delrin nuts go on the same side as the v-wheels do.*



*Tighten until snug. Don't overtighten!*

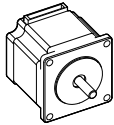


*Both sides should be mirrored.*

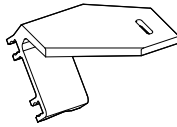


# Mounting the X-axis motor to the left plate

Parts Needed:

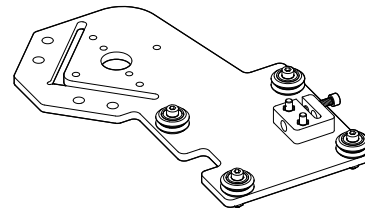


NEMA 23 motor

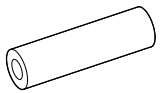


3D printed drag chain mount

Previously Assembled

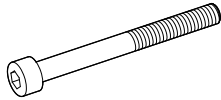


Left Y-Axis Gantry



**x4**

35mm aluminum spacer



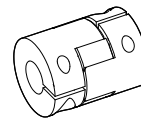
**x4**

M5-50mm bolt

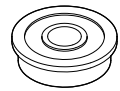


**x4**

M5-nylock nut



6.35mm to 8mm coupler



608ZZ flange bearing

Make sure you have grabbed the correct gantry (pictured below).



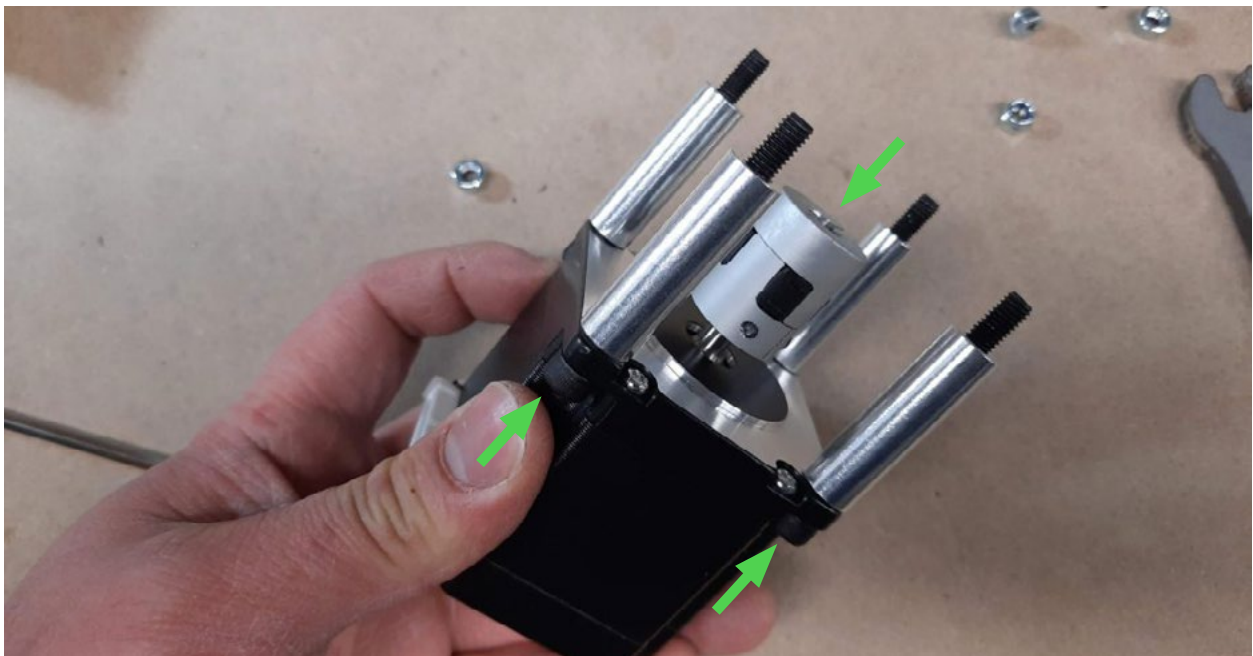
We will put a 608ZZ flange bearing into the hole.



Get a motor, the bag of medium-sized nuts, and the bag of long bolts and aluminum spacers. You will also need a coupler and bearing for this assembly. Note that your coupler may be solid or jaw type, but they both work the same way (jaw type shown below).

Start off by attaching the coupler to the motor shaft, making sure you have the smaller hole sliding onto the shaft and the larger hole facing up so that we can put the lead screw on later. Put the coupler down as far as it will go and loosely tighten the screw to secure it for now. We will adjust this later so there is no need to screw down too hard.

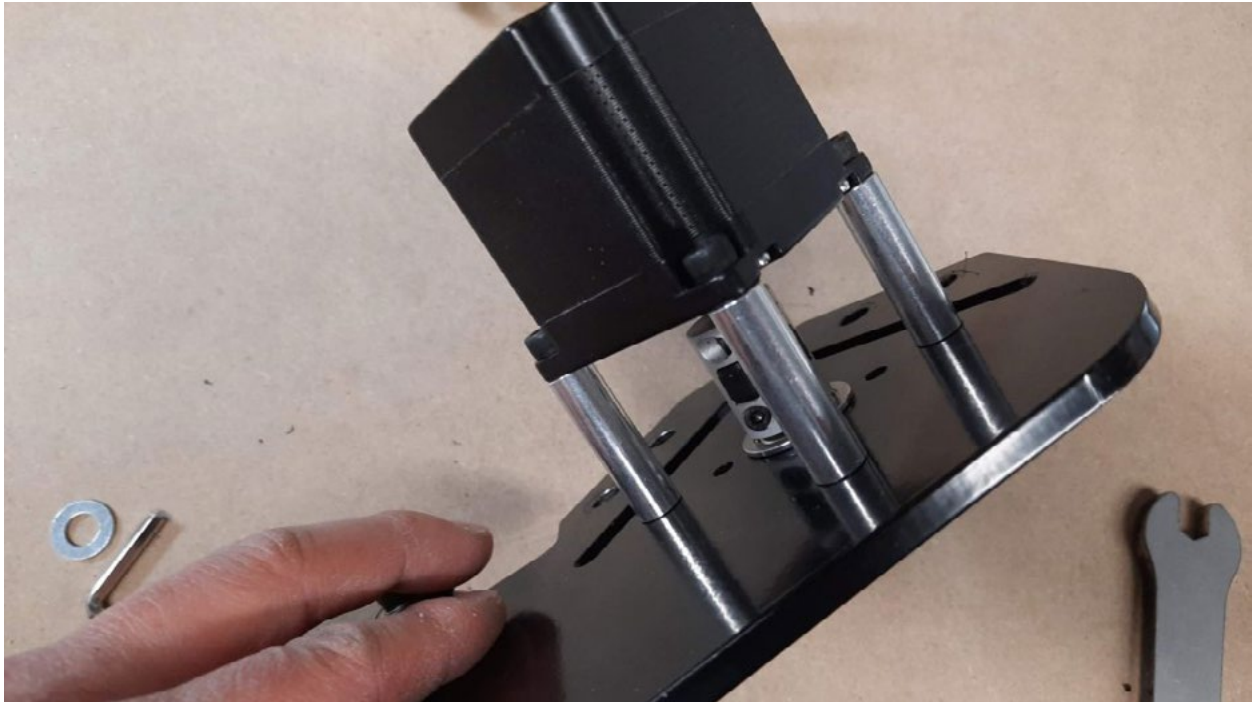
Then put the long M5 bolts onto the motor, followed by the spacers.



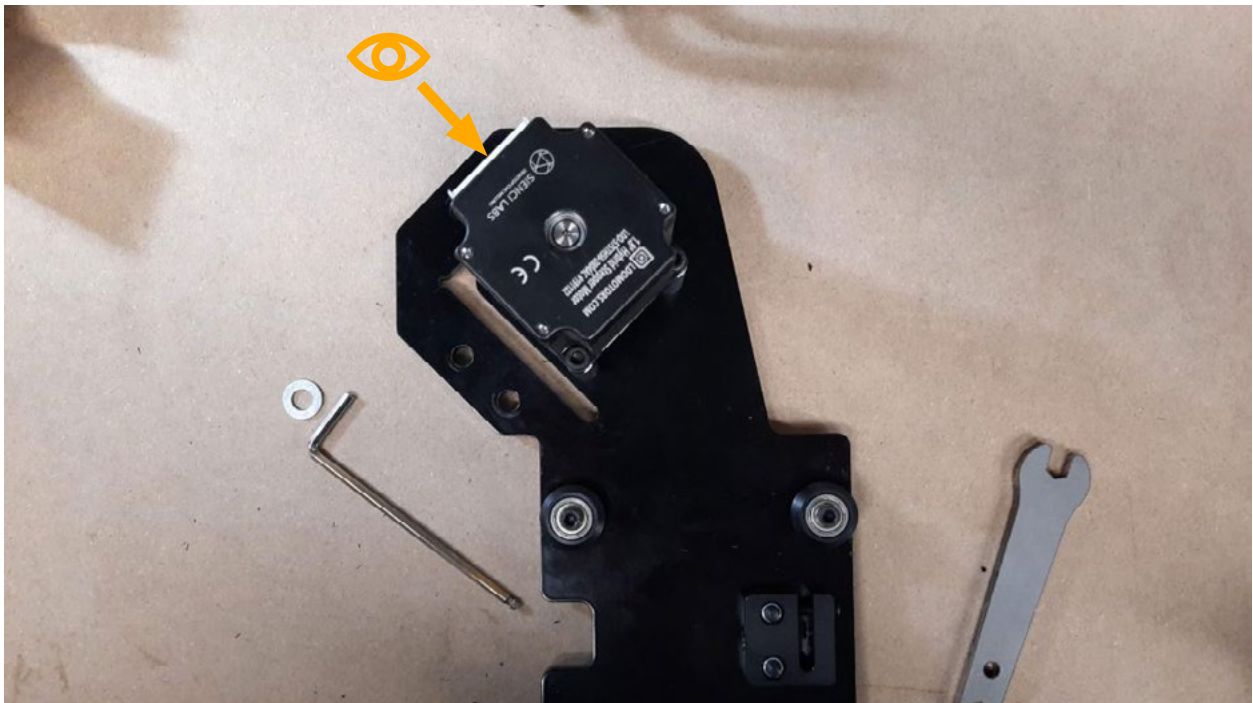
*Attach the coupler, spacers, and M5-50mm bolts to the motor.*



Carefully line up the screws into the four holes in the Y-axis gantry. Drop the motor, bolts, and standoffs into place. Take note of the position of the white motor connector in terms of its rotation and what side of the plate you are mounting it onto (the side with the wheels).

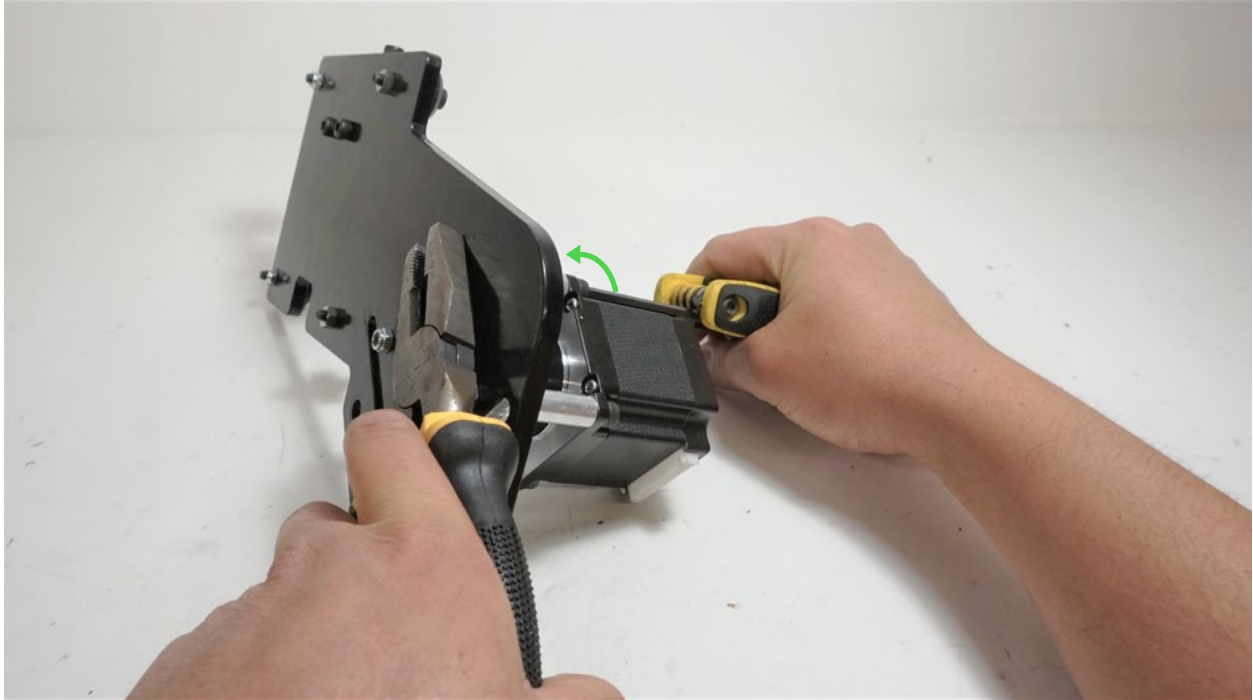


*Attach motor using M5 nylock nuts.*



*Take note of the direction of the motor connector.*

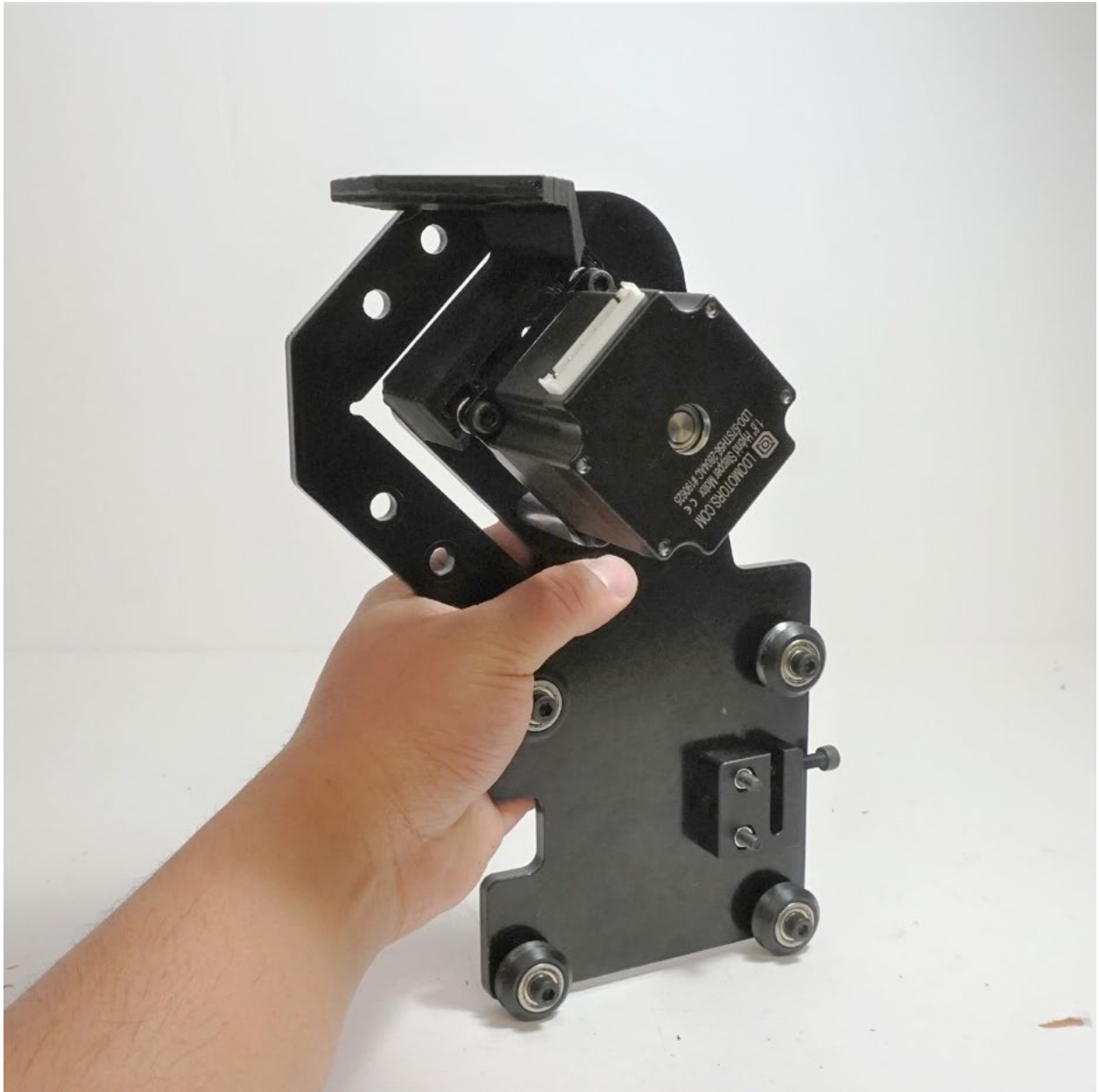
Use the four M5-nylock nuts to secure the plate-side of the M5 bolts. This requires a size 4 Allen key and an 8mm wrench or pliers. If it's easier, start by finger-tightening all four nuts to keep everything in place before using the pliers to finish tightening.



Among the group of plastic parts you should find one that has a thin 'wing-like' shape, this is the plastic y-axis drag chain mount. Grab this and clip it onto the aluminum spacers in the orientation shown. We've found that it is easiest if you clip on one side first, then swivel the other side on afterwards.



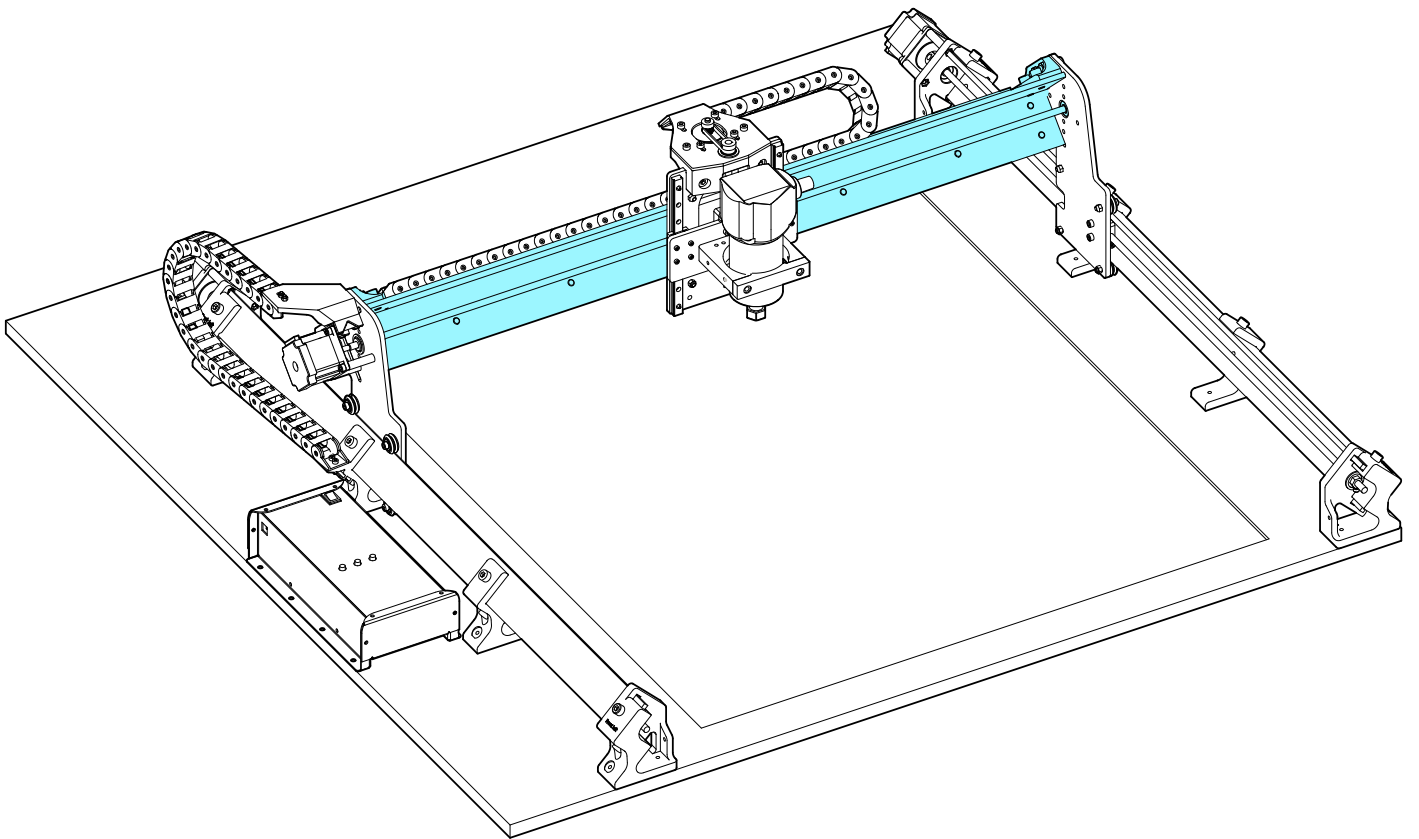
Once everything is finished getting put together, it should look like this:



*On to the next section!*

## Part 3

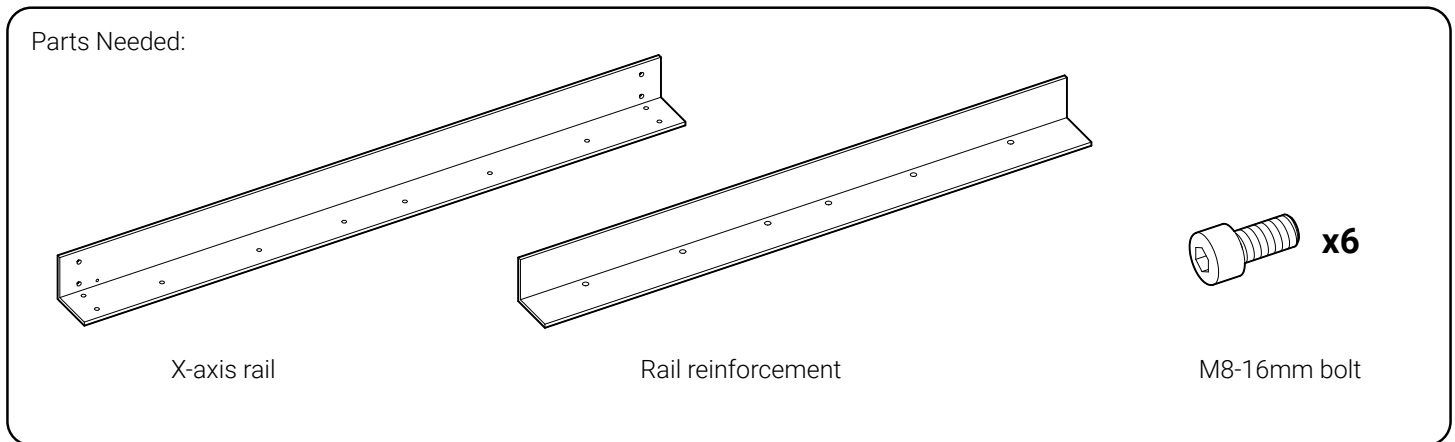
# X-Axis Rail





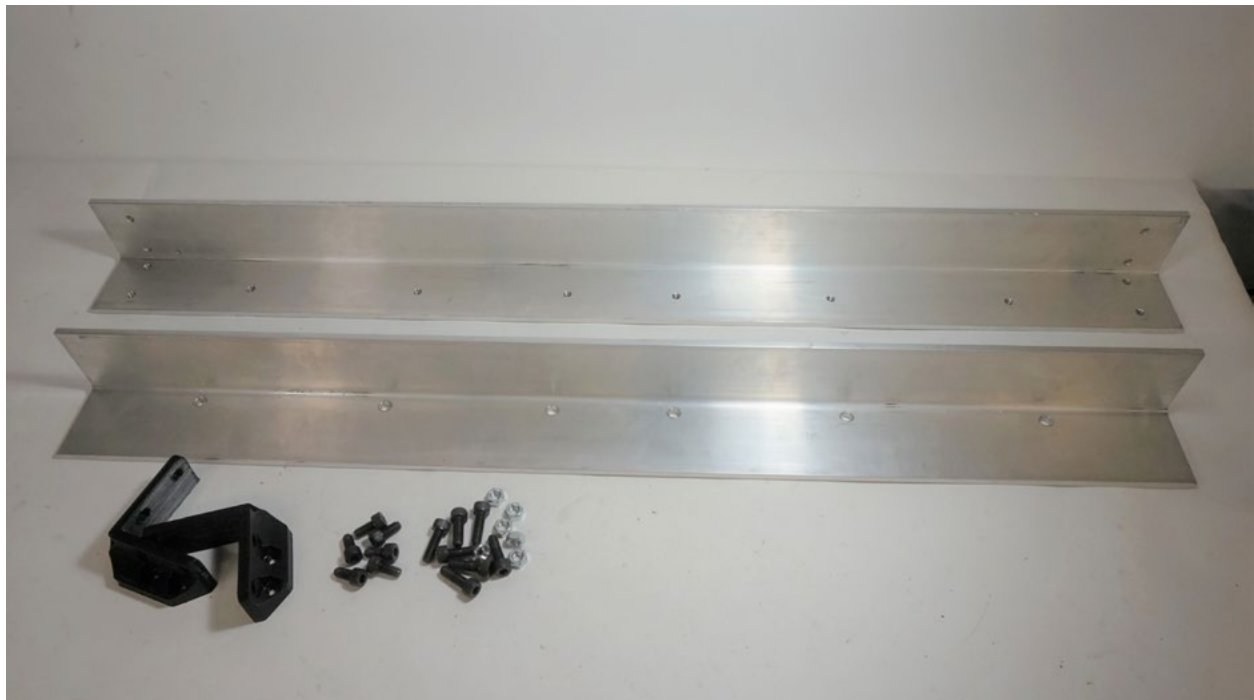
## Preparing the X-axis rail

**Note:** The 12×12 LongMill is a smaller build envelope so it doesn't require an X-axis reinforcement bar. Move onto the next step "Attaching the Shoulder Brackets", but keep in mind that the remaining pictures may show another piece of angled aluminum attached to the back of the X-axis rail. Pay no mind to this since the assembly process is otherwise the same.

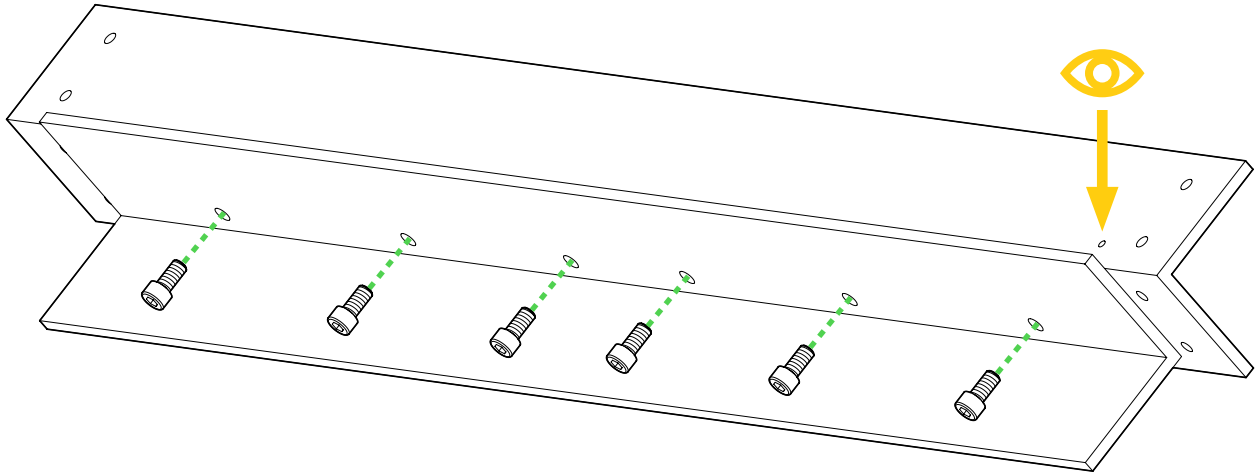


The 12×30 and 30×30 model LongMills use a second aluminum extrusion as a reinforcement bar to make the primary rail on the X-axis more rigid. These are the two longest and largest aluminum lengths on your machine and can be found in the heaviest long box alongside the other rails.

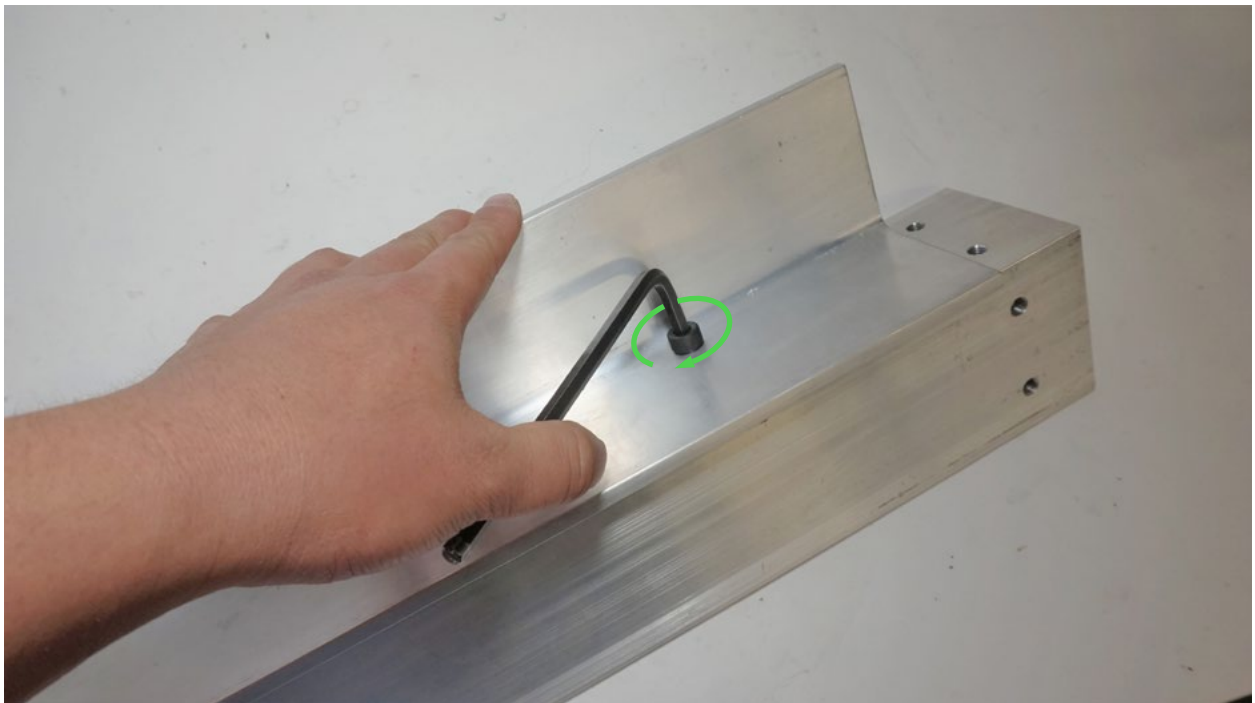
Of the two, the longer one is the X-axis rail and the shorter one is the reinforcement. You can also distinguish the two since the X-axis rail has sets of four threaded holes at its ends.



Start by orienting the rails into a 'lighting bolt' pattern like in the photo so that the set of six holes on both can be aligned. Also, make sure to check that the small threaded hole on the X-axis rail (yellow) is oriented as shown so that you'll be able to attach your drag chain later on.



Grabbing the bag of short, large bolts, you can use six of these to fasten these parts together; the bolts will go through the larger holes on the reinforcement bar and thread into the X-axis rail from the back (pictured). Start by turning each of these short M8 bolts in by hand to get all the holes aligned, then go back and tighten each of them down well with a size 6 Allen key.

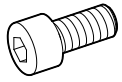


Your completed rail should now look something like this.



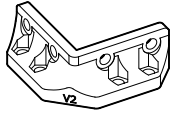
## Attaching the shoulder brackets

Parts Needed:



**x8**

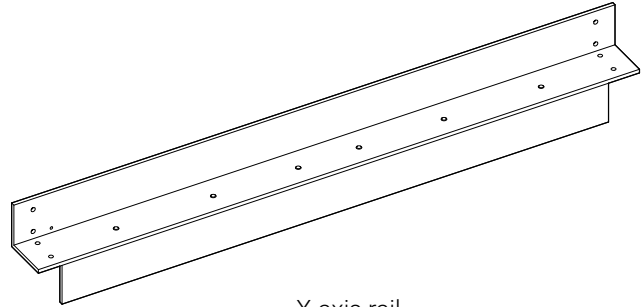
M8-16mm bolt



**x2**

3D printed  
shoulder brackets

Previously Assembled



X-axis rail

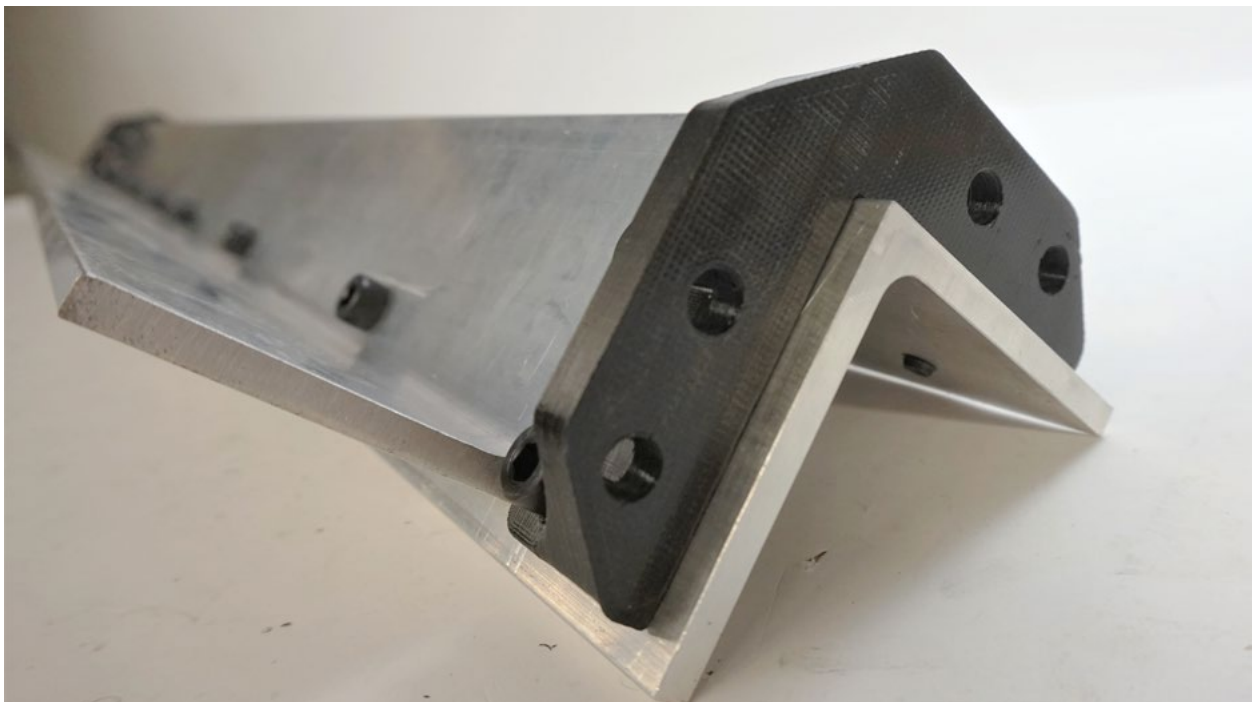
Get the plastic, L-shaped 'shoulder' parts from the pile of plastic parts next. These go onto the two ends of the aluminum rail, each fastened with four of the bolts from the bag of short, large bolts. Line each up with the holes first, with the flat part of the bracket facing out (pictured), before turning the bolts on by hand.



*Make sure to point the bracket in the right direction.*



Finish securing the M8 bolts with a size 6 Allen key, being sure not to over-tighten them.



*Brackets attached on both ends*

## Sandwiching the rail with the Y-gantries

Parts Needed:

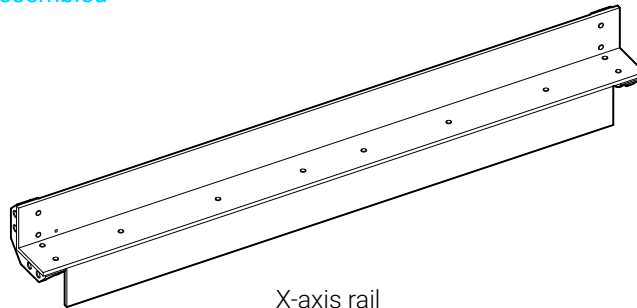


M8-25mm bolt

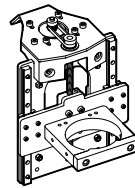


M8 nut

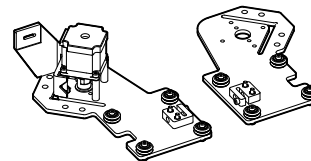
Previously Assembled



X-axis rail



XZ-axis gantry assembly



Y-axis gantries

After the previous step, you should now have four major assemblies completed: the XZ-axis gantry, the two Y-gantries, and the X-axis rail. These assemblies will all be coming together in this step, starting by sliding the XZ-axis gantry assembly onto the X-axis rail.

**DO NOT** stand the completed assembly up on the v-wheels, it can roll away or become unbalanced which may cause it to fall and become damaged; just leave it laying on its back for the next steps. You can consider propping it up at an angle as well if you don't want the weight of the assembly pressing on the back of the Z-axis motor mount.

Before we start, you want to make sure that the eccentric nuts on the XZ-gantry are positioned correctly; this can be checked visually. Since the eccentric nuts have an offset hole point, rotating the nut will change the hole position. Looking at the gantry assembly from the front, this picture shows the top, right eccentric nut at its lowest position. This puts the v-wheel closest to the bottom v-wheel, making the wheel spacing too narrow to install onto the X-axis rail.

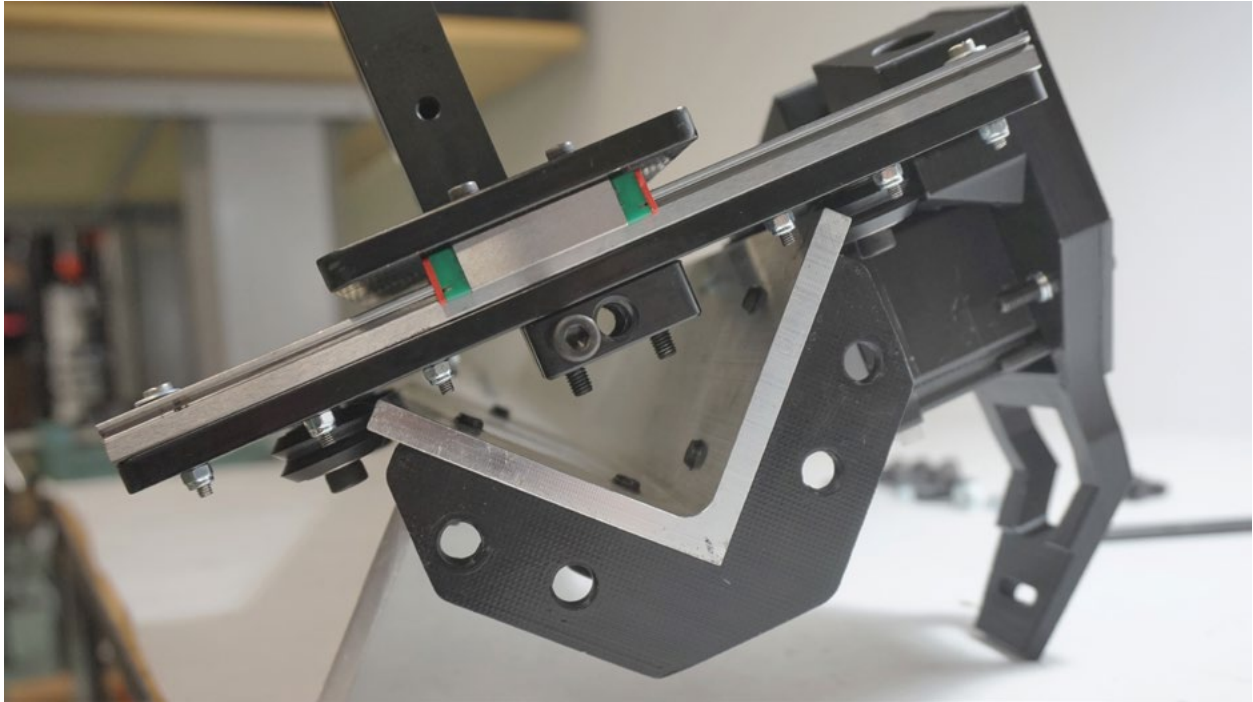


Below, the eccentric nut is in its highest position. This spreads the v-wheels furthest apart, making it easy to slide the gantry on. This is how you want your eccentric nuts to be oriented to proceed with the assembly. This should also demonstrate the concept of how these eccentric nuts can be used to 'clamp' the v-wheels onto the aluminum rail in order to have rolling movement along the rail while still being rigid in other directions.

To adjust the eccentric nuts, you'll have to make sure that the bolts on the v-wheels are still loose, then you'll be able to use an 8mm wrench or a pair of pliers to rotate the nut into the correct position. Once the eccentric nut is where you want it, re-tighten the bolt with a size 4 Allen key to secure the nut into position. Do this for both nuts.

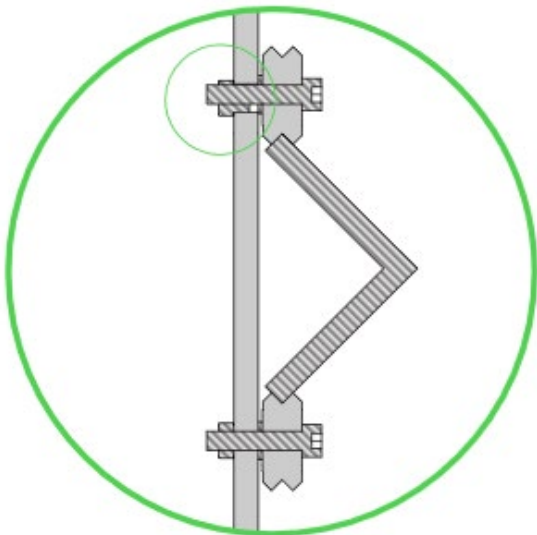


Lay the X-axis rail down along its length with the inside of the 'L' shape facing you and the small, tapped hole oriented to your left. Now take the XZ-axis gantry and slide it onto the rail, being mindful of the plastic 'arm' that sticks out the back of the assembly since it's prone to breaking in this position (pictured).



*XZ-axis gantry being slide onto the X-axis rail from the right-hand side*

The v-wheels fit over the aluminum rail as pictured below. Check that they are sitting on the rail in the correct fashion and make sure that they roll along the edge of the rail properly.

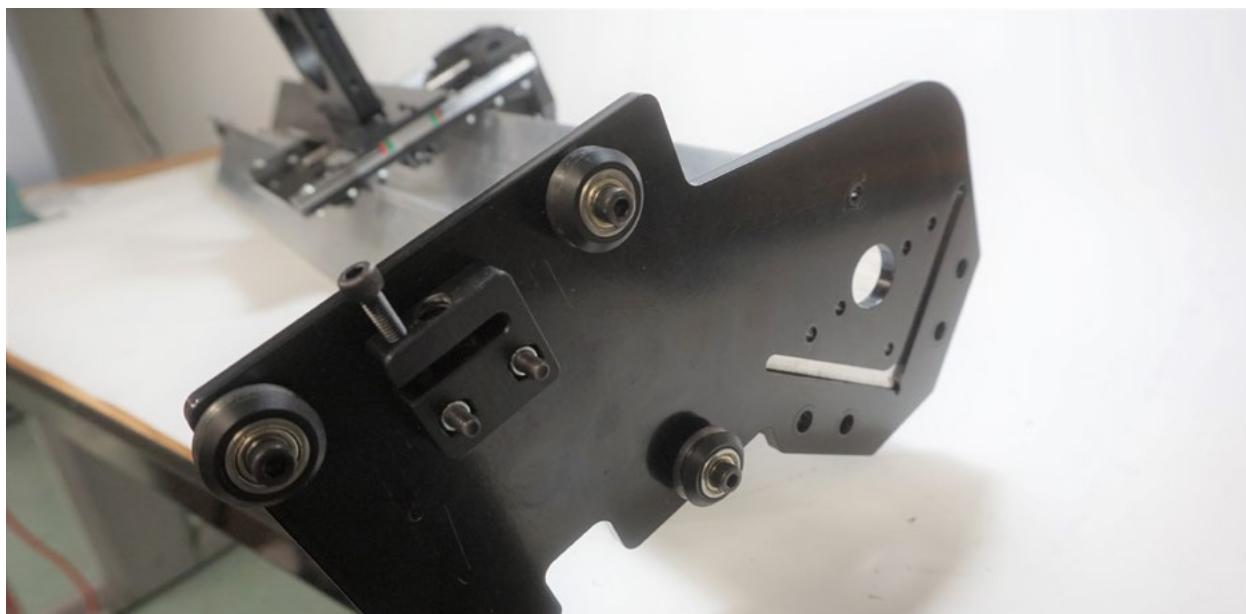


Now the eccentric nuts need to be tensioned in order for the v-wheels to properly hold onto the X-axis rail. This process is just like before when you widened the eccentric nuts, except now you want to rotate the nuts so that the v-wheels are brought closer together. Follow the process of loosening the v-wheel bolts with an Allen key, rotating the nut a small amount, re-tightening the bolts, and then checking the looseness of the wheels with your fingers. A properly tensioned system should roll smoothly along the rail but it should be difficult to use your fingers to turn the wheels by hand while the gantry is stationary.



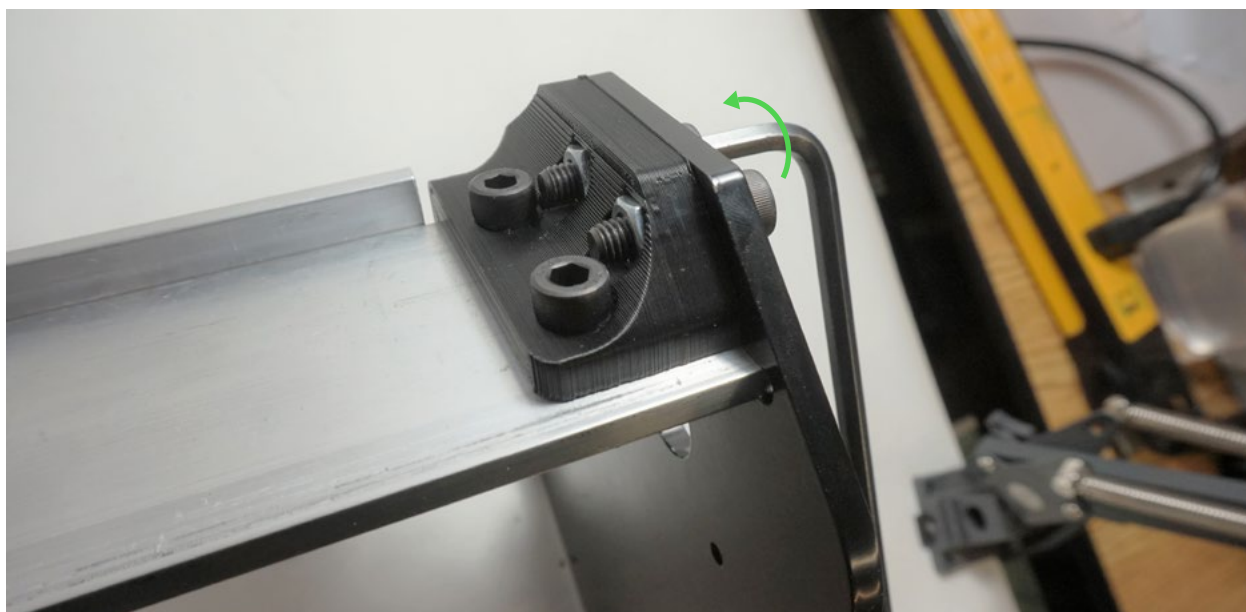
Next, we'll be putting the two Y-gantries onto each end of the X-axis rail. The orientation of each Y-gantry will be such that the wheels on the gantry will be facing towards the outside. Let's start with the right-hand side.

Line up the 'L'-shaped slot on the steel plate with the rail and tap the plate into place. It works best if you put the slot and the rail head-on so that the slot and the rail line up straight. Note that because of the variance of paint thickness in the slot, you'll chip some of it out as you mount the plate. These parts are a tight fit so that twisting in the X-axis can be kept to a minimum, so using a mallet and some coercion may be necessary but most importantly take your time.

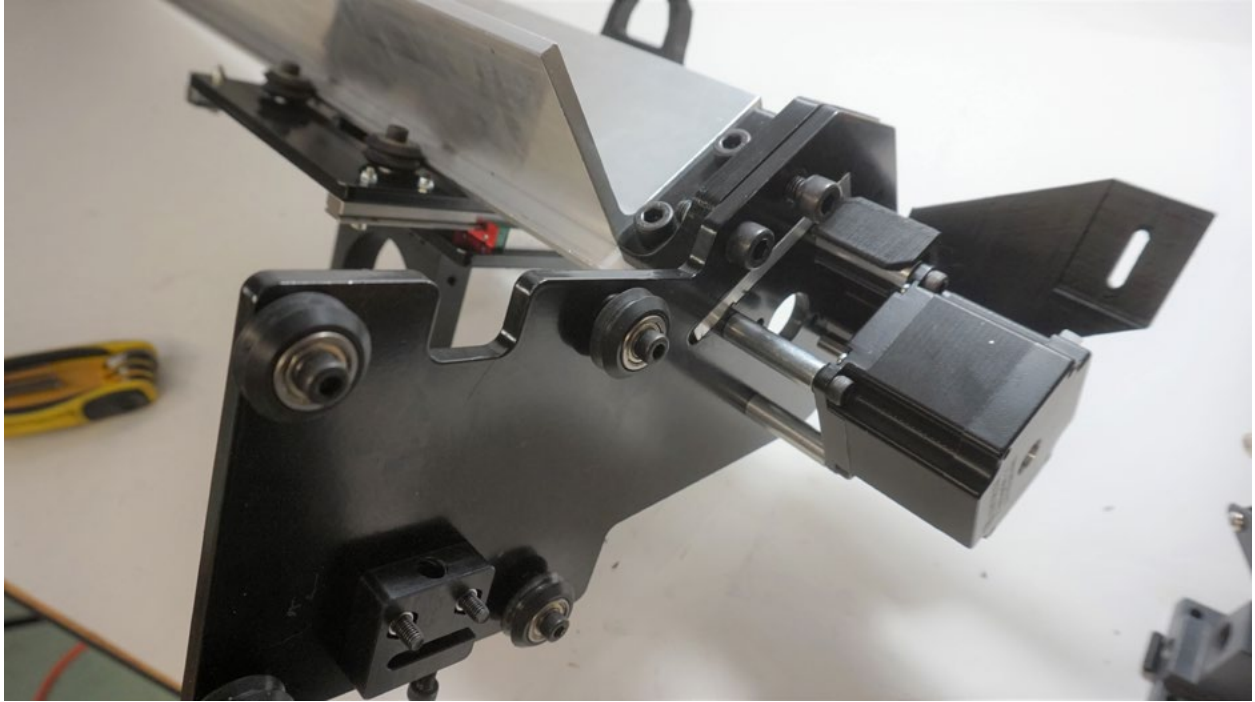


*Line up the slot to the rail carefully and tap it into place until the Y-gantry is up against the plastic shoulder bracket*

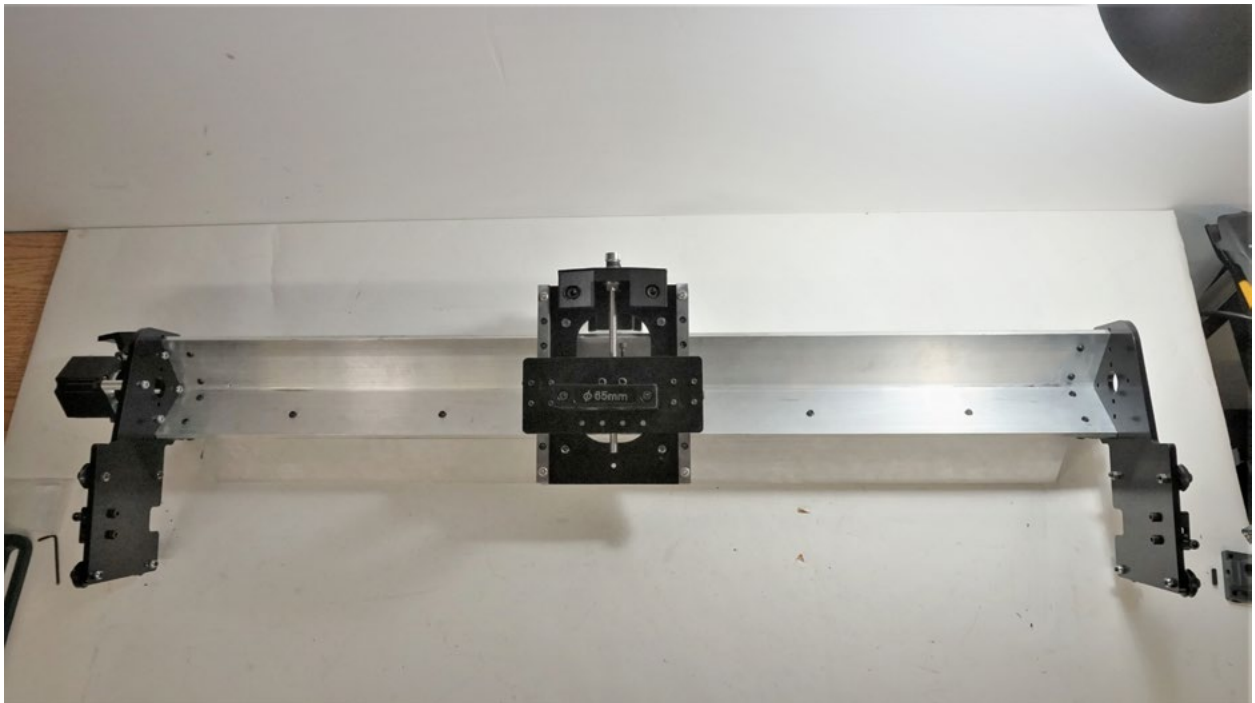
Once you get the plate on, get the bags of large nuts and the largest, longest bolts and use four of each to secure the plate to the plastic shoulder bracket. The shoulder bracket has nut catches on it to help you put the bolts on without the need for a wrench. Tighten the bolts down with a size 6 Allen key until snug. The shoulder bracket should wind up flush with the steel plate.



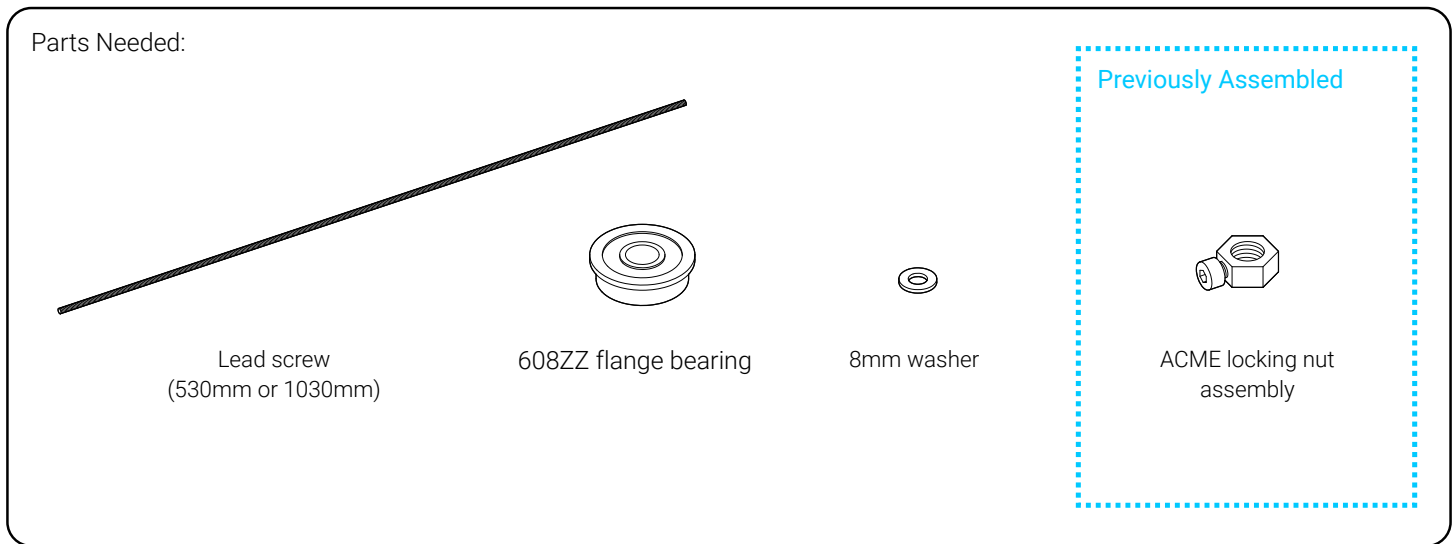
Repeat the same process on the other side, being careful not to cause damage to the motor or the drag chain mount in the process.



Now that the larger X-axis assembly is done, this is what the completed assembly should look like!

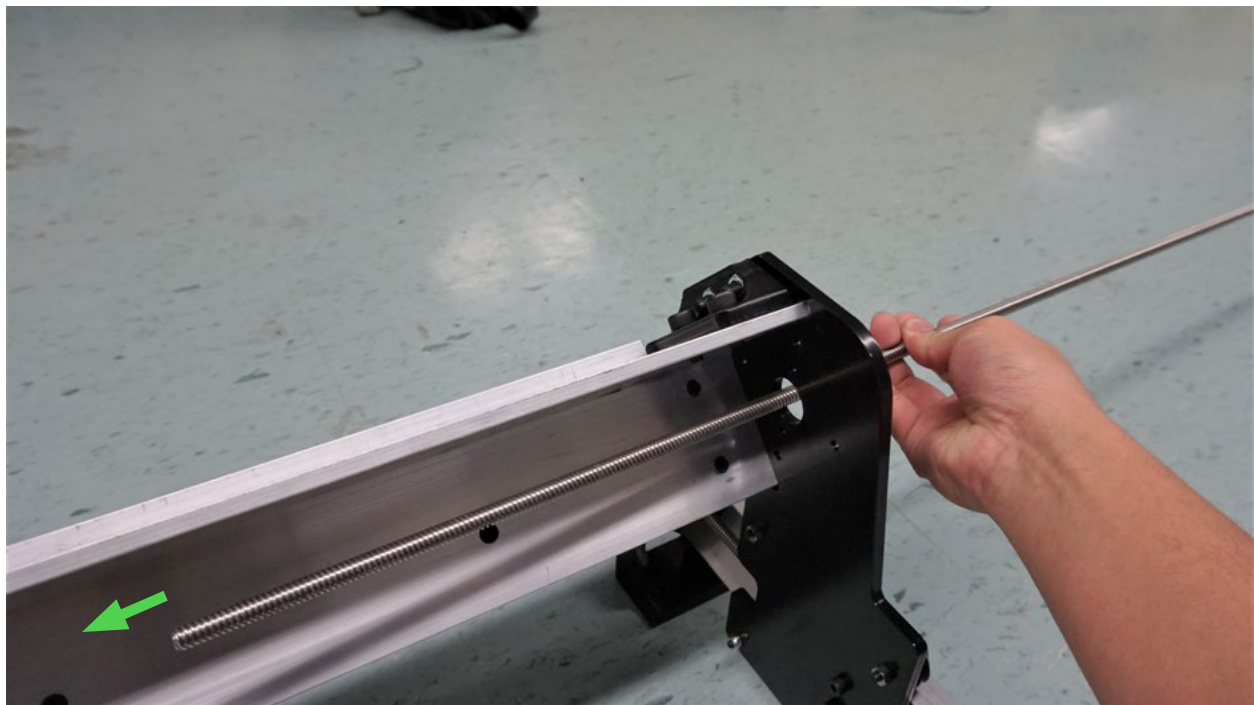


## Adding the power transmission components



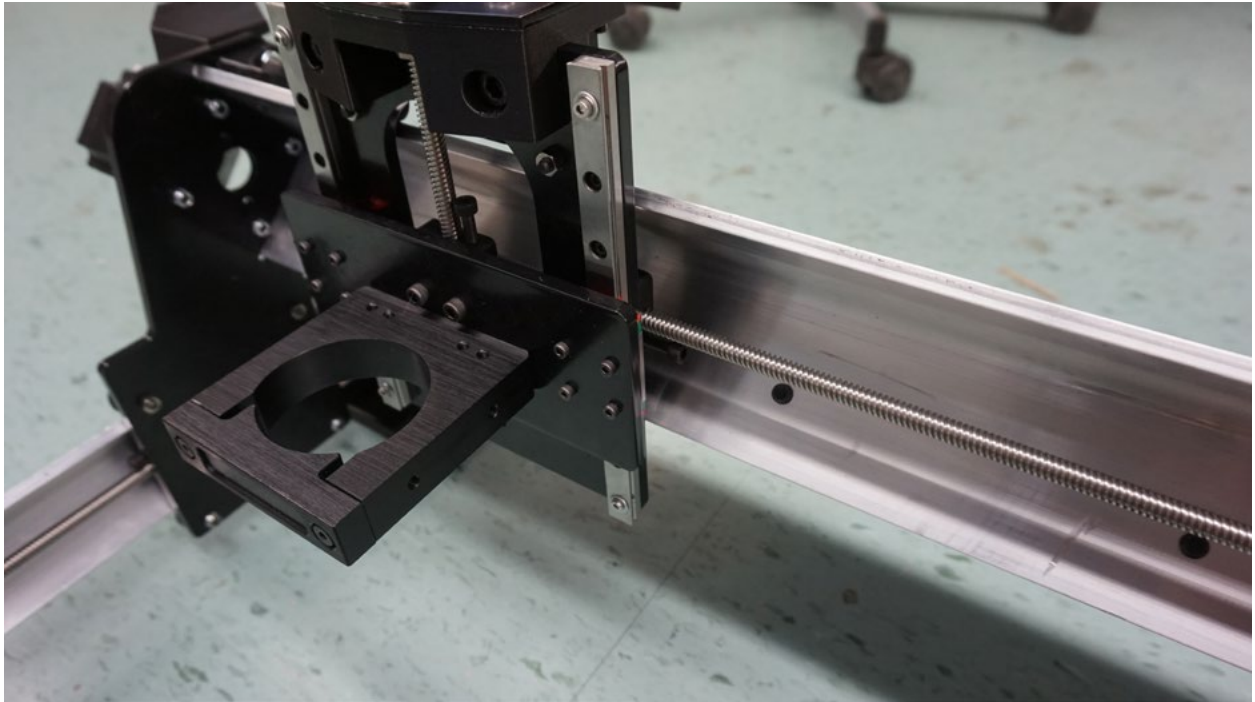
This step will attach the remaining components to the larger X-axis assembly. In the pictures, this step was done at a later time so the X-axis wasn't laying down on a flat surface, but yours should still be. Since we moved this step to be earlier, pay no mind to the other parts in the picture.

Start by grabbing the lead screws which you set aside much earlier in the assembly. Your LongMill comes with three lead screws, not accounting for the earlier one which was used for the Z-axis. For the 12×12 and 30×30 they're all the same length and for the 12×30 the longer one is for this X-axis assembly. Get your lead screw and run it through the large hole on the right-side Y-gantry, threading it through the plastic block of the anti-backlash assembly as well.



*Slide the lead screw through the hole on the right side*





*Turn the lead screw into the nut with your hand.*

Push the lead screw into the opposite bearing. Dont push it all the way into the coupler just yet.



*Push the lead screw into the bearing*

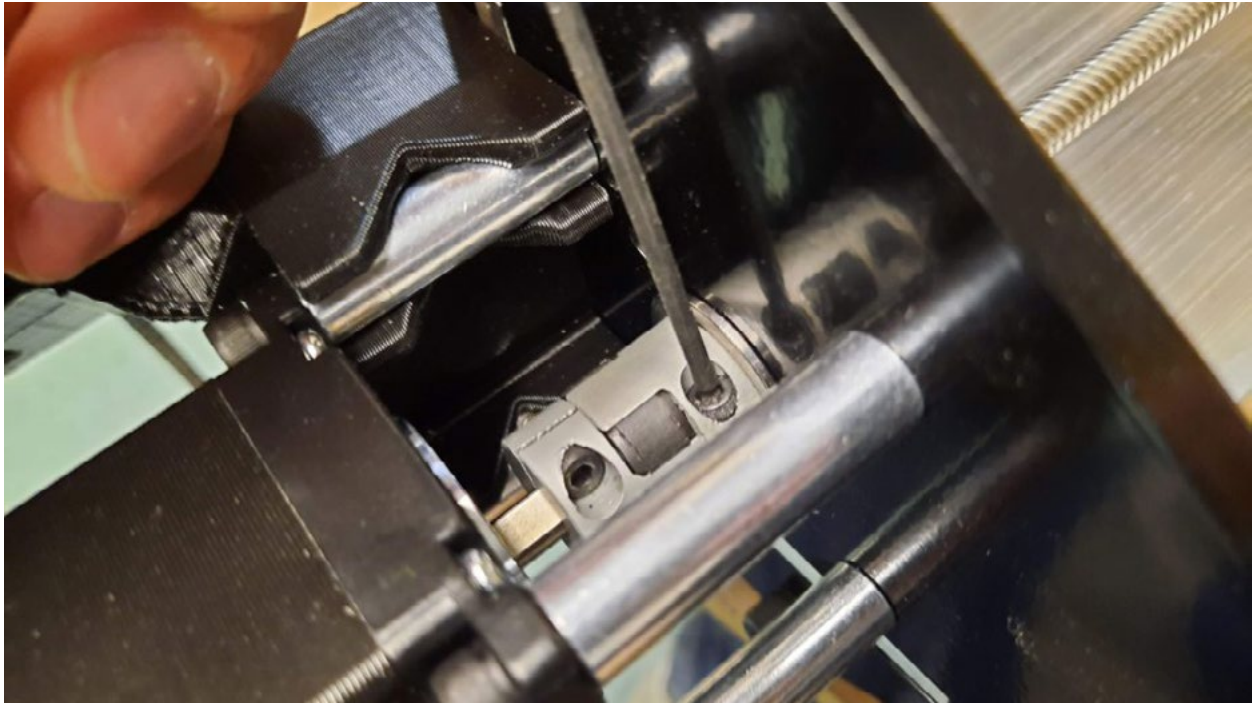


Line up the M8 washer between the coupler and the bearing, and slide the lead screw through all three.



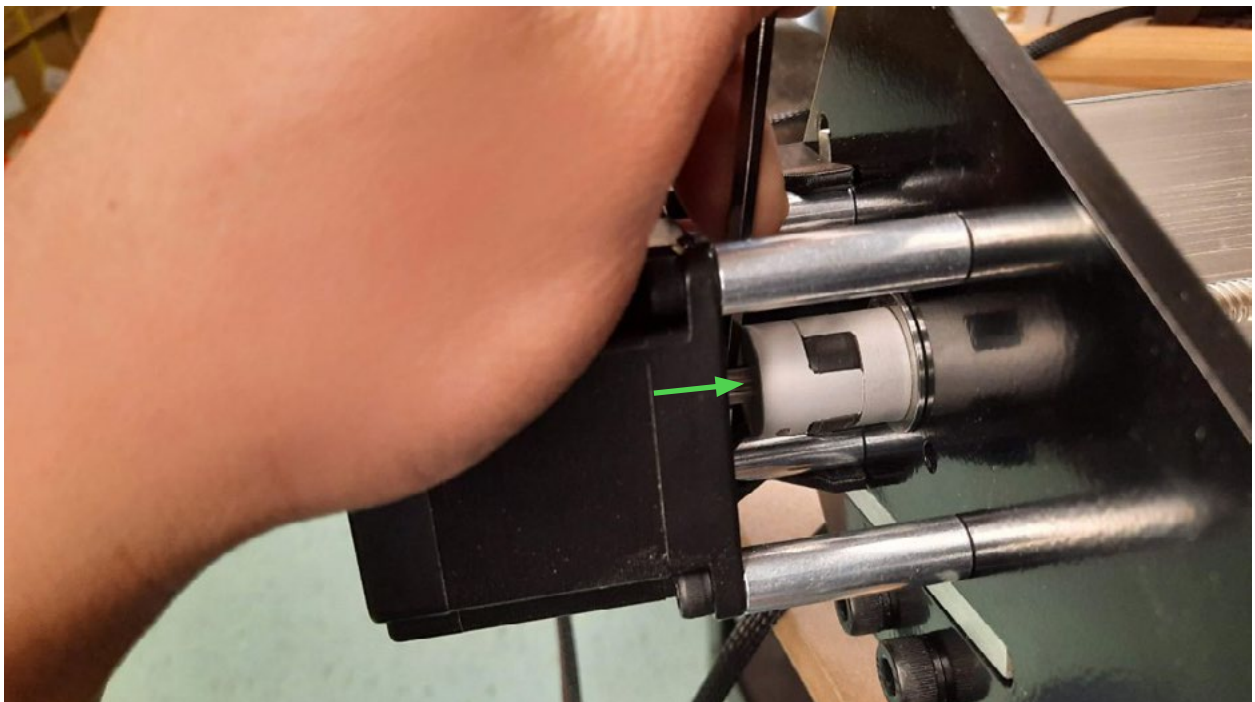
*Putting an M8 washer between the coupler and bearing.*

Tighten the coupler to fully secure the lead screw to the coupler.



*Fully seat and secure the lead screw.*

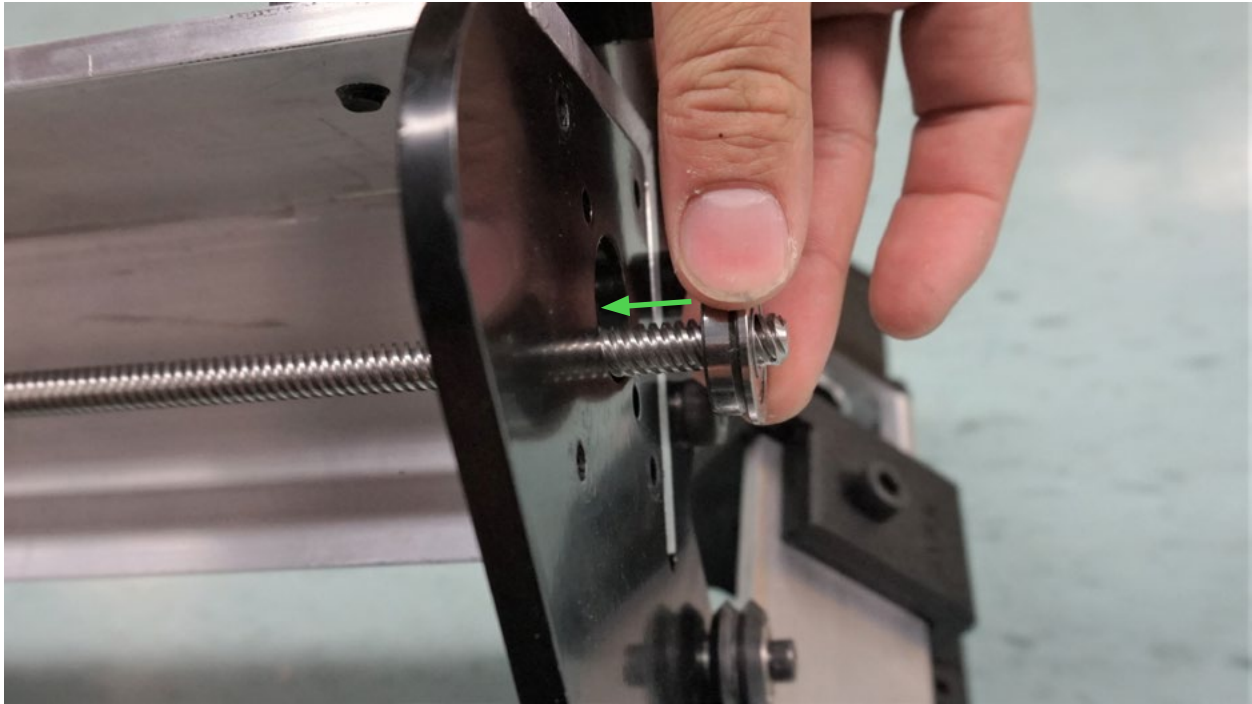
Loosen the screw securing the coupler on the motor so that you can push it into the flange bearing. Use an Allen key or other tool to push the face of the coupler into the bearing. This will ensure that there is no play left and right in the lead screw. Fully re-tighten the set screw on the motor shaft to hold everything in place.



*Push the coupler all the way into the bearing, and retighten screw*



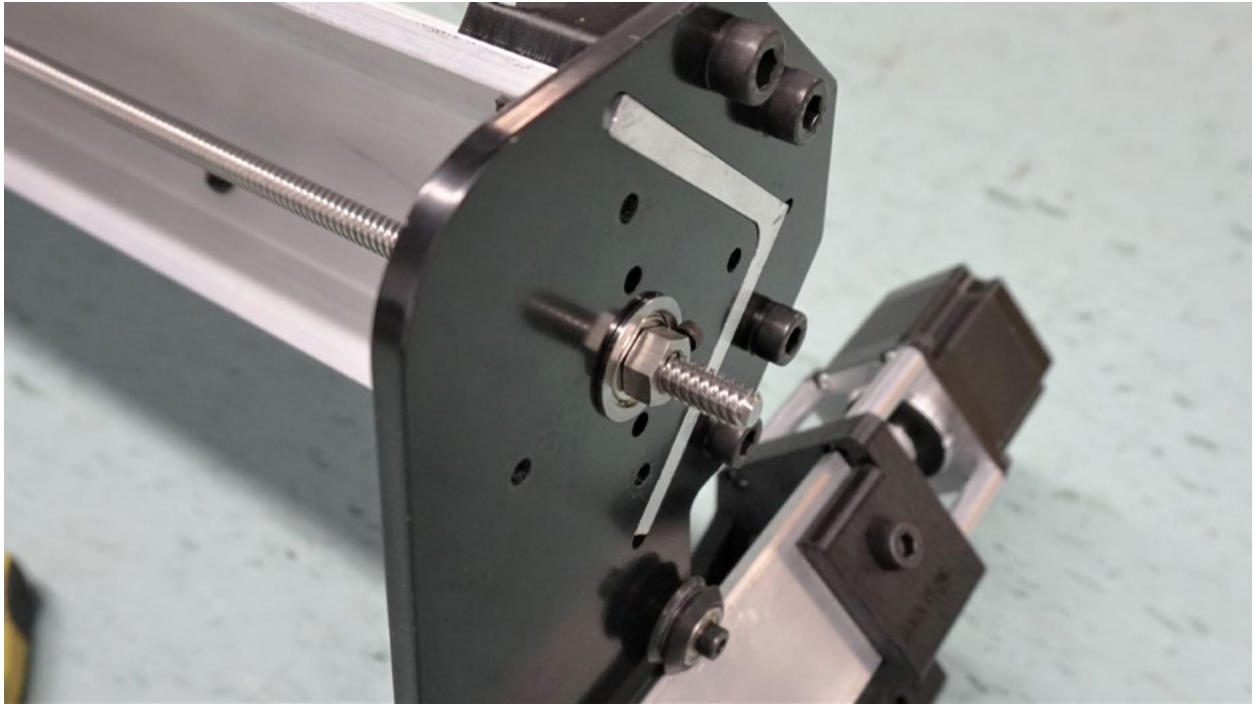
Now on the other side of the X-axis rail assembly, take a second flange bearing and slide it into place as shown. It should fit into the bore on the right-hand side of the right-side steel plate.



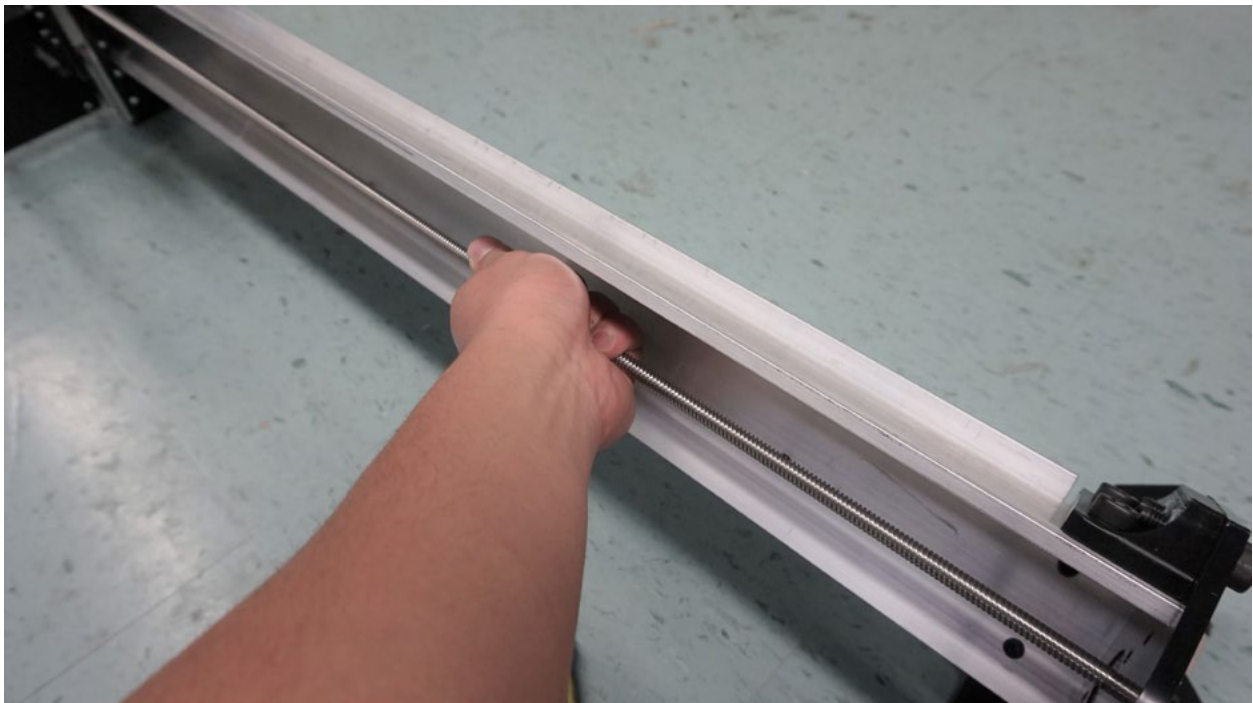
There should still be three ACME locking nut assemblies that you've previously assembled. Grab one of these and thread it onto the lead screw from the right, turning it all the way until it's against the bearing, then tighten the set screw to hold it in place. Make sure the nut is really tightened into place before tightening its set screw.



This nut is used in combination with the coupler at the other end of the assembly to constrain the lead screw on the X-axis from moving side-to-side. As such, it's a good idea to check that everything is secure by gently pulling on the lead screw to check for any looseness. Adjust the couplers and tighten the ACME lock nut more if you feel any play since you should be able to rotate the lead screw freely but not feel any side-to-side looseness.



*ACME lock nut on all the way*

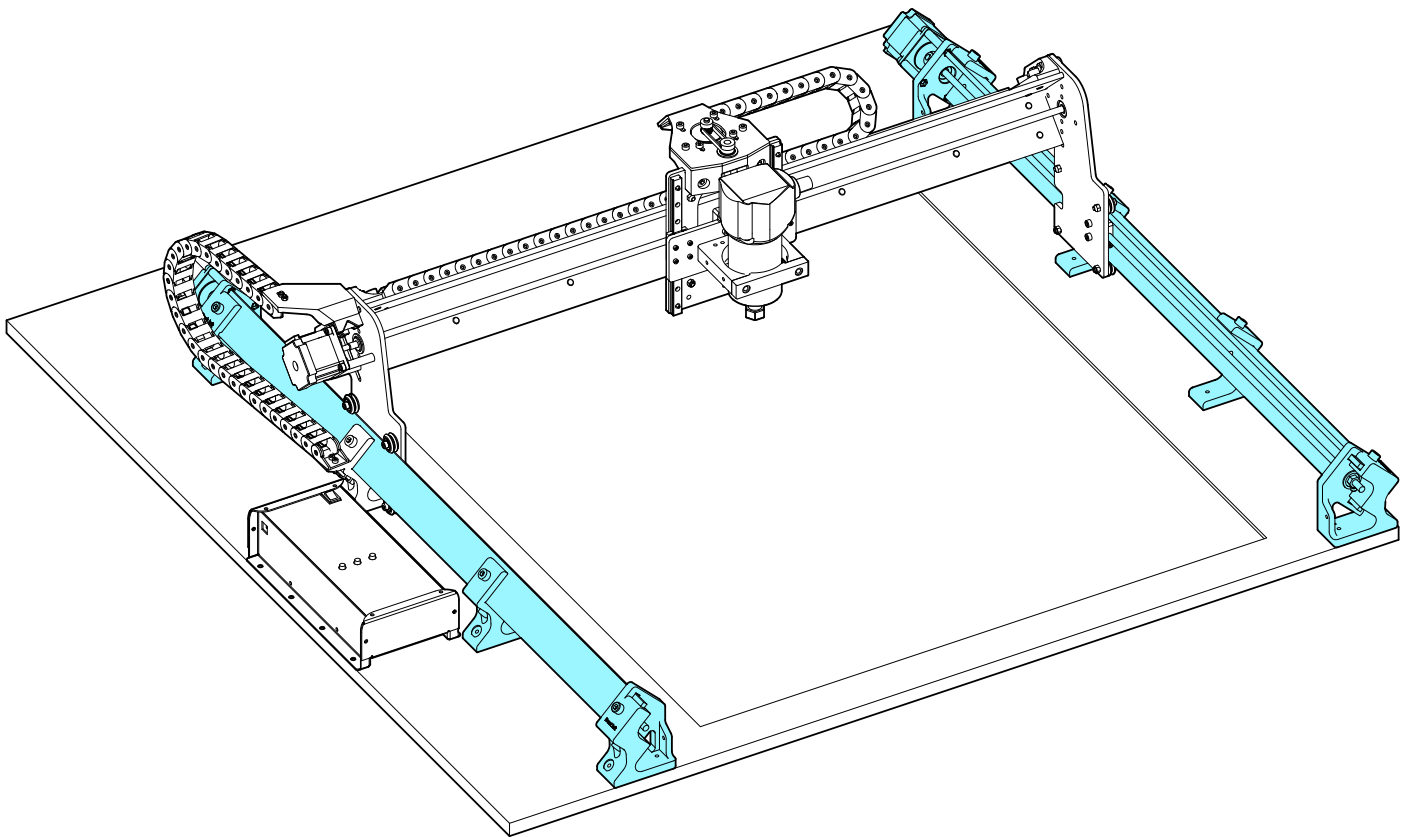


*Check for play by gently pulling on the lead screw both ways*



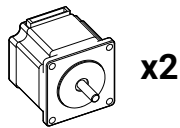
## Part 4

# Y-Axis Rails

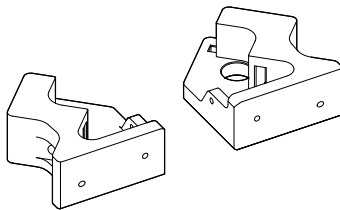


## Feet sub-assemblies

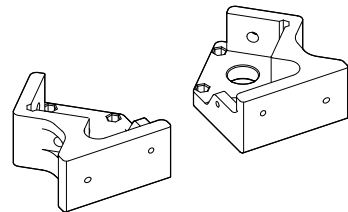
Parts Needed:



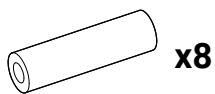
NEMA 23 motor



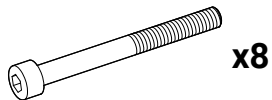
3D printed front feet



3D printed back feet



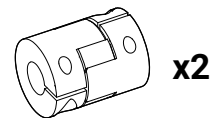
35mm aluminum  
spacer



M5-50mm bolt



M5-nylock nut



6.35mm to 8mm  
coupler



608ZZ flange  
bearing

The two Y-axis rails mount to the machine base via a handful of plastic feet which require a bit of assembly before-hand. Start off by finding the front and back pairs among the plastic parts (pictured). These parts can be distinguished by their 'zig-zag-like' pattern with a thick base and by the embossed lettering denoting their position on the machine (e.g. "Back left" and "Back right").

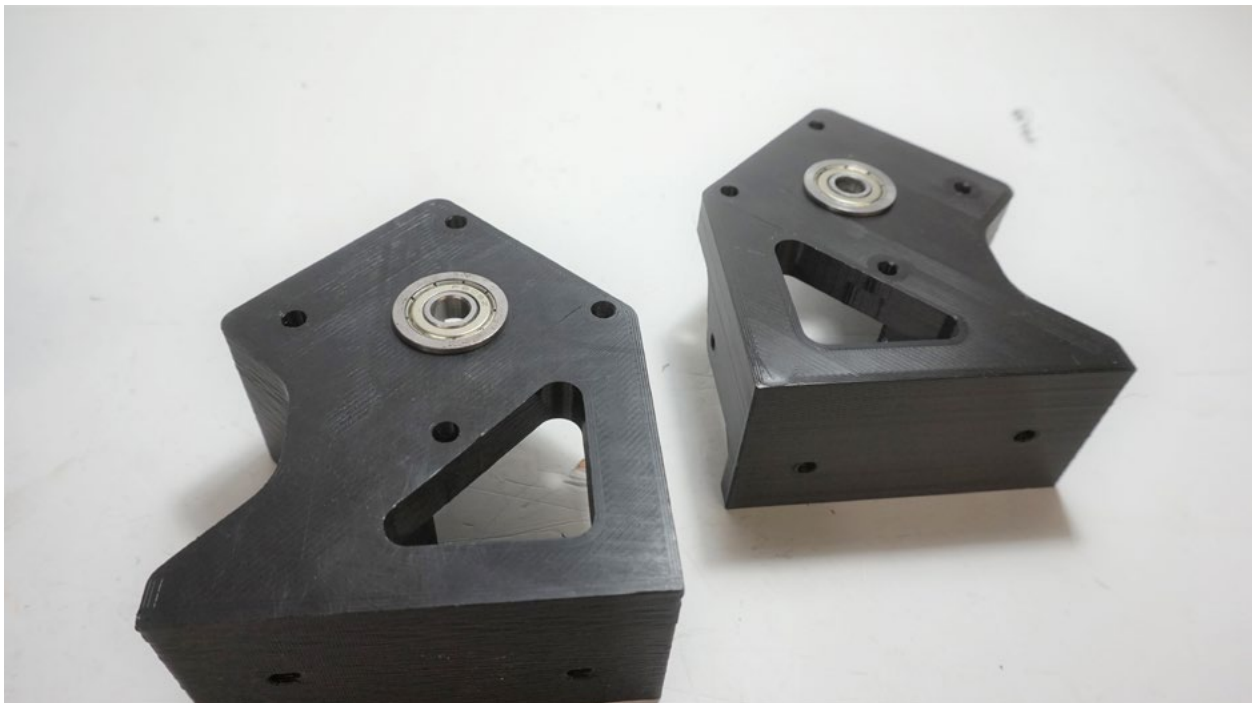


With the bearings still in hand from the last step, you'll need to push one of them into each of the four feet. The front feet should have the bearings pushed in from the front, and the rear feet from the rear (pictured); make sure that you get the orientation right on these.

These bearings are meant to be quite a snug fit, so feel free to use a vise or a mallet against the outer flange of the bearing to get them properly seated into the feet. You'll know they're in all the way once the flange is completely flush with the surface.

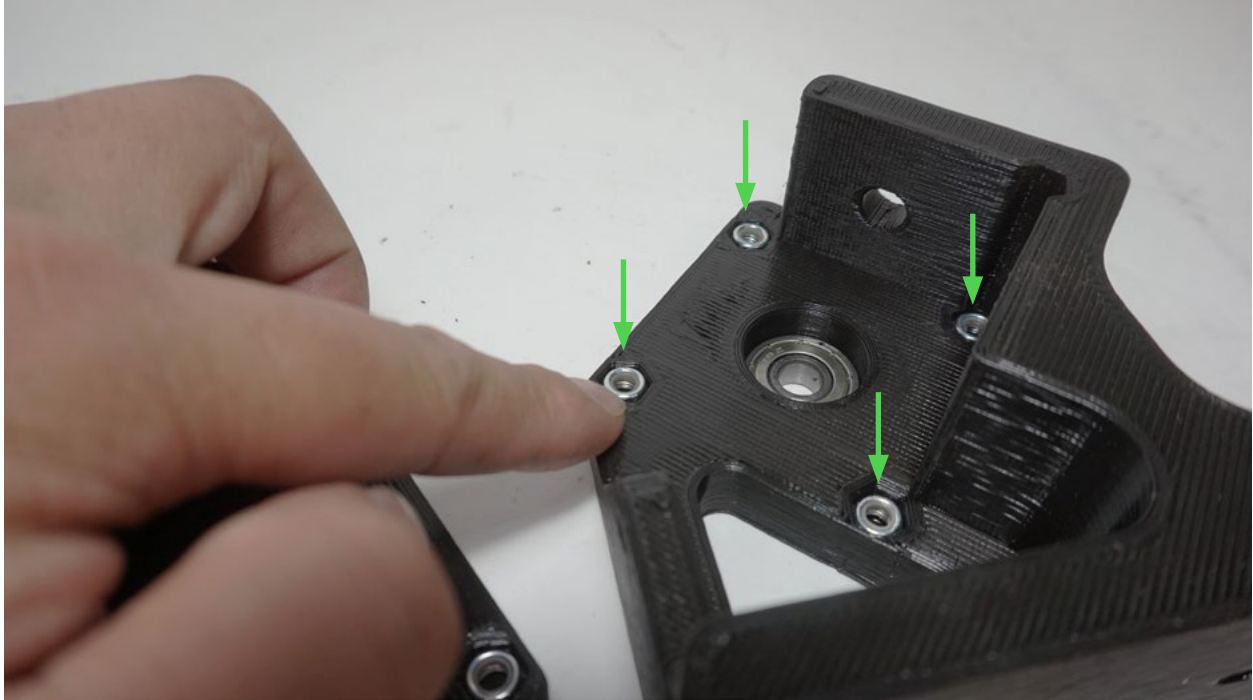


*Front feet with bearings*



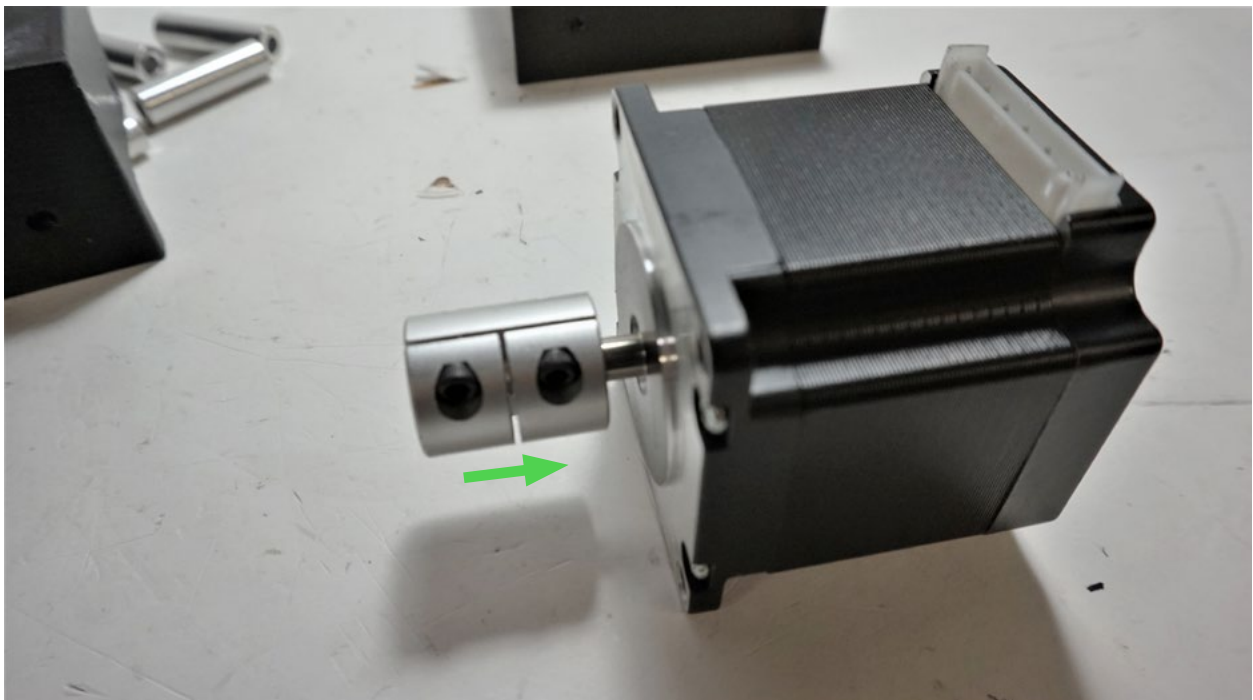
*Rear feet with bearings*

For the rear feet, we'll also press-fit in eight M5 nylock nuts with the rounded side facing outwards. You should already have the bag of these medium-sized nuts open from earlier in the assembly.



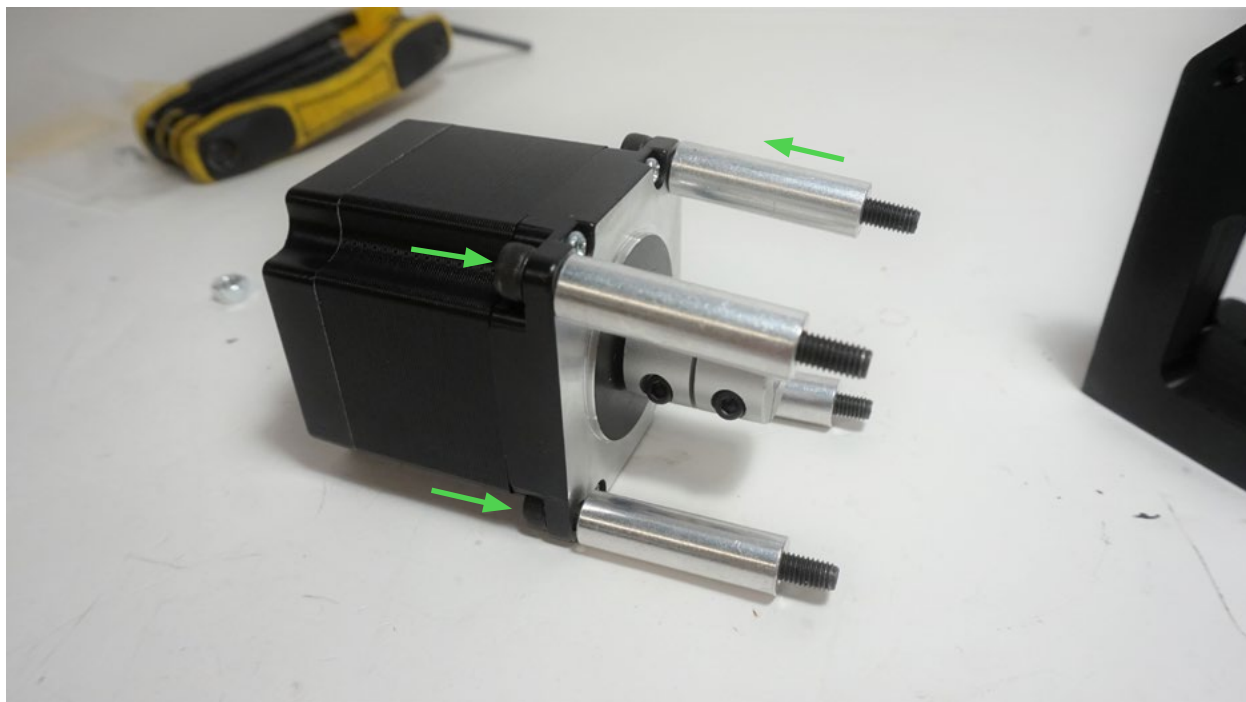
*Put M5 nylock nuts into each nut catch on the rear feet*

Now, we'll attach the two remaining motors to the rear feet. Install the coupler onto the motor first, followed by the long bolts and spacers that were used for the X-axis motor assembly.



*Loosely push the coupler over the motor shaft*





*Install the bolts and spacers*

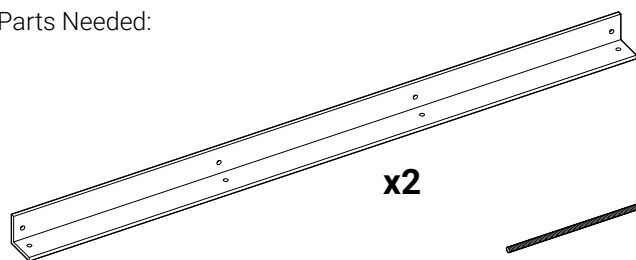
Move this over to the back of one of the rear plastic feet, orienting the motors white connector towards the flat base of the foot (pictured). Using a size 4 Allen key, you'll be able to bolt the motor in place. Repeat the process for the other foot.



*Both feet with motors attached*

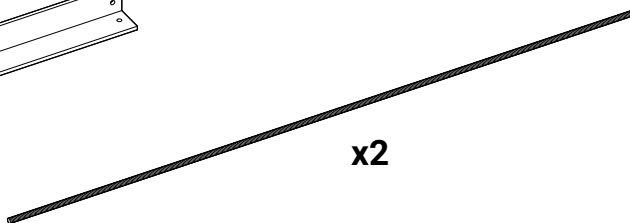
## Completing the Y-axis

Parts Needed:



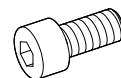
**x2**

Y-axis rails  
(500mm or 1000mm)



**x2**

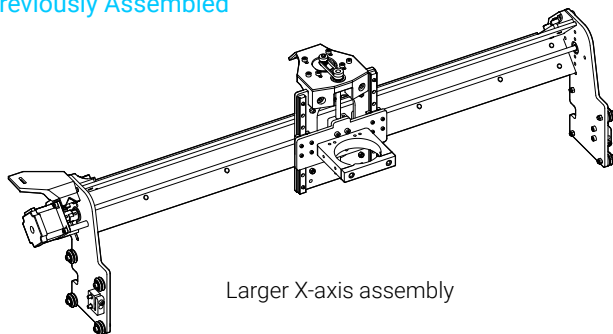
Lead screws  
(530mm or 1030mm)



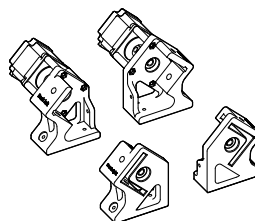
**x8**

M8- 16mm bolt

Previously Assembled



Larger X-axis assembly



Front and back feet  
assemblies



**x2**

ACME locking nut  
assembly

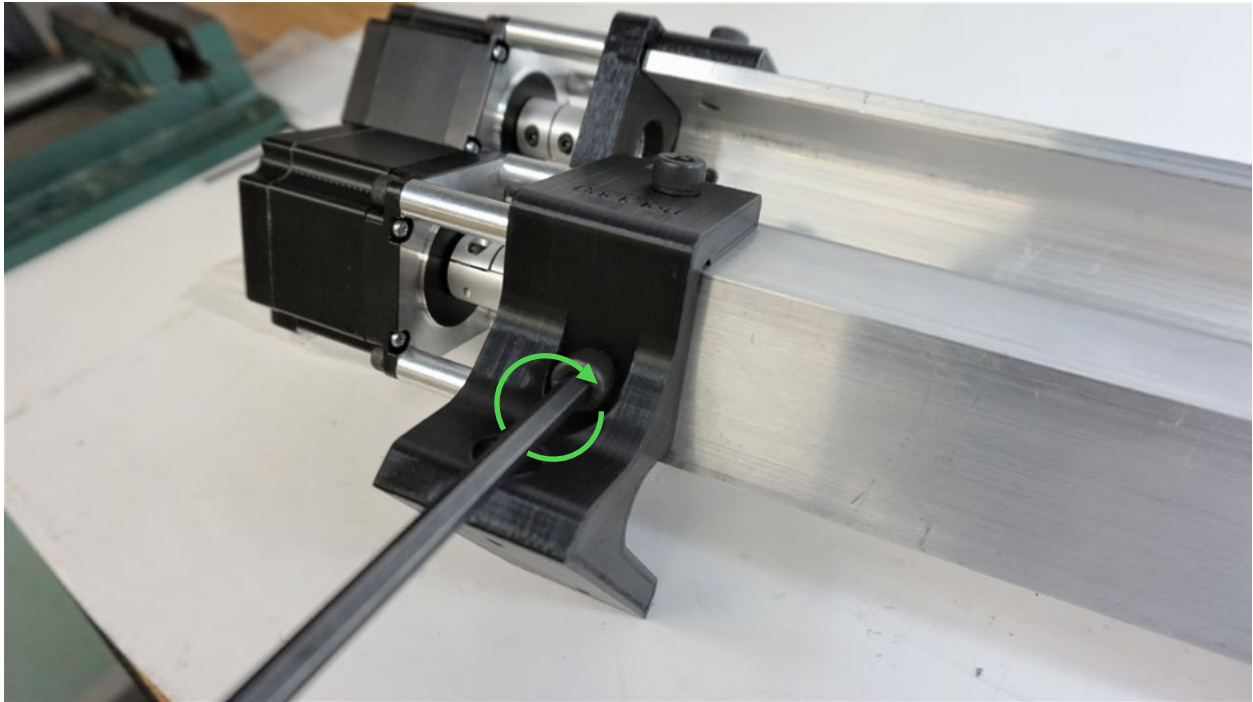
The 30×30 LongMill comes with 1000mm long rails for the Y-axis, meanwhile the 12×12 and 12×30 models have 500mm long rails. These will be the last two remaining aluminum lengths in the kit, distinguishable by their 2" width compared to the 3" width of the X-axis rail.

We will be doing the assembly for the 30×30 here, but the assembly for all three versions is very similar. Start by grabbing the two Y-axis rails, the feet assemblies from the last step, and the bag of the largest, short bolts.



*Note that your rails will be shorter if you don't have the 30×30 LongMill*

Secure the rear left and right feet assemblies (pictured) to one end of each rail. These can be secured using two of the short M8 bolts per foot assembly using a size 6 Allen key; the rails should be a mirror of each other.

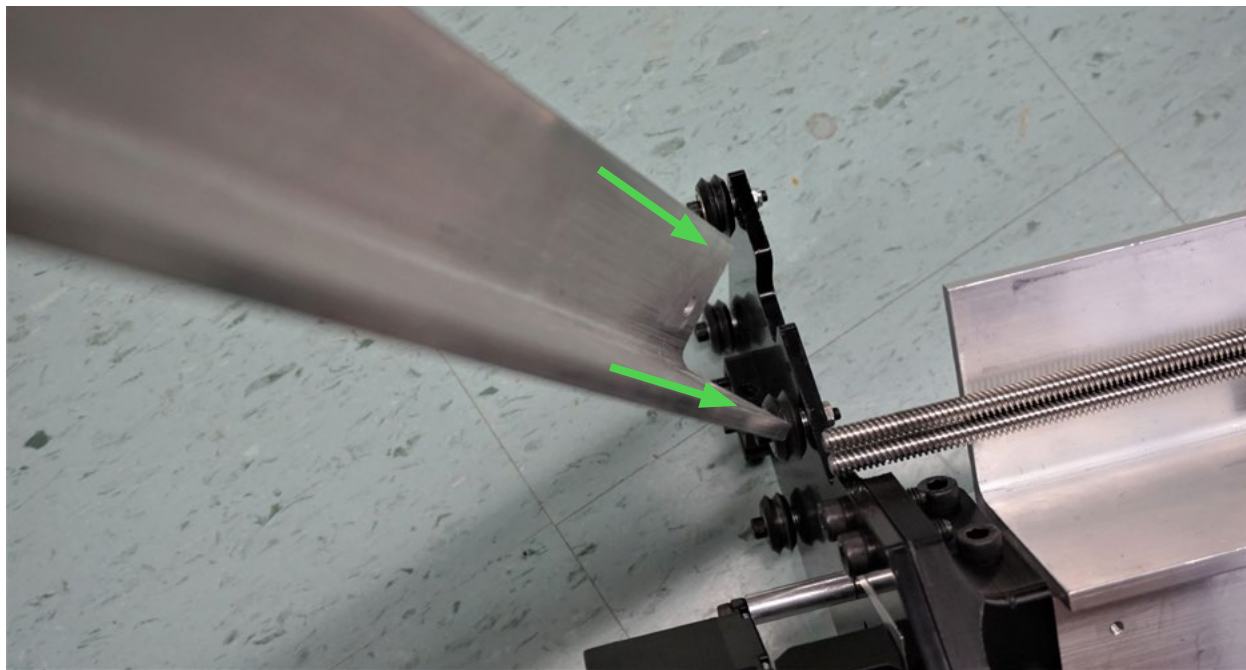


These rails need to now slide onto the larger X-axis rail assembly that you have set aside. To prepare for this, flip the X-axis assembly onto its front so that the router mount is contacting the ground; be sure that it's stable in this position.

You should also check the current state of the eccentric nuts on both Y-gantries. Just like when you checked them on the XZ-axis gantry, they should be in their outer-most position so that there's enough space between the wheels for the rail to fit.



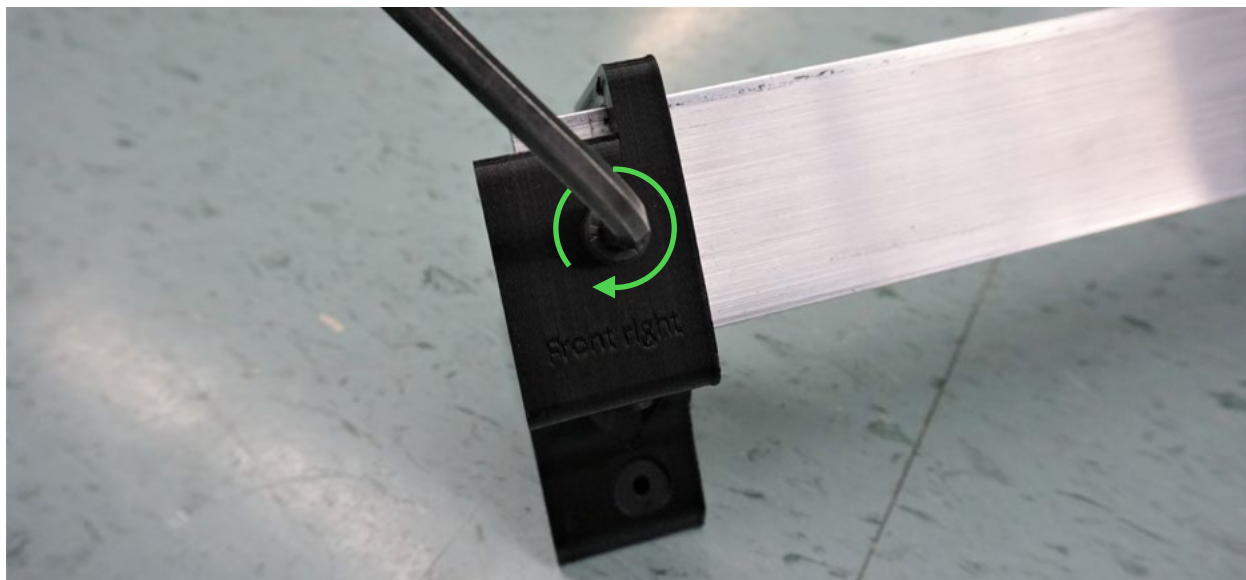
Now slide one rail onto the wheels of each of the Y-gantries from the back (pictured). Make sure that the flat side of the feet is pointing away from you so that, when completed, the machine is able to sit on the bottoms of the feet.



*Line up the inner profile of both sets of v-wheels to the edges of the rails in order to slide them into place*

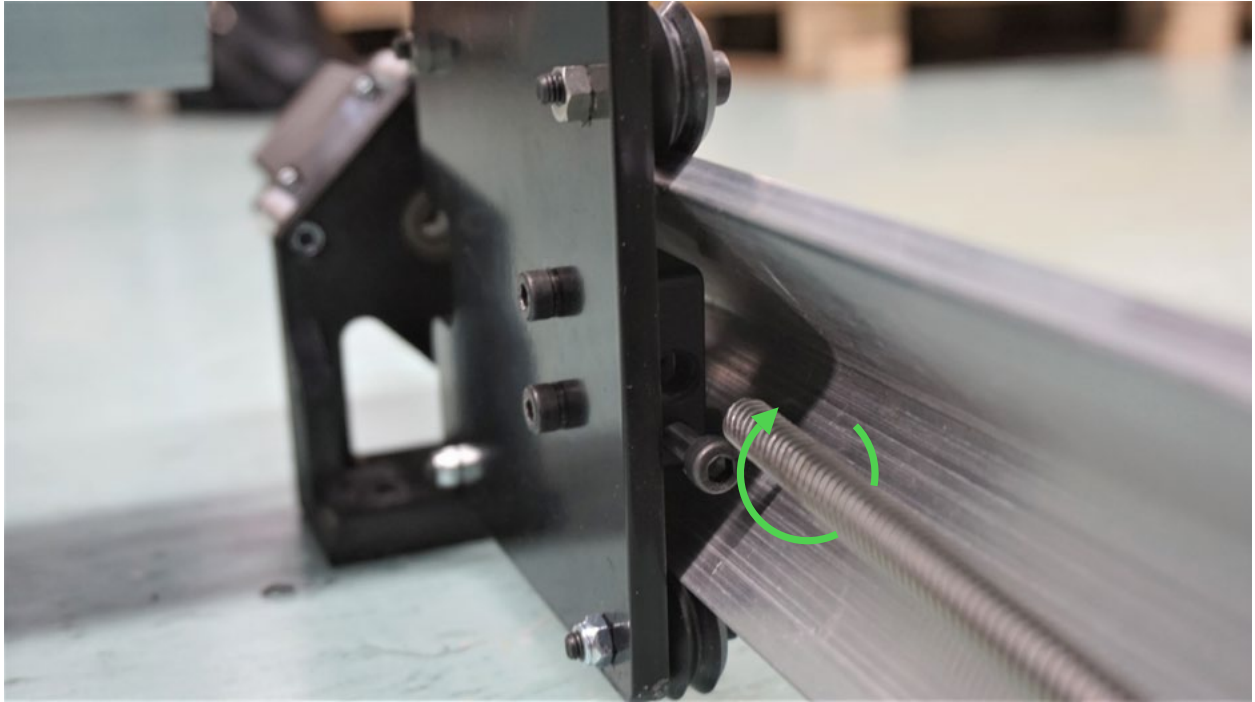
Leave this sitting for a second while you collect the two front feet assemblies and four more of the short, large bolts in preparation for this next step. You'll have to make a combined motion where you tilt the X-axis rail assembly backwards while you finish sliding the Y-axis rails all the way on. **Be very careful while doing this.** It's possible to lose control of the heavy components and have them fall away from you and become damaged.

Once you've slid the rails all the way on to the X-axis rail assembly, use the two front foot assemblies we collected earlier. Sliding them into place and mounting them to the front of each rail on their respective sides with two bolts each and a size 6 Allen key will help to keep the large assembly more stable.



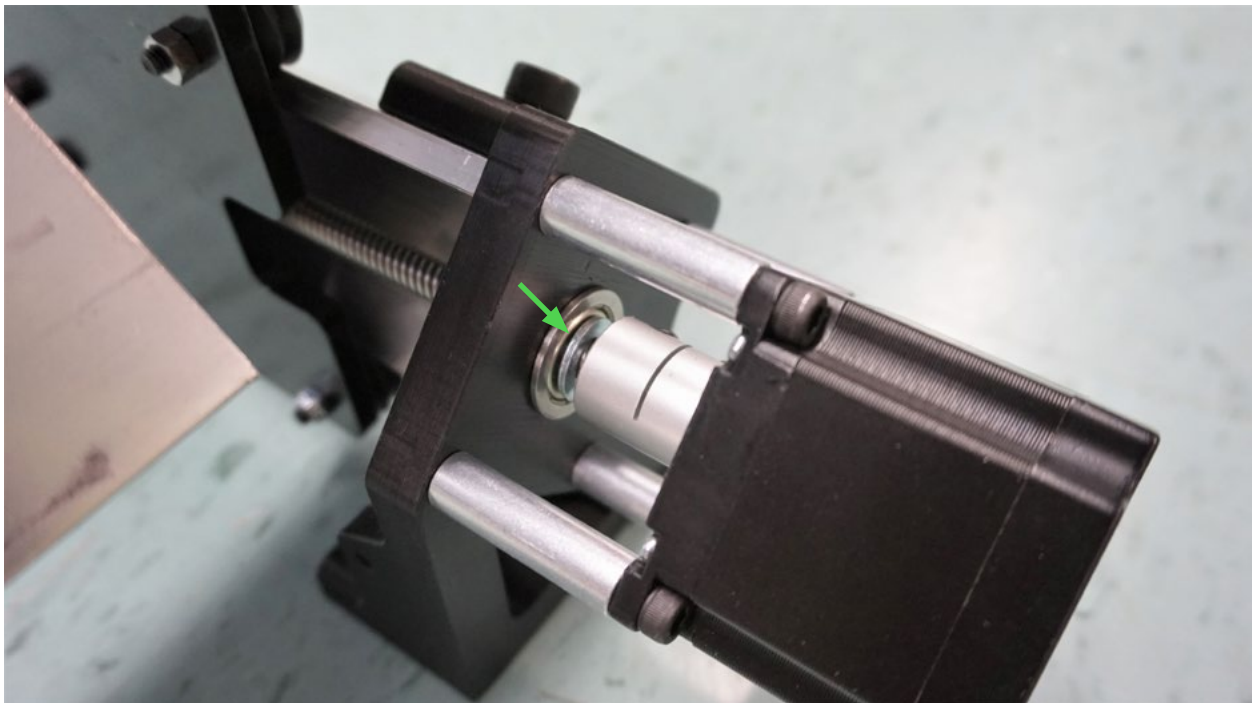


Next, thread the lead screws into place. It will go through the bearing on the front foot, threaded through the nut block on the Y-gantry, and through the bearing on the back foot. If you move the gantry to the back of the machine when doing this (pictured) it'll require less time to thread it through.

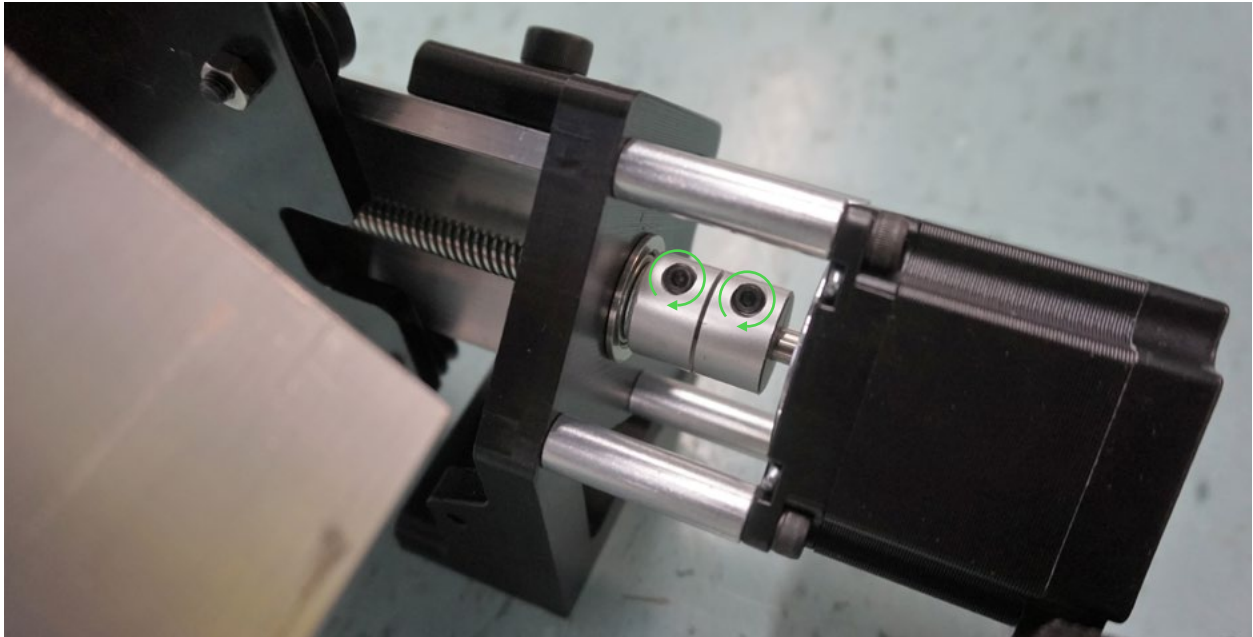


*Thread the lead screw into the nut.*

Just like for the X-axis assembly, put a washer between the coupler and the bearing on the motor-side of the back feet.



Tighten everything down by pushing the lead screw all the way towards the motor shaft while pushing the coupler all the way towards the bearing, then tightening down the two set screws on the coupler to clamp down onto both sides. Ensuring that the face of the coupler/washer is flush against the bearing is important to prevent any play in the lead screw. Do this on both sides.



*Everything tightened down*

Back at the front of the machine, the last two of the ACME locking nut assemblies are going to be used to constrain the lead screws on the Y-axis. These share the same purpose with the locking nuts on the X and Z-axes, where the combination of the nut on one side and the coupler on the other side keeps the lead screws from moving side-to-side; so it's a good idea to check that everything is secure by gently pushing and pulling on the lead screw to check for any looseness. Do this on both sides. Adjust the couplers and tighten the ACME lock nut more if you feel any play, since you should be able to rotate the lead screw freely but not feel any side-to-side looseness.

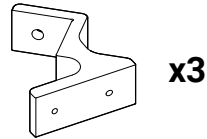


*Thread on the ACME lock nut, making sure it's tight against the bearing before tightening the screw to secure*

## Attaching the middle feet

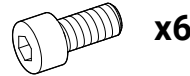
If you have a **12x12** or **12x30** LongMill, there will only be one foot to attach to the right rail, which will only require 2 of the M8 bolts to attach it

Parts Needed:



**x3**

3D printed middle foot

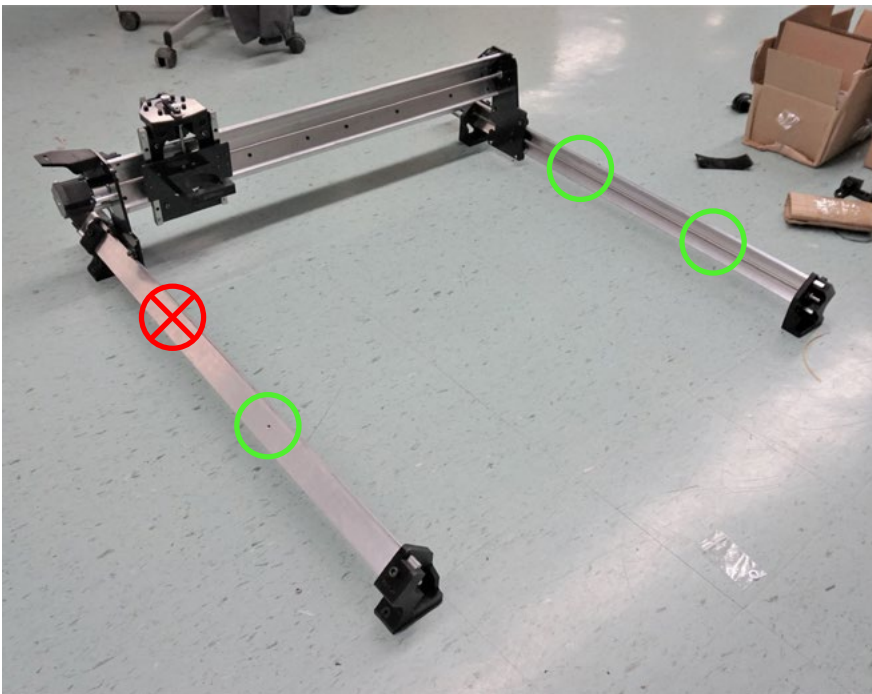


**x6**

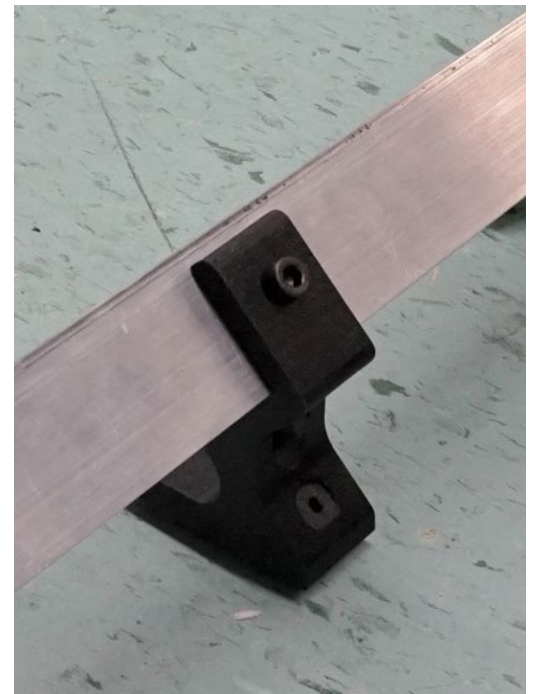
M8- 16mm bolt

The last pieces to add are the middle feet. They look exactly like the back feet but exclude the backing. There are three of them and a fourth one that looks very similar but has another mounting point that juts out; this one will be used later in the assembly.

Attach the middle feet in the positions indicated in the below picture. Just like the other feet, they can be attached using two of the short M8 bolts and a size 6 Allen key. It's best to twist the bolts into place by hand first, then finish tightening them snug with the Allen key.



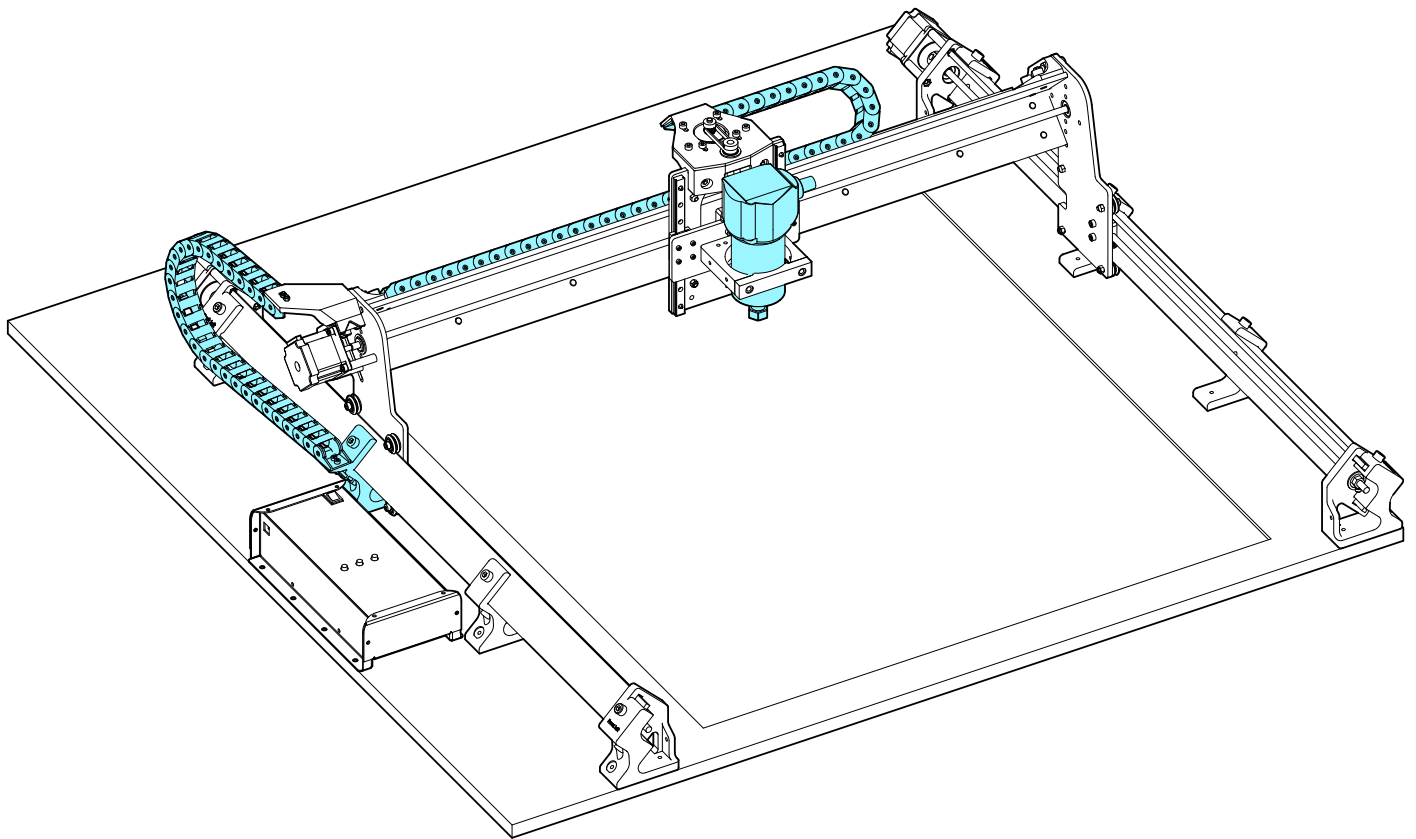
*Mount the middle feet in the spots indicated*



*Single middle foot on right rail  
(LongMill 12x12 and 12x30)*

## Part 5

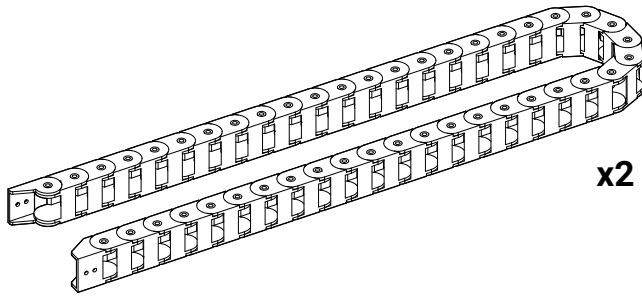
# Drag Chains and Wiring



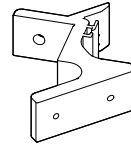


# Drag Chains and Wiring

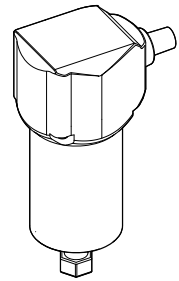
Parts Needed:



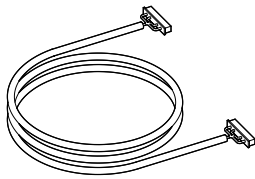
1000mm drag chains



3D printed drag chain foot

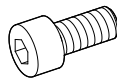


Router



**x4**

Motor wires



**x2**

M8-16mm bolt



**x6**

M4-16mm bolt

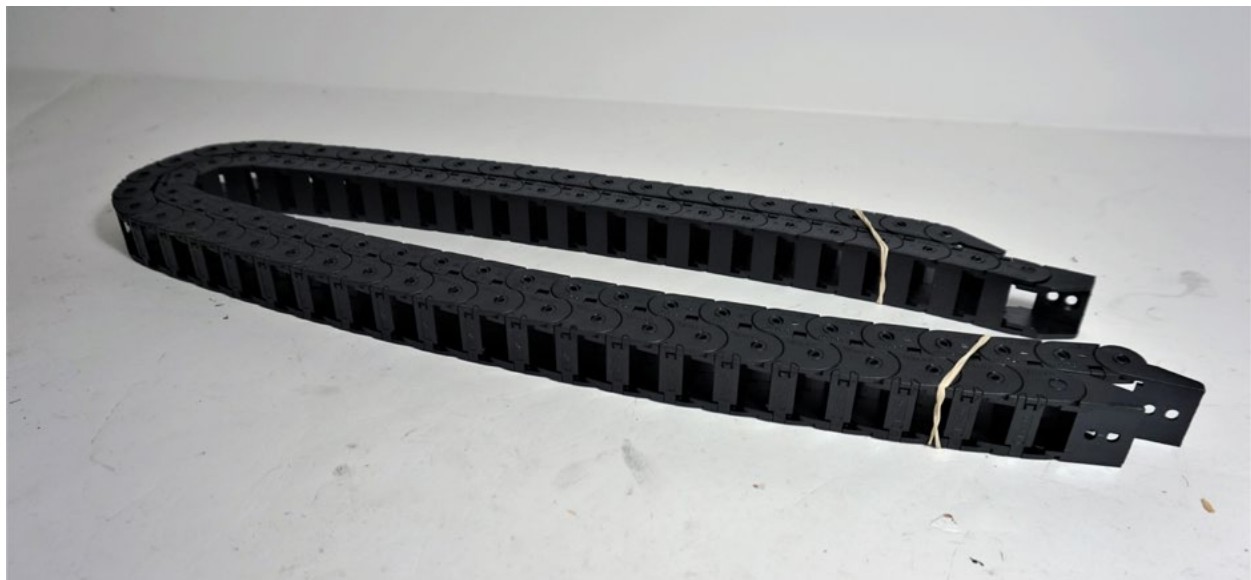


**x6**

M4 nylock nut

We will now be installing the drag chains; these contain and guide the wires on the LongMill so that they aren't in the way during cutting. They also keep wires from wearing out from bending or being cinched around corners.

As mentioned previously, the chains can be found in the lighter long box (pictured). They come with detachable links so that you can adjust their length depending on the size of your LongMill. You can save these links for later when you upgrade to a larger LongMill if you have the 12×12 or 12×30 versions.



We'll first start by removing the end connector links from both drag chains. You can either pull or squeeze off the connector as shown in the photos. A flat head screwdriver or thin shim can also be handy for this, just be careful not to cut yourself in the process.



*For the pin-type end link, squeeze the two sides of the link together, then twist and pull to disconnect*



*For the hole-type end link, pull on one side of the link then twist it away to separate it*

Do this for all four end pieces, two hole-types and two pin types, and set them aside.



We will attach these links to the machine, starting with the drag chain foot you set aside in the last step. It can be identified by its lightning bolt shape and the nut catches and wire clips it has on its back side. Also locate the small bag containing smaller bolts and nuts, as these will be used to attach the links in the following steps.

Use a pair of bolts and nuts to secure the hole-type end link onto the drag chain foot in the orientation shown by using a size 3 Allen key. The nuts should fit into the hexagonal cutouts underneath the mounting point, meaning a wrench won't be needed.





This last foot can now be attached to the Y-axis rails in the vacant space on the left side of the machine. Use two of the short M8 bolts to fasten it to the rail, similar to how all the other feet have been mounted.



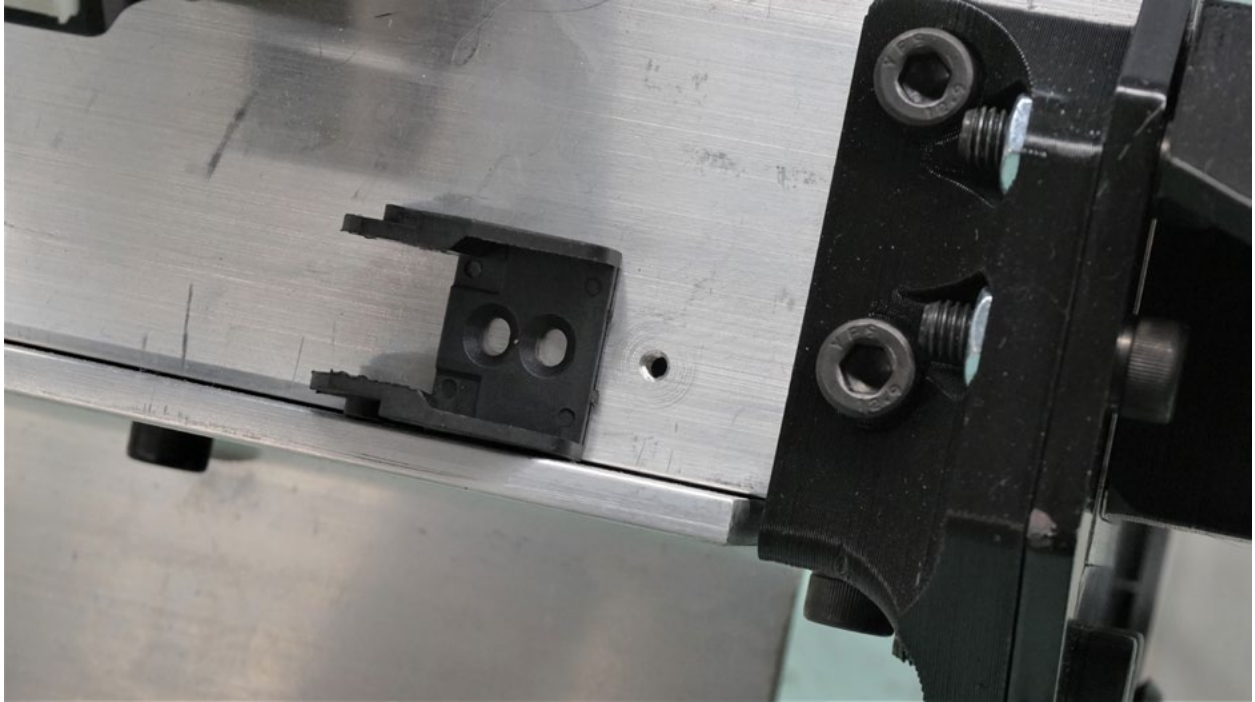
*Drag chain foot mounted in place*

Now get a **pin-type** end link (pictured) to mount the other end of the drag chain. This one will attach the the X-axis clip-on mount where there's a slot for the two bolts to fit through. Use pliers or a 7mm wrench to hold the nuts from the top while you fasten the bolts from underneath with a size 3 Allen key.

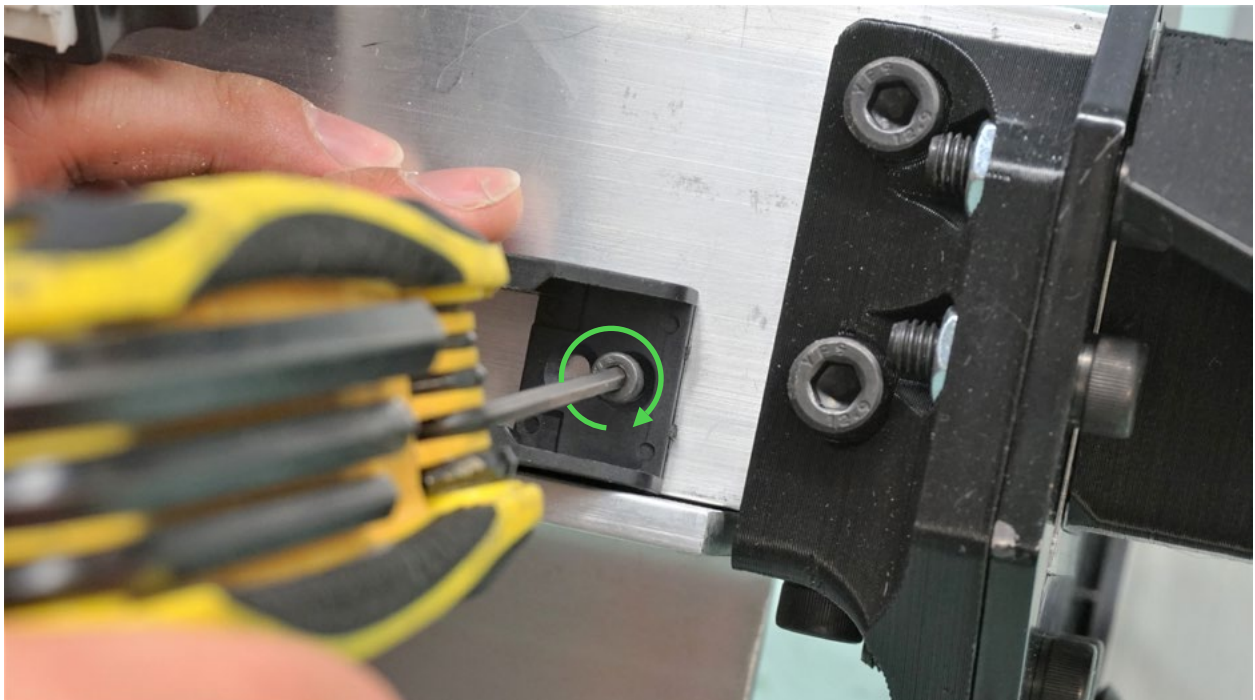




On the back-left side of the X-axis rail, you'll find a hole to secure another drag chain link. You should only need one bolt to secure the pin-type end link using the tapped hole, but if your hole is not tapped, use an M4 nylock nut on the other side to secure the part.

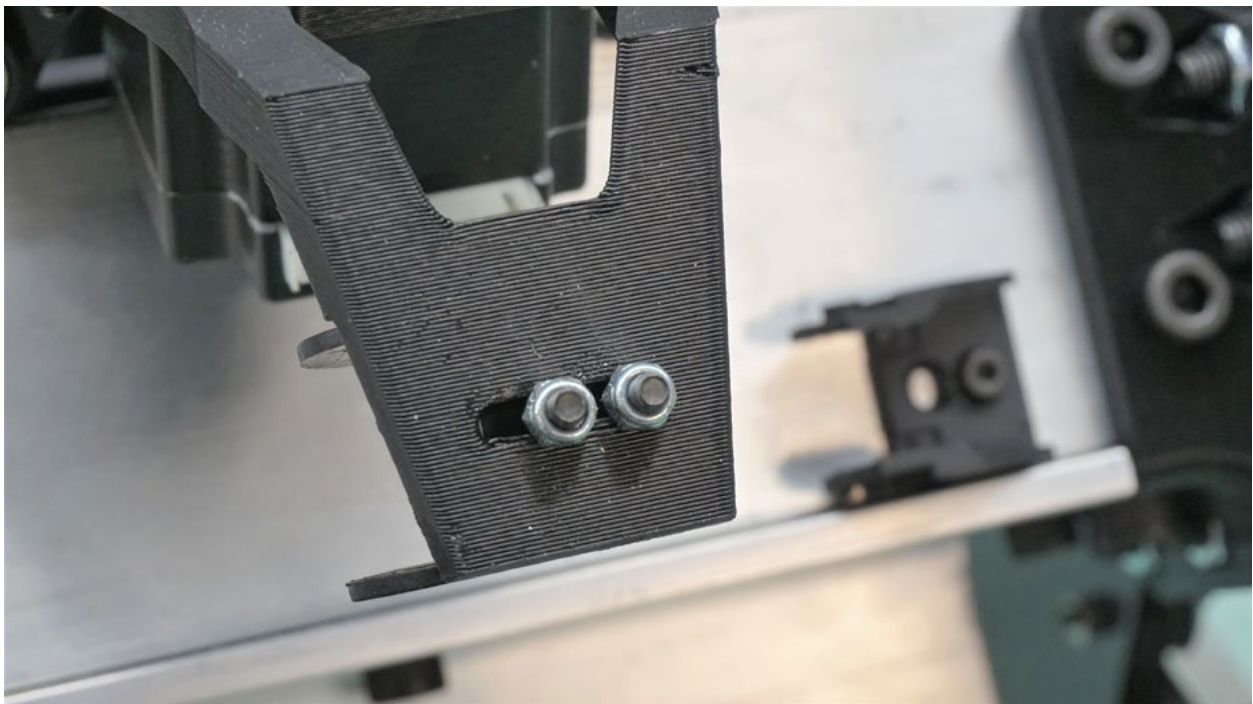
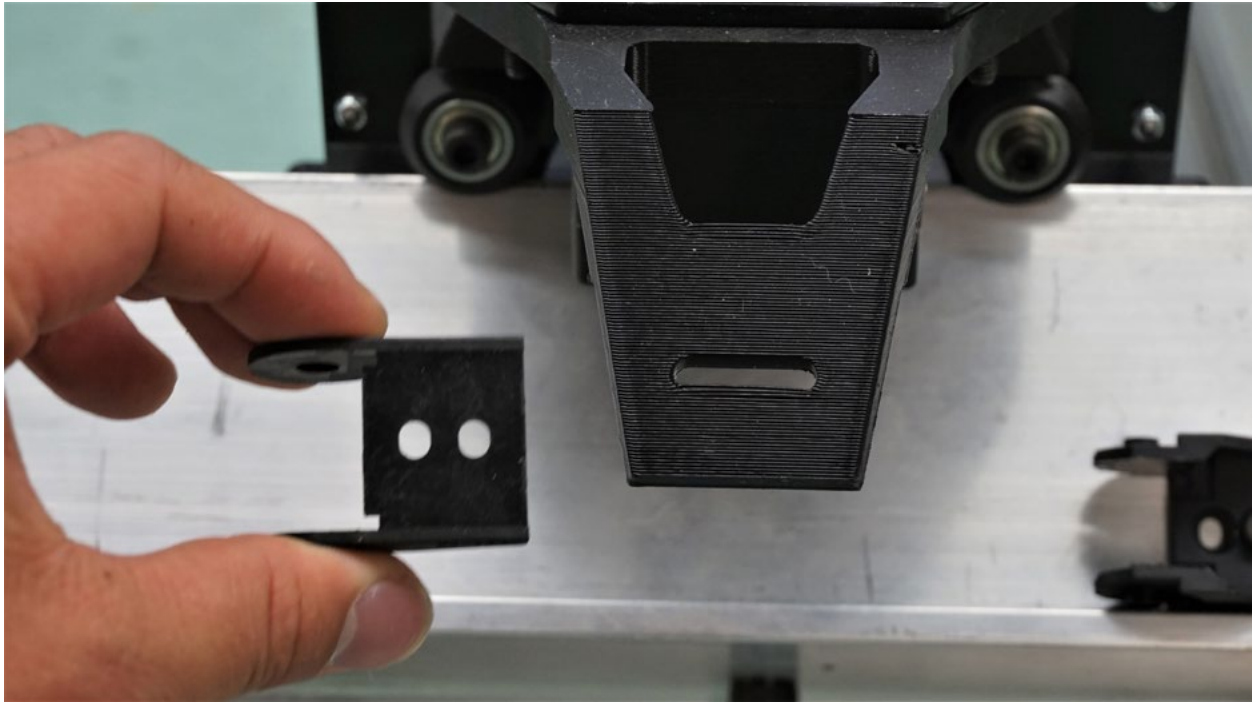


*Find the hole on the X-axis rail to secure the drag chain link*



*Use an M4 nylock nut on the other side of the aluminum angle if needed*

Lastly, we'll attach the final drag chain end link onto the plastic 'arm' of the Z-axis mount using another pair of M4 bolts and nuts. Note the direction the link is facing before installing it.



*Link fastened into place*

Next, we'll be removing a couple of links on the drag chain. To do this, put your hands on either side of the link you want to break, then twist and pull them apart to disconnect. Set aside the remaining, unused links for later; they can come in use if you're planning on upgrading to a larger sized LongMill later.

In the case of a **30×30** machine, we will remove 15 links off of the Y-axis drag chain, and none off of the X-axis drag chain. This will make it the correct length to mount at both ends when re-attached. Make sure to keep track of which chain is the shorter one so that you can re-attach them onto the correct axes.

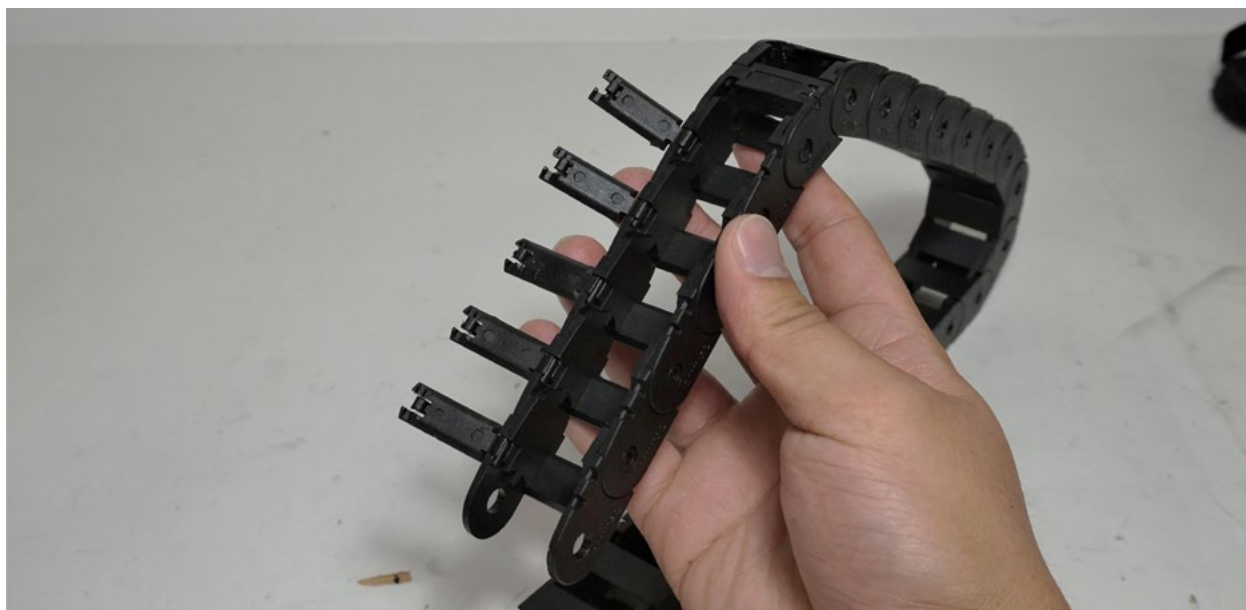
On the **12×30** LongMill, only the Y-axis drag chain needs to be shortened to about 24 links long. This is a little over half the length of the existing drag chain so it's easiest to just fold it in half and add a couple links onto the halfway point.

On the **12×12** LongMill, both chains need to be shortened to about 24 links long. This is a little over half the length of the existing drag chains so it's easiest to just fold it in half and add a couple links onto the halfway point.



*Use both hands to twist and disconnect the drag chain links.*

We'll then start to unclip the tabs that hold the wires in the drag chain (pictured). These tabs are designed with clips on both side so that they can be removed to allow you to insert and remove wiring inside the drag chain. The clips on the tabs are quite strong, so sliding a flat head screwdriver or a long Allen key into the drag chain and using them as leverage to pop the tabs open works quite well.



*Unclip the tabs on the drag chain*



One quick note, if you plan on adding more wiring into the drag chains in the future, it's worthwhile to permanently remove every other cover tab since the wire will still be held in just as well but opening and closing them will take half the time. You can stick the extras into a baggy to save for later if you wish.



*All of the tabs unclipped and ready for wiring*

At this stage, it's a good idea to grab the router you'll be using with your machine. We'll show these steps using the Makita RT0700 / RT0701 trim router that we recommend. Also, grab the paper-wrapped motor wires while you're at it.



*Get your router and motor wires to start wiring the machine*



To mount your router, simply loosen off the two front bolts until you can fit the router in the mount, then tighten back up again to secure it. You can adjust the height later if needed.

We recommend going back and forth between the two bolts to keep them parallel; and make sure not to over-tighten them. If you do over-tighten these bolts and start to strip the bolt head, these bolts can be substituted with the M5 bolts that came with your machine if you have any extras. It's also best to face your router power cable towards the right side (pictured) since the dust shoe hose port sticks up on the left side of the router mount.

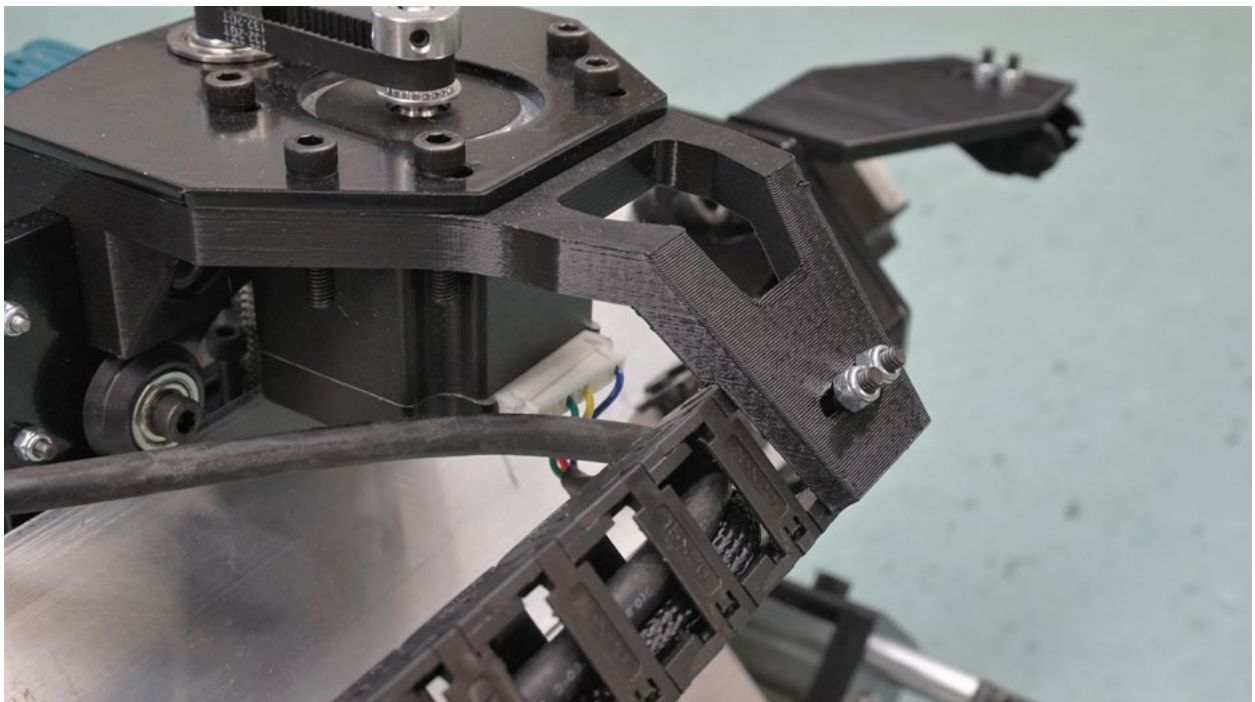
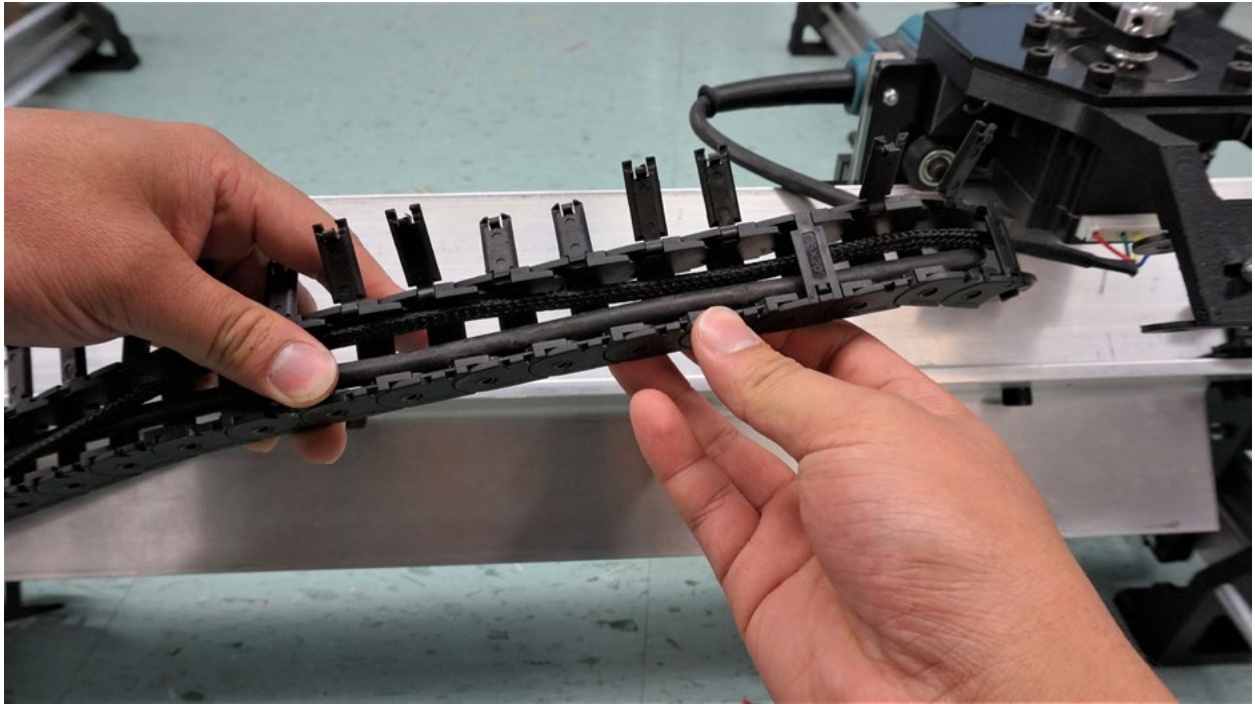


*Mount your router with the power cable facing right*

Grab a motor cable and connect it to the Z-axis NEMA 23 motor.



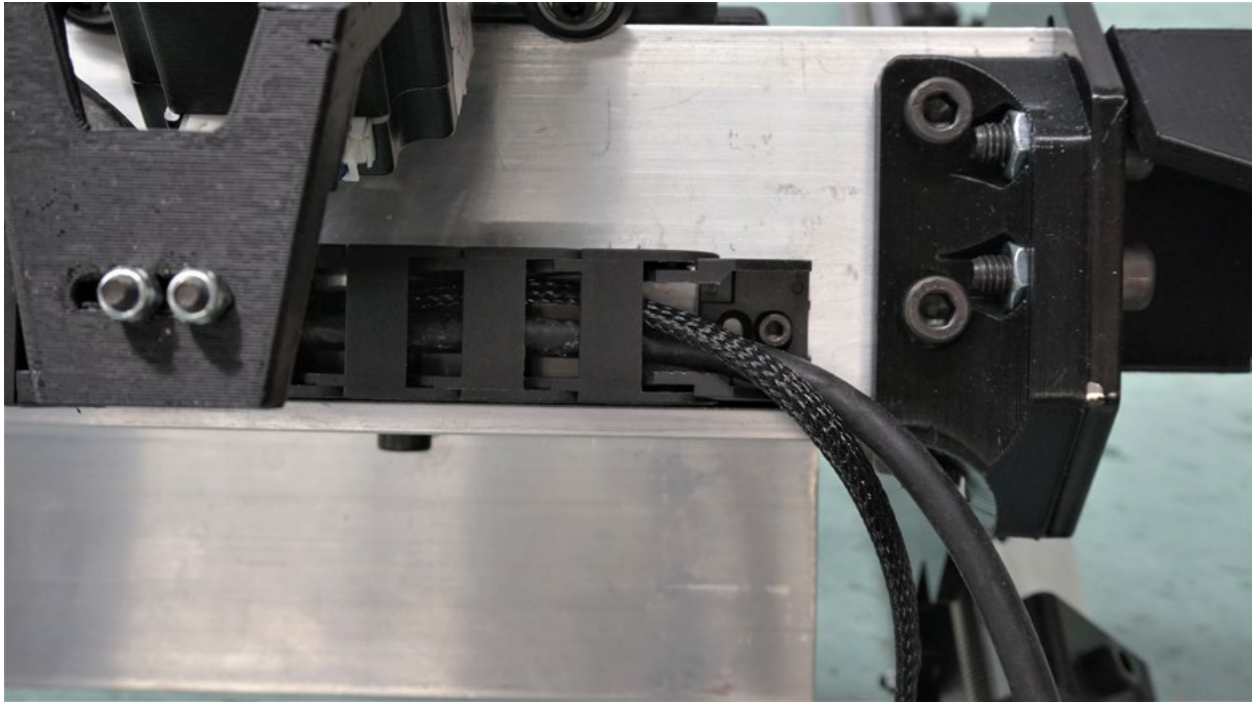
Grab the drag chain for the X-axis (the longer one for the 30×30) and seat the Z-axis motor and the router wire into the drag chain. Make sure that you have the correct end of the drag chain (with a pin-type link) so that you'll be able to connect it to the mounted end link (pictured), and so that the drag chain can bend in the right direction against the X-axis. You can start to re-clip the tabs in place.



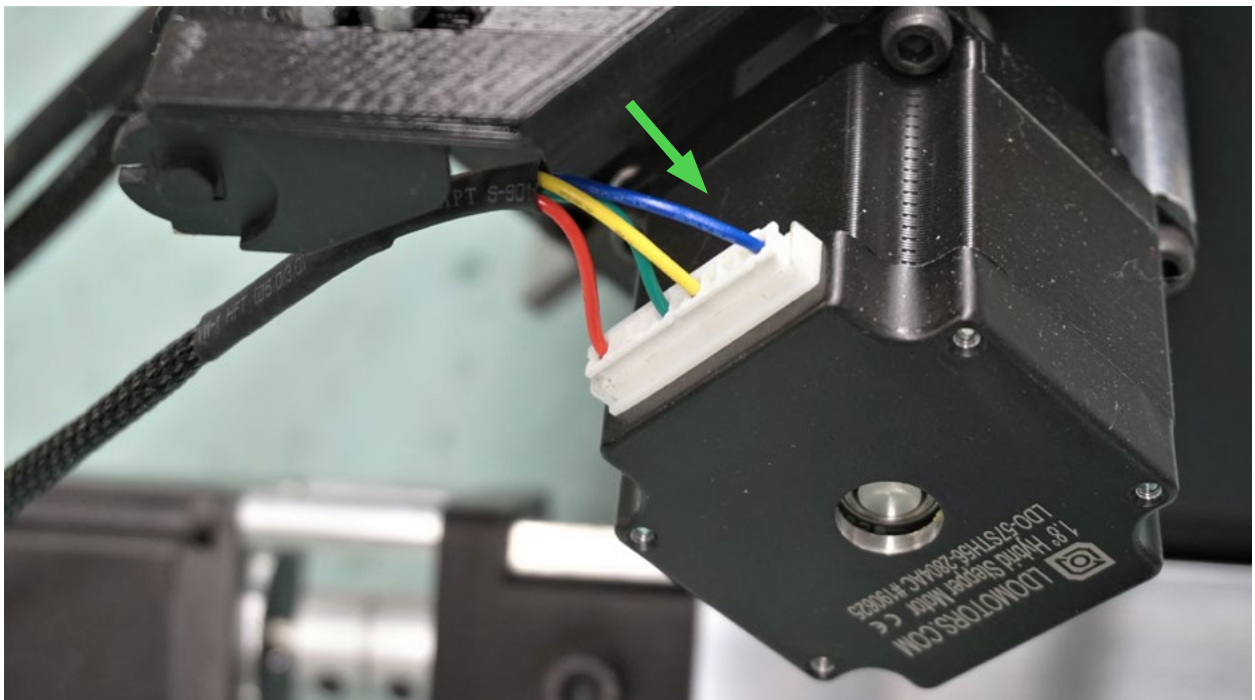
*Clip the end of the drag chain to the end link on the Z-axis mount*



Swing the drag chain and clip it onto the end link attached to the X-axis rail. Pull the wires through.



Now attach a motor cable onto the X-axis NEMA 23 stepper motor.

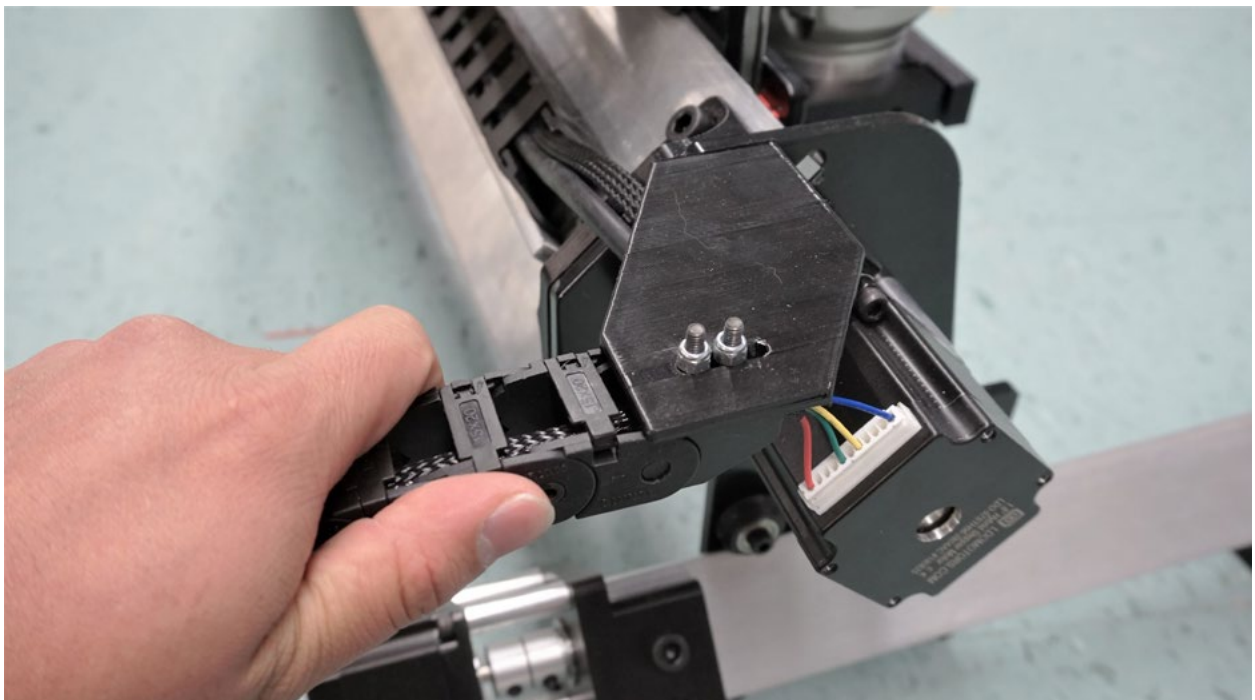


We will take the cable from the X-axis NEMA 23 stepper motor and the Z-axis NEMA 23 stepper motor, as well as the router cable and insert it into the Y-axis drag chain. Clip the tabs in to secure the wires, and make sure that the drag chain is facing the right direction (with the hole-type link, pictured) to fit into the correct end links.

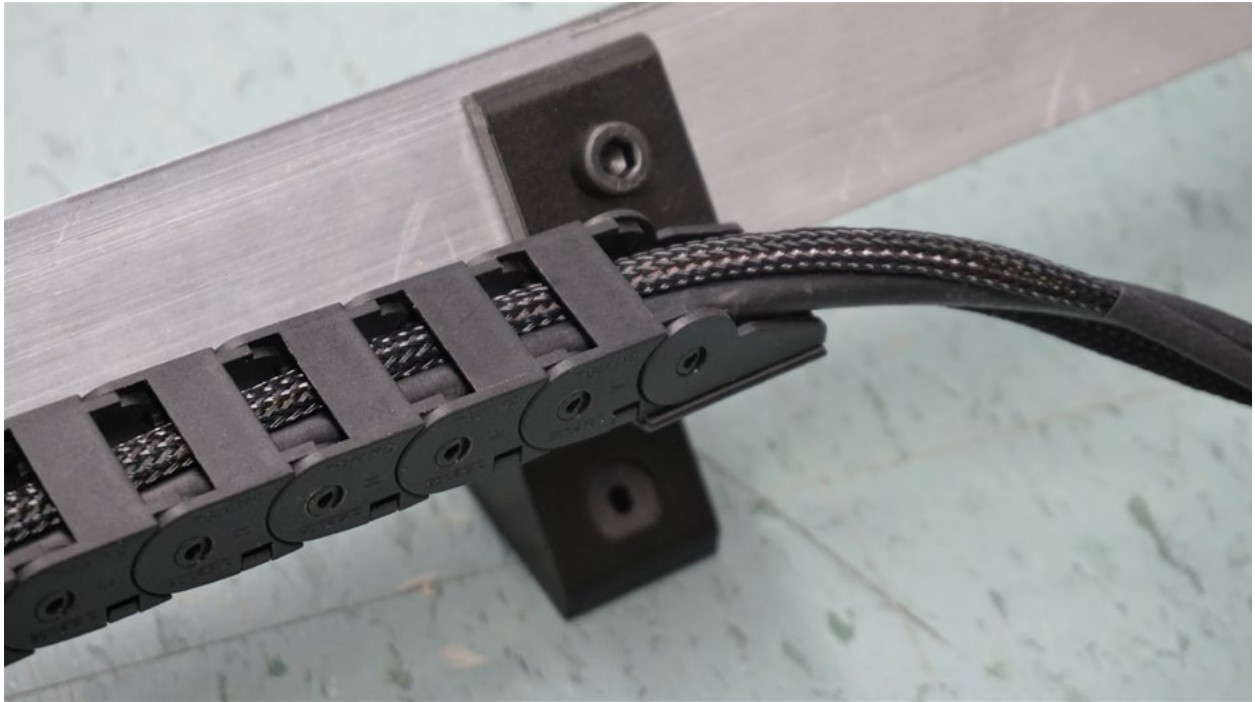


*Grab the Y-axis drag chain and insert the X and Z-axis motor cables and router cable*

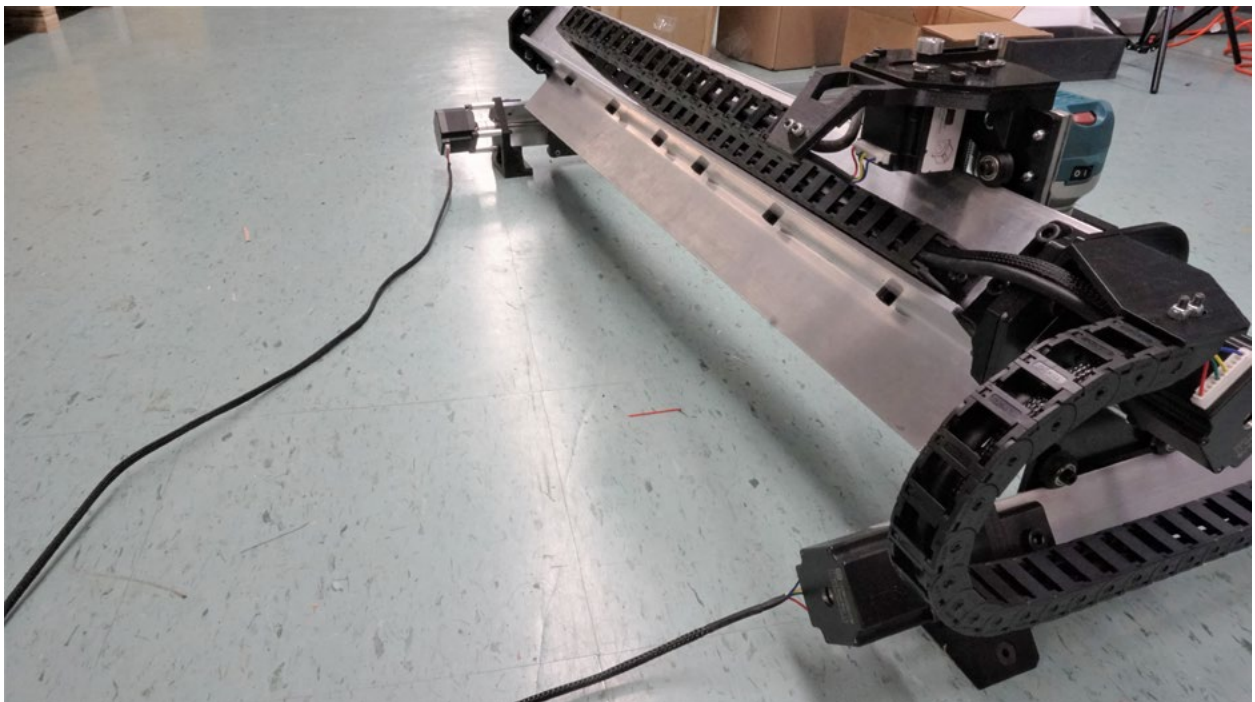
Clip the both ends of the drag chain into the previously mounted end links on the Y-gantry and the drag chain foot.



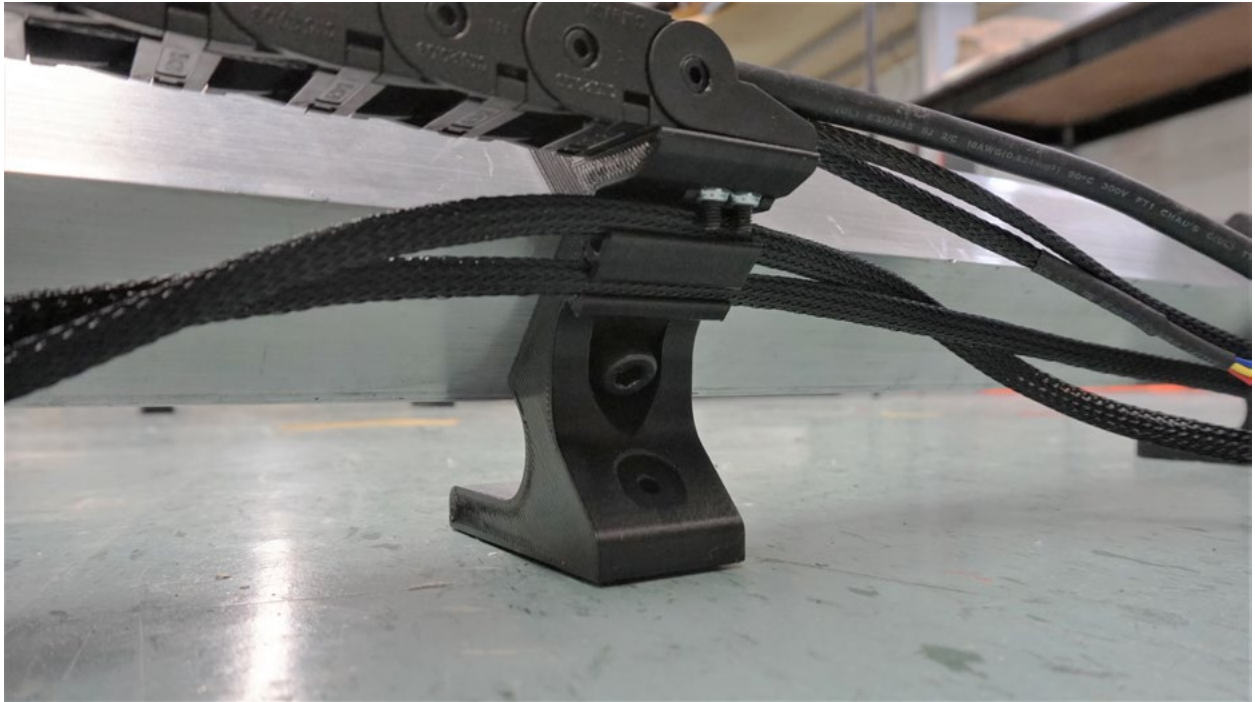




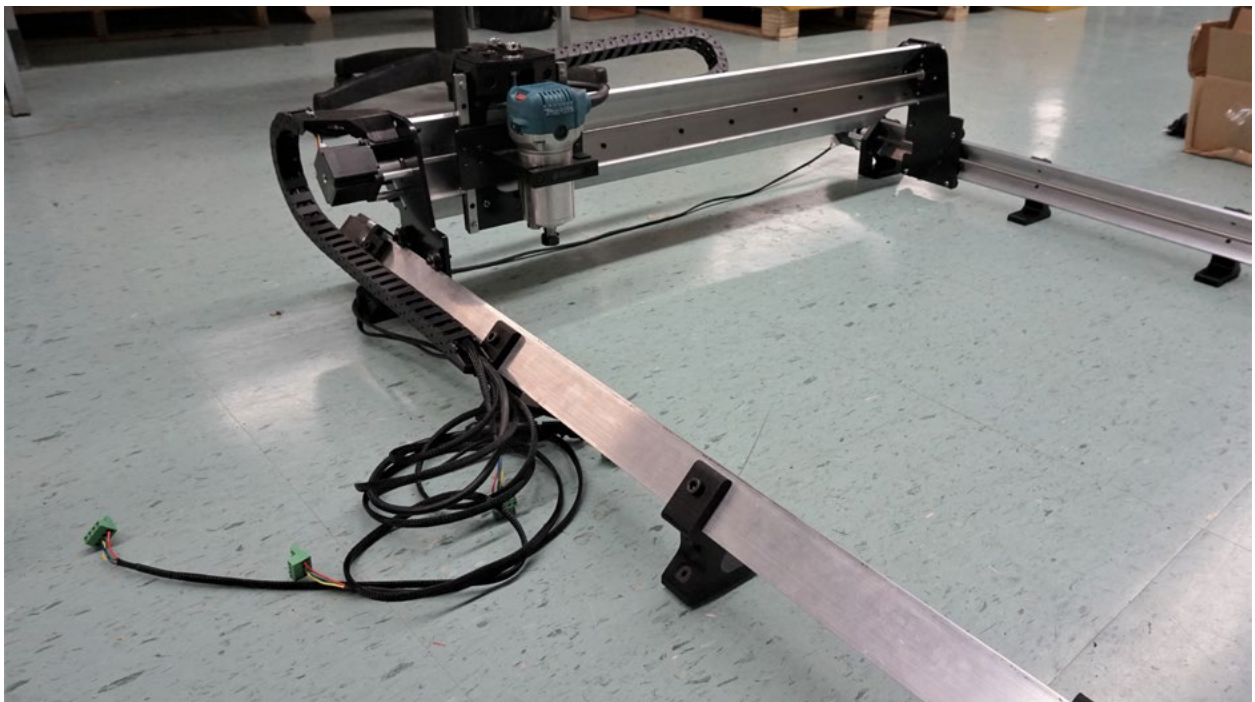
Now plug in the cables for the motors on the two Y-axis NEMA 23 stepper motors.



Bring the cables around to the left of the machine and slot them into the wiring cutouts in the drag chain foot.

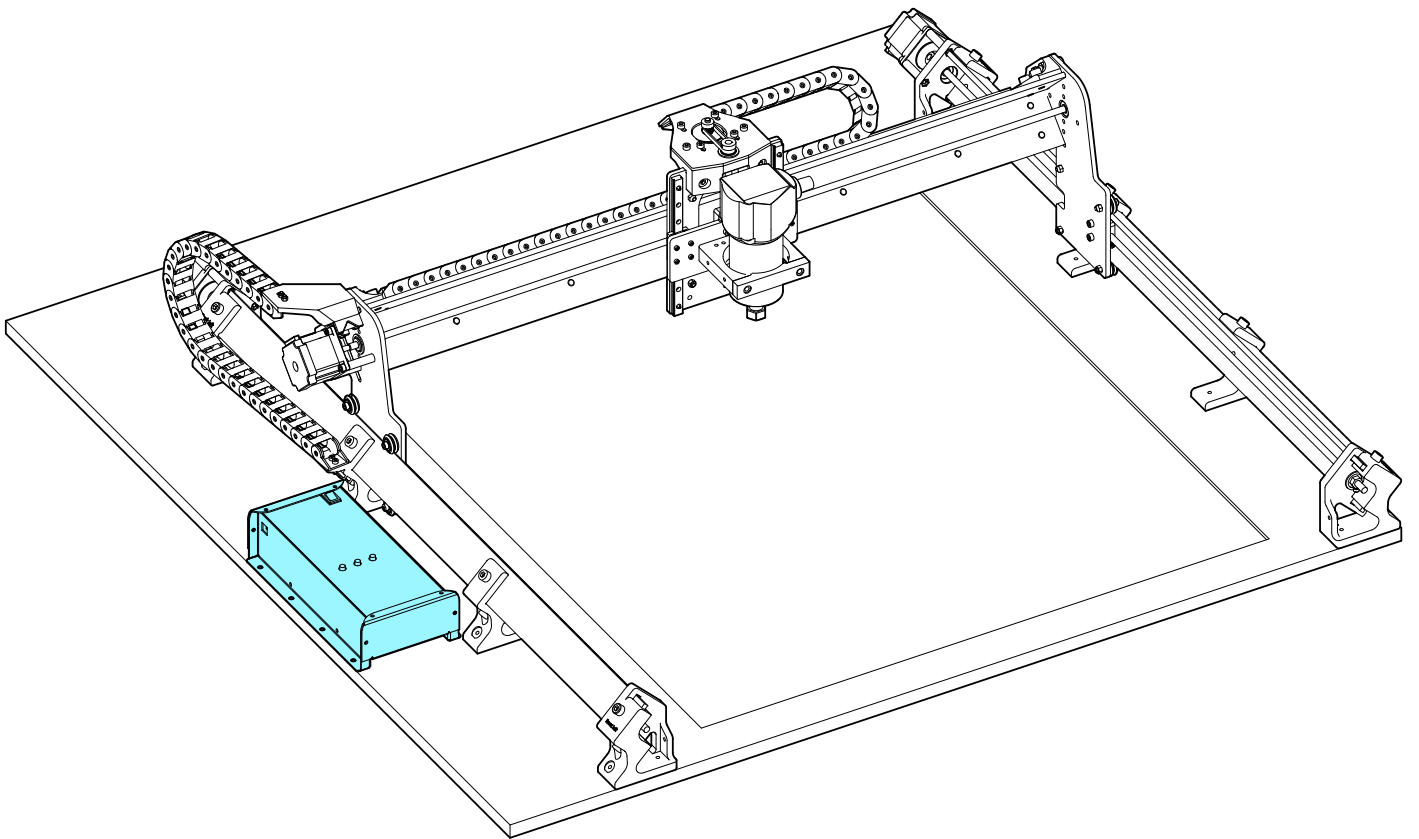


With all of the wiring coming in from the left, the machine wiring should now be complete.



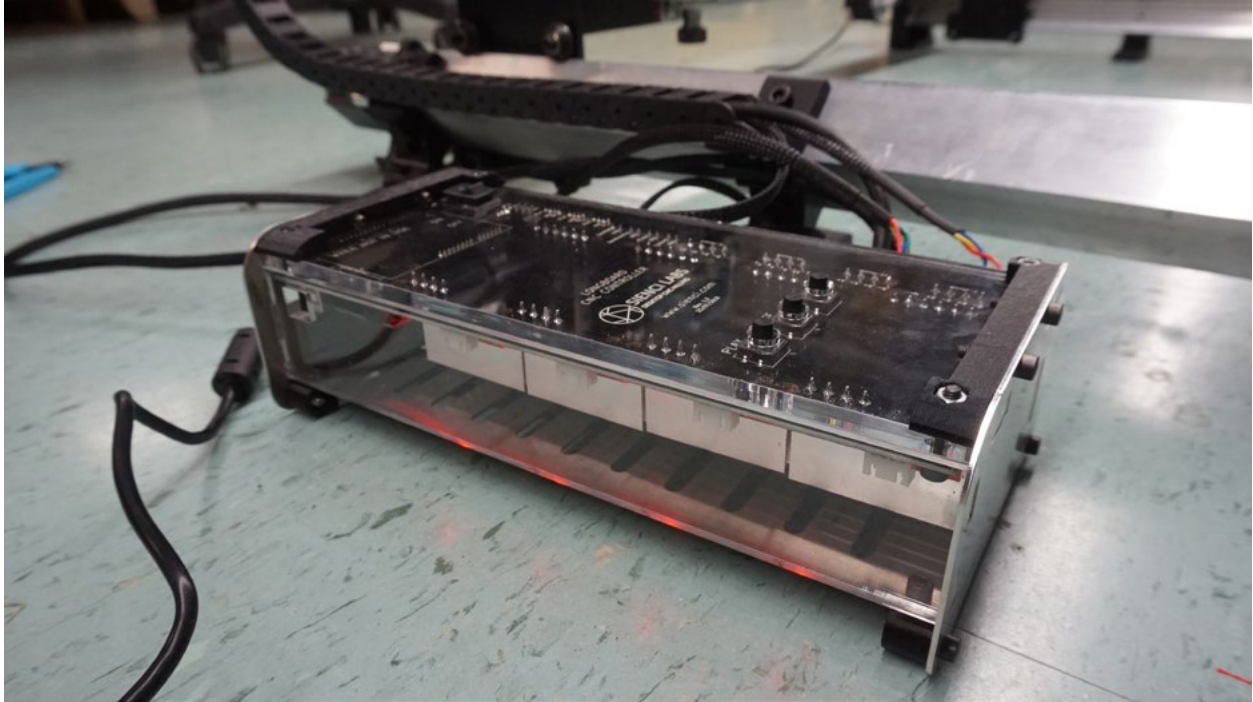
## Part 6

# Electronics





The LongMill electronics come pre-assembled and are pretty much ready to go out of the box. However, we recommend double-checking a few things before powering-on.

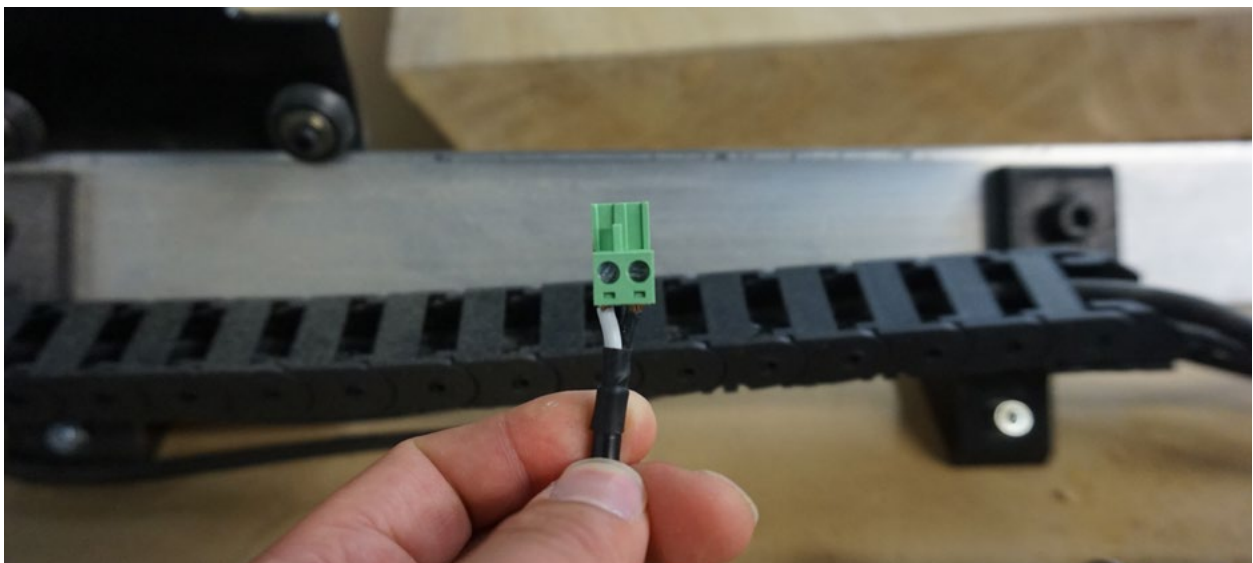


## DC power supply connector polarity

Before you plug in the power, check that the connection at the connector is correct and secure. The wire colours should be **white** or **red** on the left side and **black** on the right when the screw terminal is facing you (as pictured).

Check that the wires are connected securely by tugging on them. Secure them using the screw terminals and a flat head screwdriver if they're loose or disconnected.

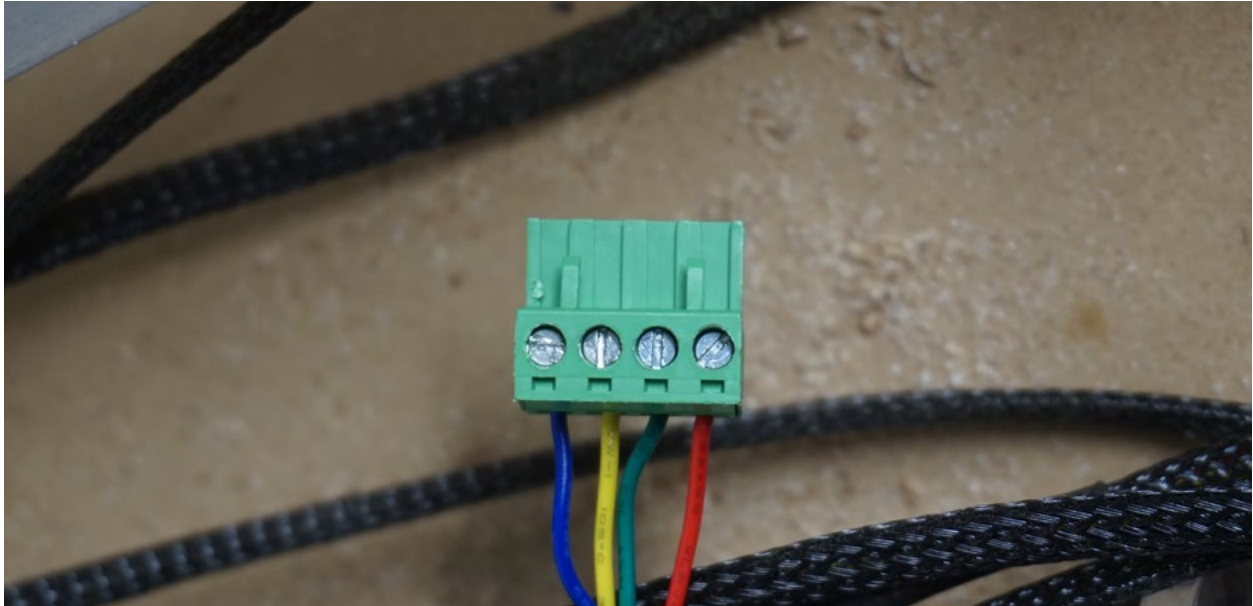
If you're unable to get the tinned wire ends to clamp inside the connector securely, then consider snipping the wires ends off and removing some more of the wire insulation to reveal a stranded length of wire. Clamping the stranded cable down tightly inside the term





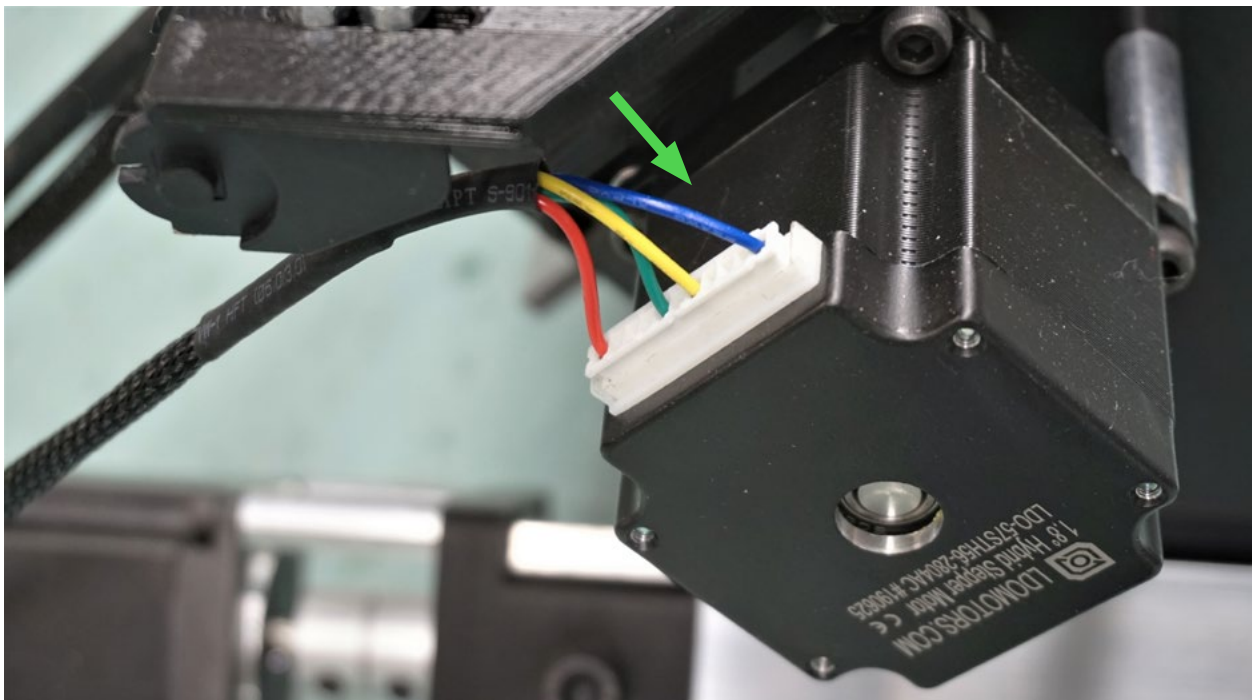
## Motor connector wiring

The wires, looking down from the side with the screw heads, should be, from left to right, BLUE, YELLOW, GREEN, RED (pictured). Check if the color pattern on all four of your motor wires is correct and re-arrange them if needed. As previously, also check that the wires are connected securely to the connector.



*The wiring color pattern should be blue, yellow, green, red.*

While you're at it, double check that the motor-side, white connectors on each axis are pushed all the way into the motor housing to ensure a good connection. If these connectors are sitting too loosely, then they can cause issues later on since the motor won't move as expected.



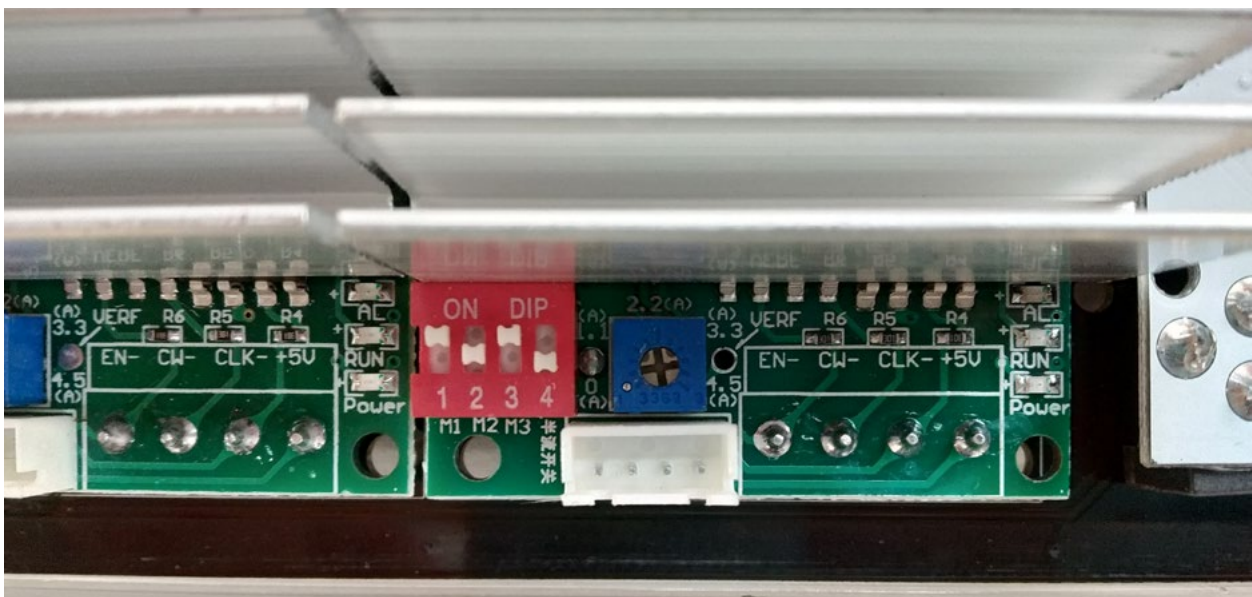
*X-axis motor*

## Properly seated DIP switches

Looking at the underside of the control box, you should notice four red switch blocks on the circuit board through the slots in the steel (pictured). These are a way of toggling how the motors are controlled by their respective motor controllers, where the slots in the steel have been made wide enough so that you can reach in with a small flat head screwdriver or an allen key to adjust these switches without disassembling anything.



These DIP switches normally **look** like they've been properly switched when in reality they're 'floating' between the up and down positions, as is the case for switch 2 in the picture below. Because of this, it's a good idea to push every single switch into it's correct position before moving on to the next step, putting switches 1 and 3 into the 'up' position and switches 2 and 4 into the 'down' position (pictured).



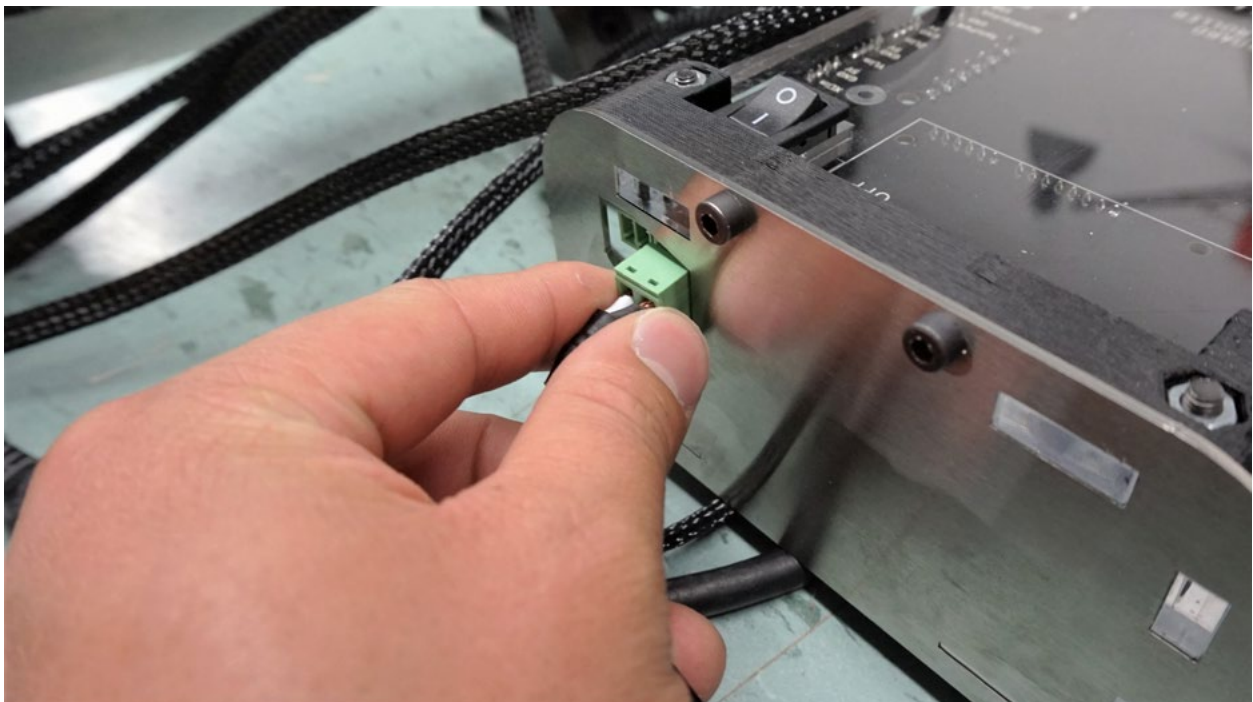


## Plugging in the motors and power supply

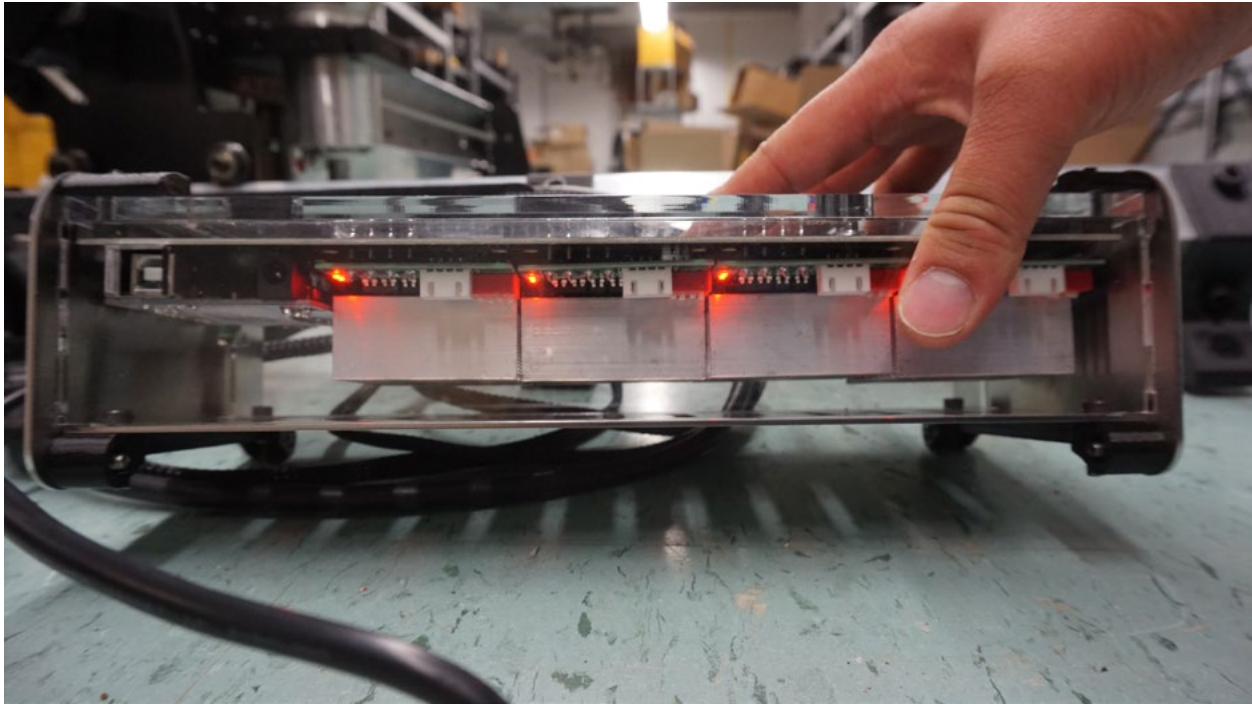
With these checks done, start by connecting the motors. Track each cable from each motor to its corresponding green connector and connect it to the board. The fit of these connectors is tight but you need to be sure to push them ALL THE WAY in so that there is good contact between the plug and the connector. Each plug on the board is labelled on the top (note that there isn't a difference between the Y1 and Y2 plugs, the Y-axis motors can be connected to either of them).



Next, plug the DC connector into the LongBoard before plugging the power supply into the wall; a green LED on the power supply brick should light up to indicate that it's receiving wall power.



Now, flip the power switch on top of the control box to turn on the electronics. You should see four red lights inside the box light up to confirm that everything is receiving power.



Once you've checked that the lights are turning on, flip the power switch back off.

A note on the control box is that it will be limited in its placement due to the length of the Z-axis motor cable. If you wish to place it further from the machine, extending the wires for that cable is quite straightforward either through the use of a soldering iron or through crimp-able wire extenders.

## Connecting the LongMill to your computer

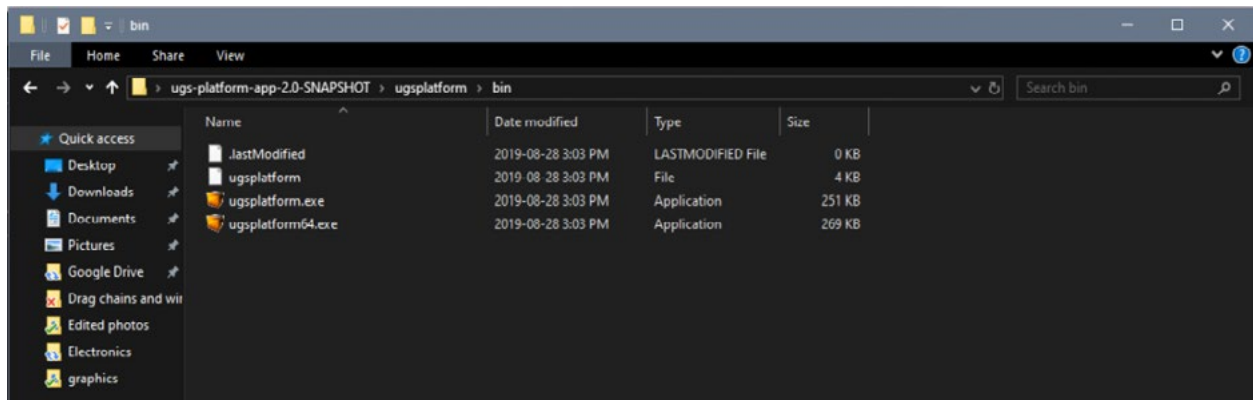
To manipulate your LongMill and send it files, you'll need a g-code sender which acts as the control software. We recommend using UGSPlatform, which is what we'll be using to show the next couple of steps and in the remaining part of the assembly. You can download UGSPlatform here: [bit.ly/2Z3DIVC](https://bit.ly/2Z3DIVC)

Note: Some users have reported some bugs with the latest version (Dec 2019) of UGSPlatform. We recommend users to use the August 2019 version of UGSPlatform.

UGSPlatform works with any operating system (MacOS, Windows, Linux) that has Java installed. Most computers come with Java installed but if you don't have Java, you can download and install it here: <https://www.java.com/en/download/>



Once you have UGSPPlatform downloaded: locate the downloaded file, 'un-zip' or 'extract' it (usually found when you right-click the file), then open the "ugsplatform" folder. There will be a folder inside called "bin" which will look like this once you open it up:



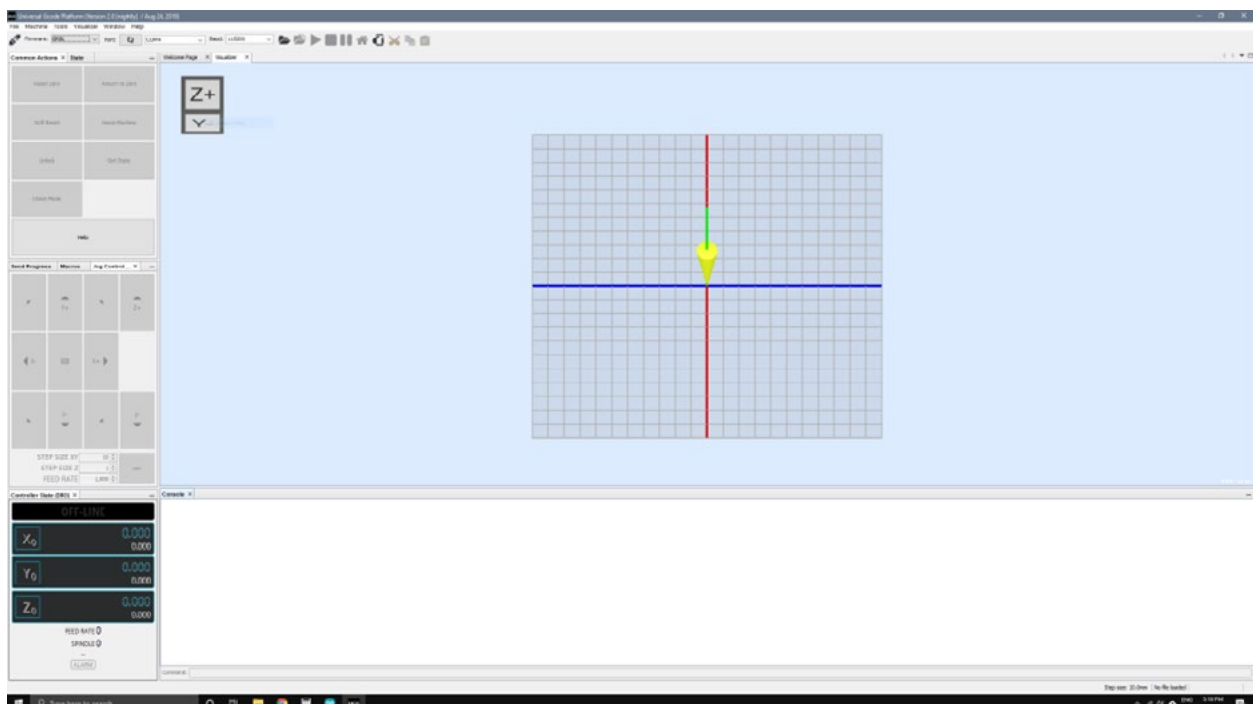
If you are using a 64 bit Windows computer, use **ugsplatform64.exe**

If you are using a 32 bit Windows computer, use **ugsplatform.exe**

If you are not sure which type of Windows you are using, you are most likely using a 64 bit computer. You can try both and see which one starts.

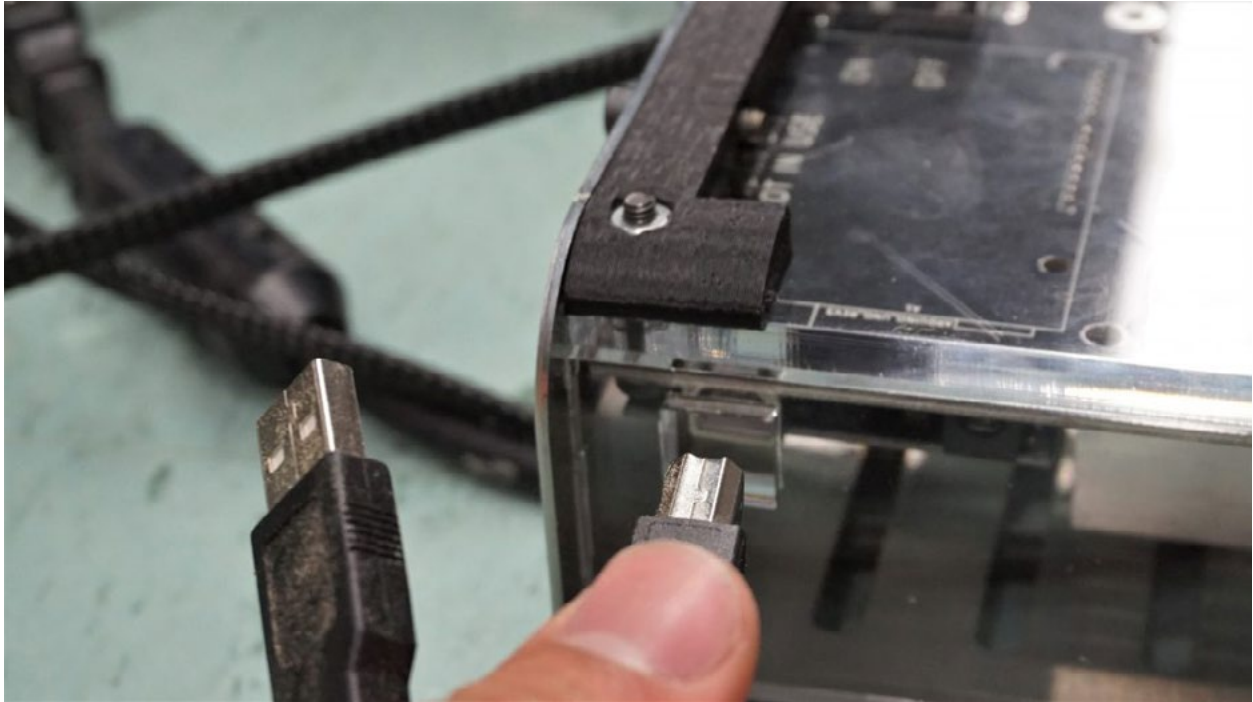
If you are using a Mac OS computer, use ugsplatform.

You should be greeted with a screen that looks like this. If you aren't and you encounter an error while opening UGS because it's not able to locate Java, then there is another program on your computer blocking UGS from opening properly; see the general fix for this [here](#).



Connect your computer to the LongMill control box via USB.

**Note:** Your computer will automatically install drivers for the Arduino at this point if they are not already on your computer (can take a minute or two). If you try to connect your machine but you cannot, you may need to manually install the drivers. You can do this by installing the [Arduino IDE](#) which will install the drivers during the installation, or you can follow the instructions on doing them [manually for Windows](#).

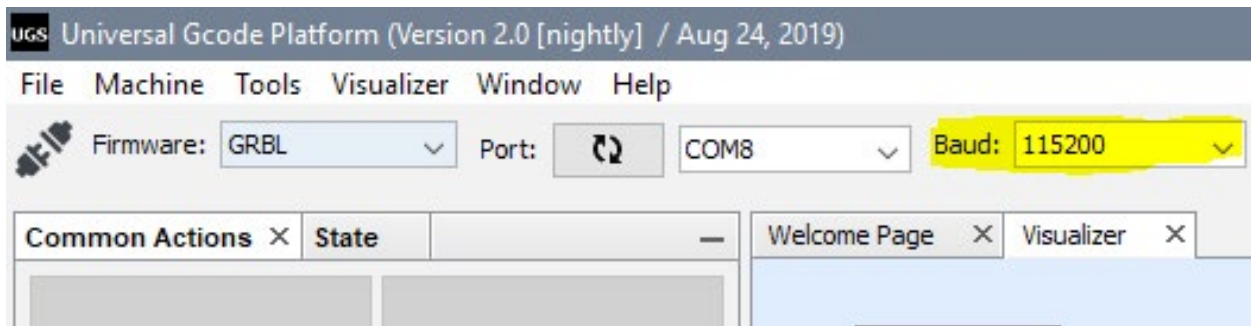


*Plug in the USB cable onto the LongBoard.*



*Connect your USB cable to your computer.*

Once that is done, go to the top left corner of the program. First, make sure that your baud rate is set to 115200.

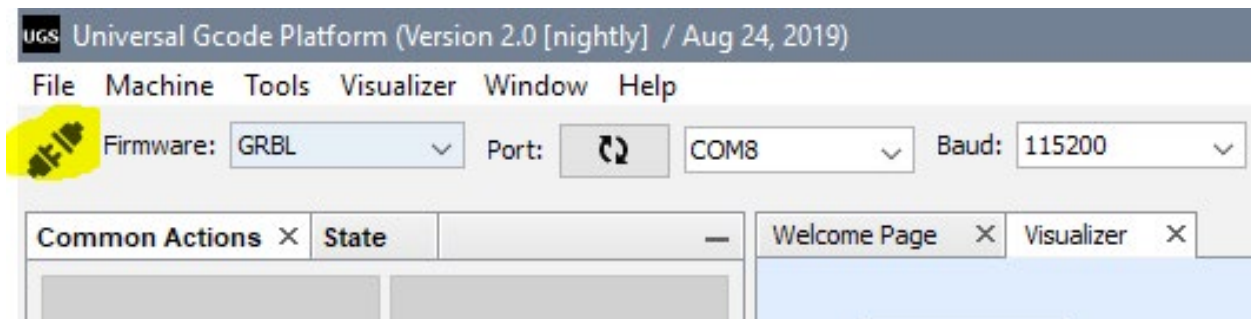


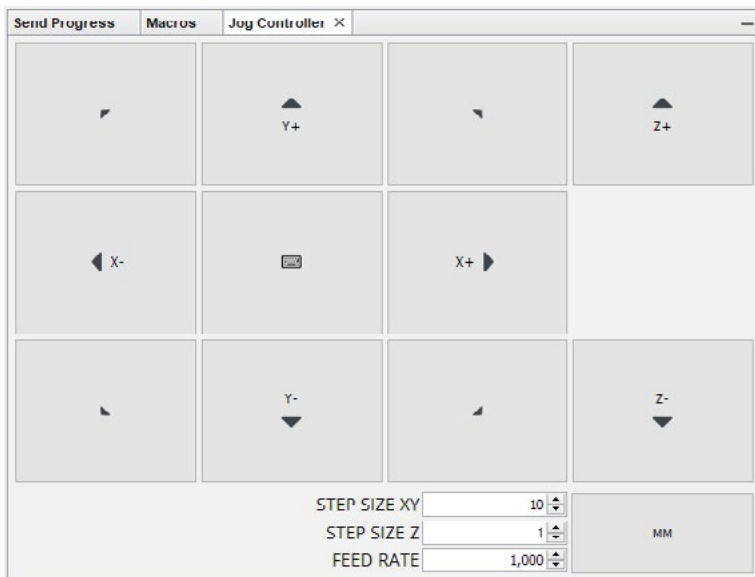
Then click on the refresh icon. This will go through and auto-detect which USB port your machine is connected to. If you have multiple things connected to your USB ports, you may have a few different options to choose from. You can either unplug the other items you have plugged in, or you can try connecting to each one to see if they make a connection.



At this stage, power on your machine.

Finally, click on the highlighted "Connect" button. If your machine connects successfully, you should see this icon turn orange and you should see in the console output a message like "Grbl 1.1g ['\$' for more help]"





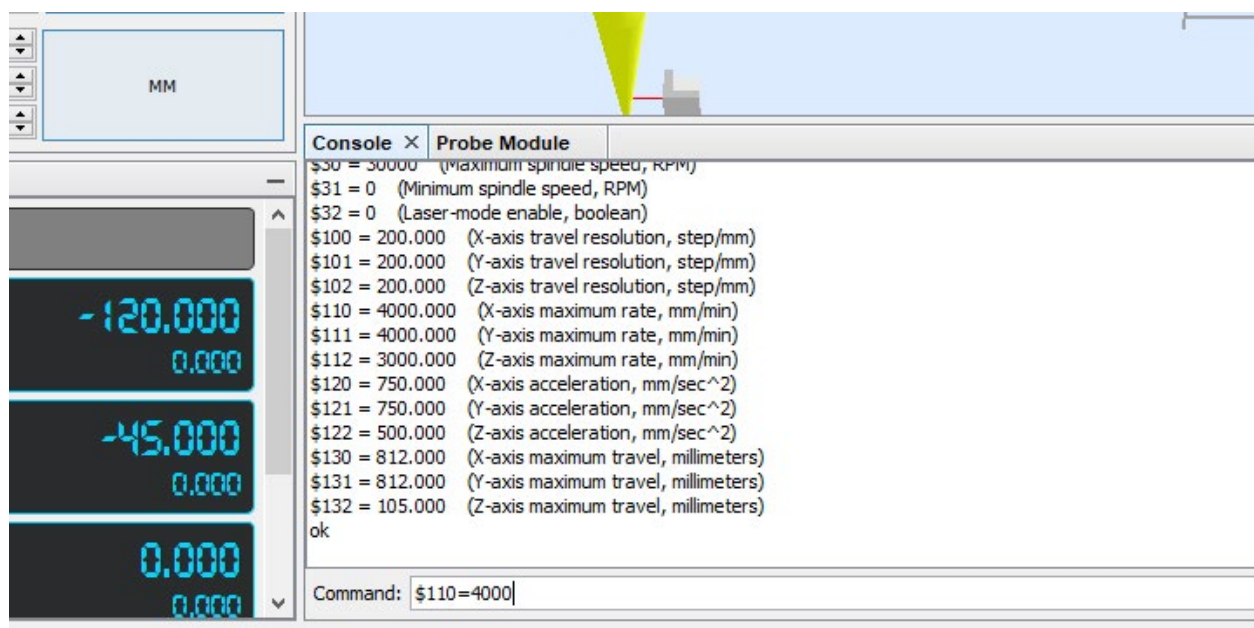
You will usually hear a gentle hiss and a thump noise when the machine connects. If so, you can now try playing around with moving the machine. You can jog the machine in the direction you want within the “jog controller” window.

You can choose the amount that the machine will move in the XY directions by changing the “STEP SIZE XY”, the amount in the Z direction with “STEP SIZE Z”, and the feed rate with the “FEED RATE” boxes.

We recommend starting with 10mm for the XZ and 1mm for the Z step size, as well as 1000mm/min for the feed rate. You can adjust this as needed.

Moving the machine around will be important for when we mount the machine to the wasteboard next!

**Note:** Once you’ve connected to your machine via UGS or your preferred interface software, go to the console communication tab and type in: “**\$110=4000**” and hit the ‘Enter’ key. This will modify the maximum feed rate of the X-axis to being 4000mm/min which we’ve found will help it to run more reliably. If you’d like to know more about this recent fix, see our post here: <https://forum.sienici.com/t/fixing-the-x-axis-torque-out-issues/332>

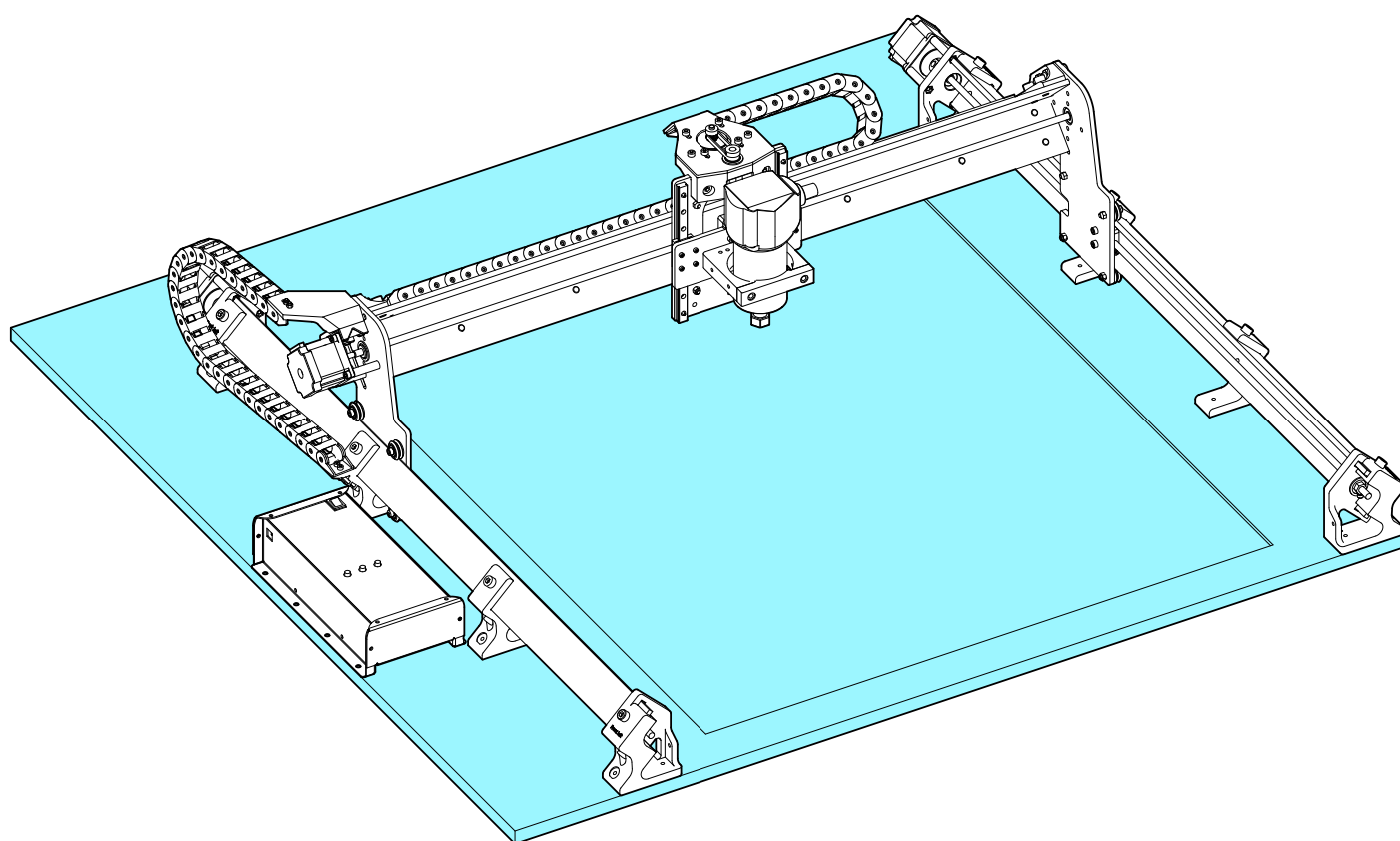


Anyway, on to the wasteboard mounting!

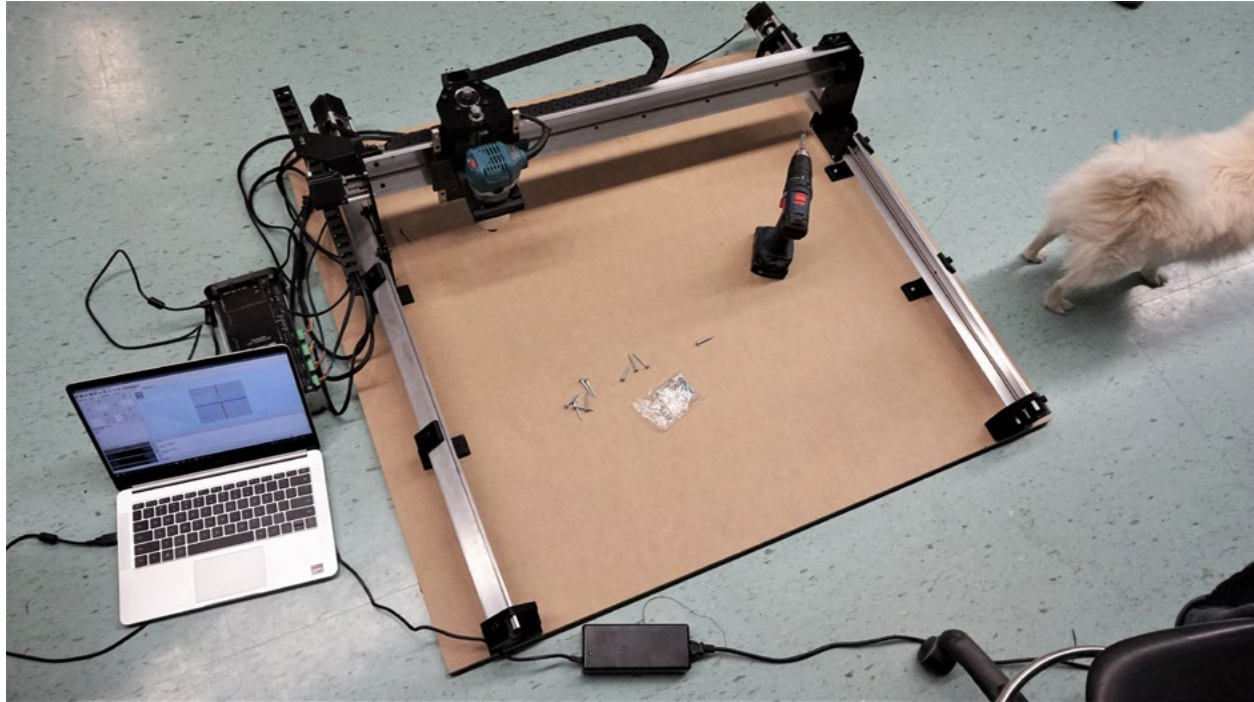


## Part 7

# Table Mounting



The LongMill is designed to be mounted to a flat surface which is provided by the user. This could be as simple as a single sheet of material, or as intricate as a multi-piece torsion table with t-tracks and threaded inserts. One thing is to ensure that you've got a flat sheet (or multiple flat sheets) of material within the cutting area of the machine. This "wasteboard" area is where the material you will cut will sit on and serves to be cut into and replaced when needed.



We do not ship LongMills with a wasteboard because:

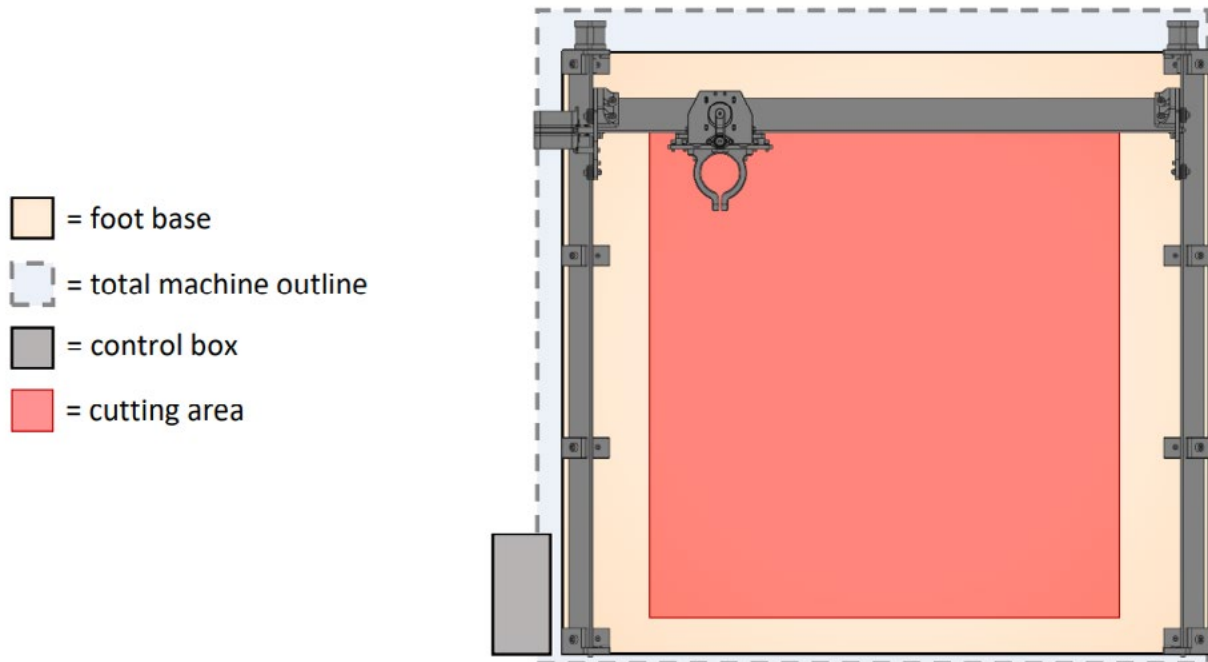
1. It saves the cost for shipping. For example, a 4ftx4ft piece of 3/4" MDF shipped often costs over a hundred dollars in shipping and is very easy to damage during transit. You can usually find a full 4ftx8ft sheet of 3/4" MDF for under \$60 at your local lumber or hardware store.
2. Users can choose the size and material of the wasteboard to match their needs.

## Suitable wasteboard materials

The easiest setup that we recommend is a flat, clean piece of 3/4" MDF to act as your mounting surface and your wasteboard. This is because 3/4" MDF is quite stiff and is readily accessible in 4'x4' and 2'x2' sizes from most big-box hardware stores or a lumber store. Any similar piece of thick, flat material would also suffice; you can choose at your own discretion. If you're looking for more of a flashy setup, you can check out some of our community members' table/wasteboard builds here for inspiration: <https://sienci.com/dmx-longmill/community-table-builds/>

## Machine Dimensions

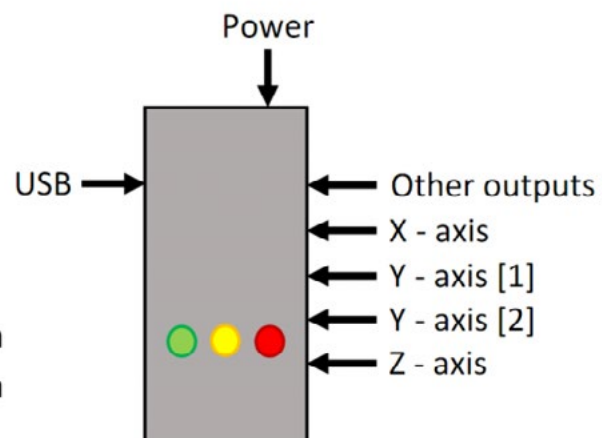
When getting ready to mount your LongMill, the most important dimensions you'll need to know are the size of its foot base and the total outline of the machine. As long as your mounting surface is at least the size of the foot base and you've left enough space around your mounting surface to account for the total machine outline, then your setup will be suitable.



The control box is also something you should plan for, as the design of the machine favours placing the control box on the left side of the machine whether it's sitting on the table or mounted to the side or underside of the surface. The control box has buttons on the top which can Play, Pause, and Stop the machine's motion so it's a good idea to keep it mounted near your CNC. It also has a USB input on the left side, motor and other outputs on the right side, and the power input on the back side, so make sure to keep some space around it for cable management.

**LONGMILL**  
Control Box

Approximate Width = 150mm  
Approximate Depth = 280mm

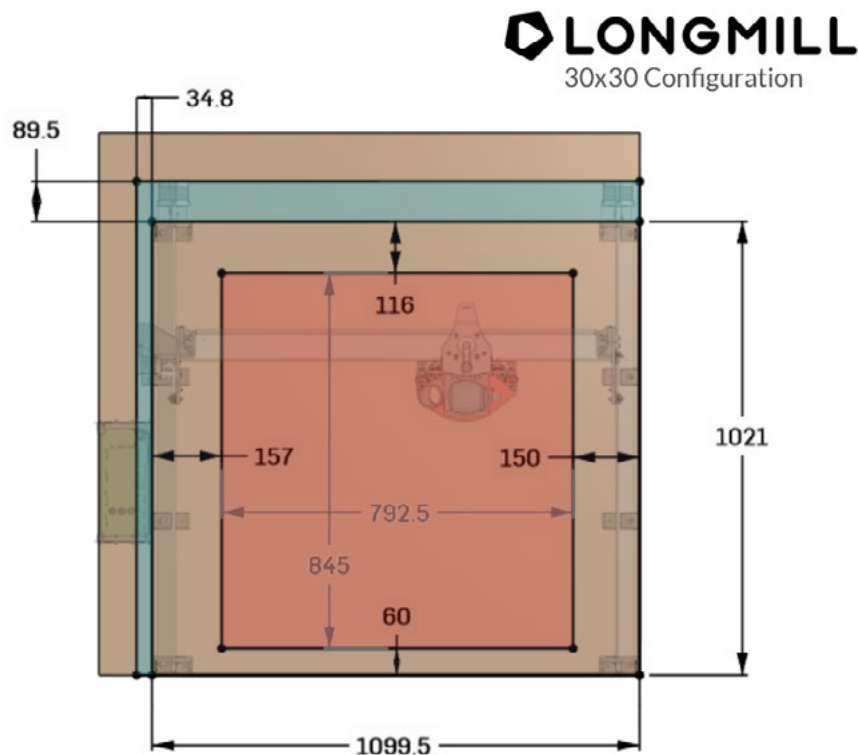


Generally, the sizes of each model of the LongMill have been designed to fit on the following surfaces as follows:

- LongMill 12×12: Fits on a 2ft x 2ft surface
- LongMill 12×30: Fits on a 2ft x 4ft surface
- LongMill 30×30: Fits on a 4ft x 4ft surface

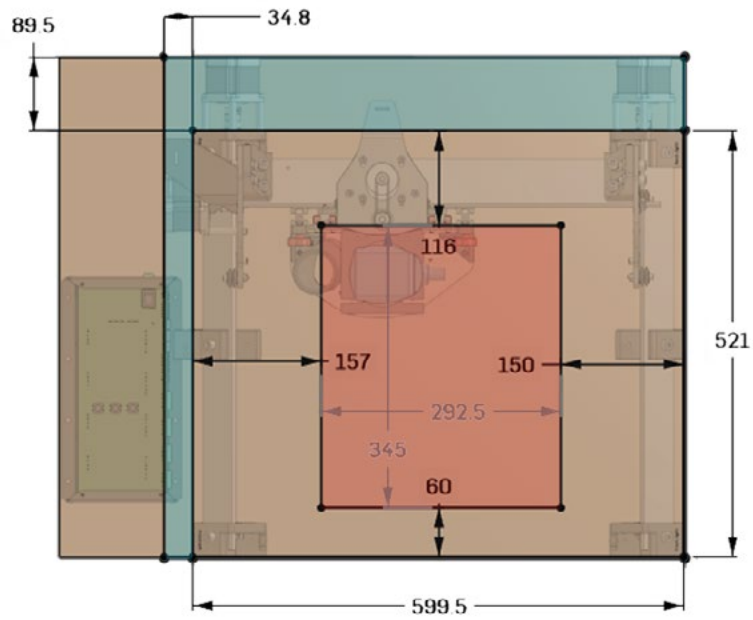
The diagrams below shows a more detailed view of each of the important dimensions. Note that:

1. The **red area** inside the main box shows the cutting area as an offset from the foot base
2. The **blue area** outside the main box shows the hanging parts as an offset from the foot base which makes up the total machine outline
3. The area taken up by the control box isn't accounted for in this diagram
4. If you have our **dust shoe** attached, your cutting area in the X-dimension will be shrunk by approximately 50mm (about 22.5mm off the left side and 27.5mm off the right side)
5. The width of the foot area is determined by the distance between the middle feet (not the front and back feet) since the middle feet sit slightly wider than the front and back feet do
6. The red cutting area is based about the center-point of the router, thus you can plane an area larger than what's stated if you're using a large surfacing bit (add your bit diameter to the width and depth of the cutting area to find the maximum)
7. These diagrams have got a small buffer on the cutting area (i.e. it's been shrunkened slightly) since each part has its own manufacturing tolerance and can come together differently in assembly so we want to ensure we're providing a reasonable guarantee on what can be expected from your machine
8. Although the working height of the LongMill is approximately 350mm, if you're planning an enclosure then we'd recommend having a height of 500mm at the minimum to ensure enough space for hose management, manipulating cutting material, etc."

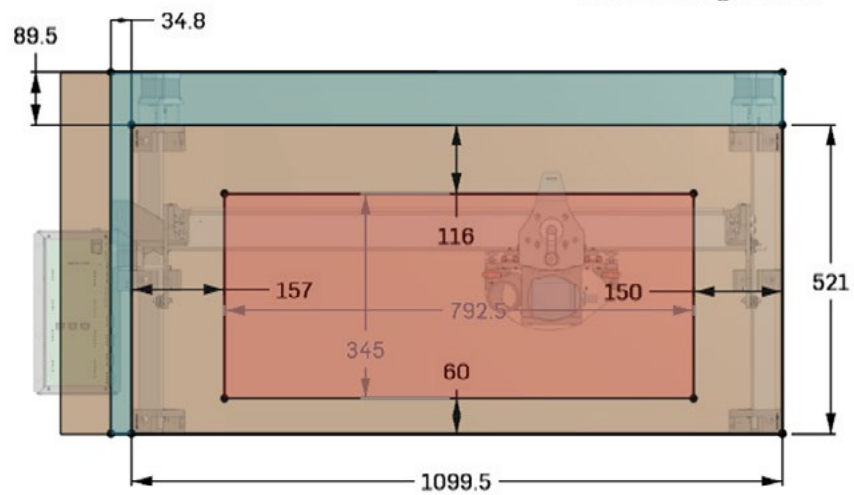




**LONGMILL**  
12x12 Configuration



**LONGMILL**  
12x30 Configuration



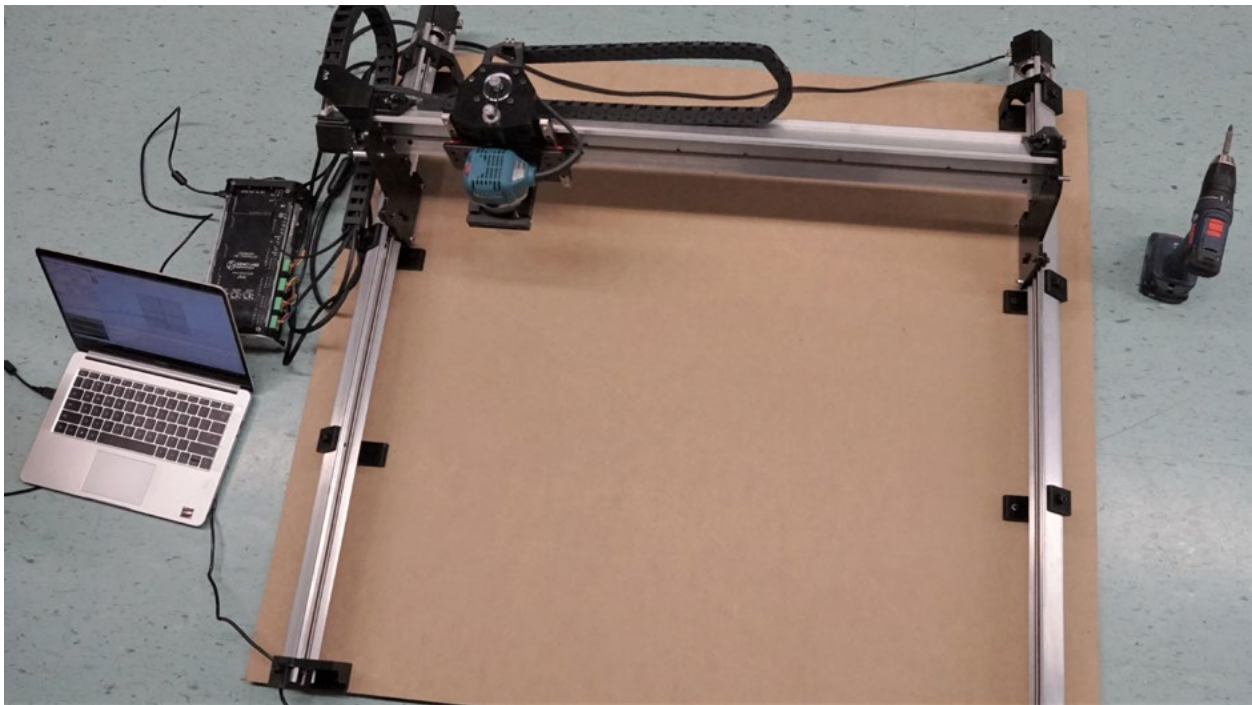
## Mounting your LongMill

To ensure that your machine is mounted securely and accurately, we've created a series of steps to help you do so. We highly recommend following these steps exactly, as the order of these steps matter. You'll need a computer to be connected to the machine in order to align it properly.

We will start by checking the tension of the Delrin v-wheels. As we did in the previous steps, we want to make sure that the wheels barely turn with our fingers by adjusting the eccentric nuts.

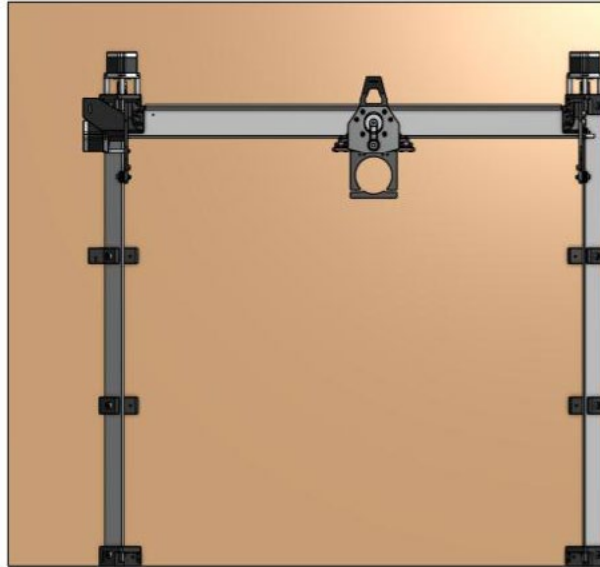
We will also properly tension the Delrin anti-backlash nuts. Turn the tensioning screw a little bit at a time. Check for play by moving the gantry back and forth and seeing if there is any excess movement. Do not over tighten, usually a half turn is more than enough.

Gently put your LongMill on the mounting surface and shuffle it over roughly where you want it. In this case we're using a 4'x4' MDF sheet as a combination mounting surface and wasteboard which we had cut to 42 inches to better fit in a car. We'll be mounting it in the middle and have the electronics box sit off the material to the side.



*Move the machine onto your mounting surface. Position it to where you want it.*

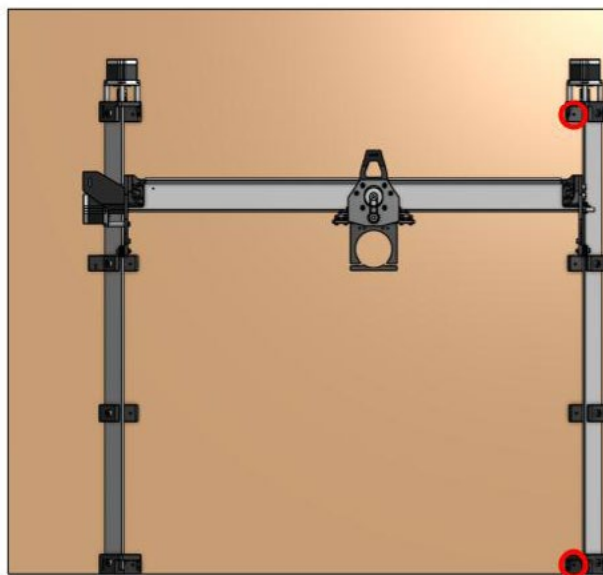
Once positioned, start by moving the machine all the way to the rearmost position by jogging in the y-axis on your control software. Keep moving backwards until you hear a grinding coming from the motors on both sides; this is to confirm that your machine is all the way back and it aligns the left-side feet to the right-side feet.



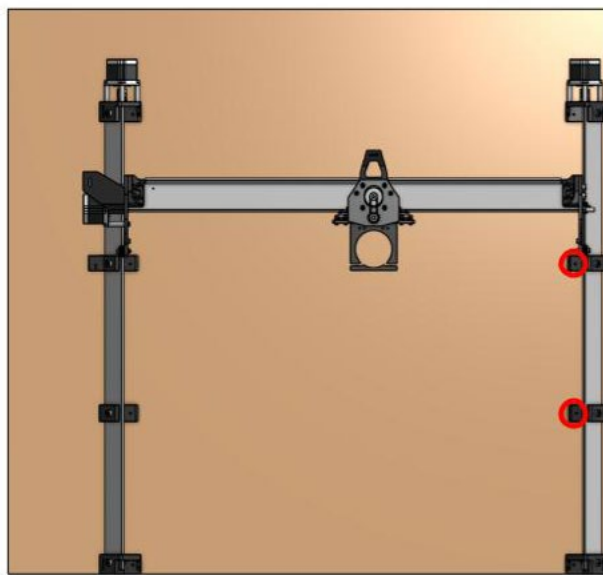
We'll start by mounting the right side of the machine. Using a drill with a long Robertson driver or a short one on a bit extender works best for driving in the screws so that you have the necessary reach. You can use the particle board screws provided, or use your own mounting hardware depending on your material or its thickness, but please ensure that you **don't use counter-sunk wood screws** to attach the feet as this will crack them.

The screws included are 1-1/4", 1-1/2", and 2" size #8 particle board screws. Each foot has two holes for mounting where the shortest screws are meant for the inside and the longer one are for the outside. Please note that the 2" screws WILL go through 3/4" MDF, but were still included since they can hold the LongMill feet down better. If you choose to use them, make sure that the surface under the board will not be damaged if you have screws coming out the bottom.

Alright, begin by moving the machine a couple of inches forward and mount the inside of the top and bottom feet using two wood screws (1-1/4").

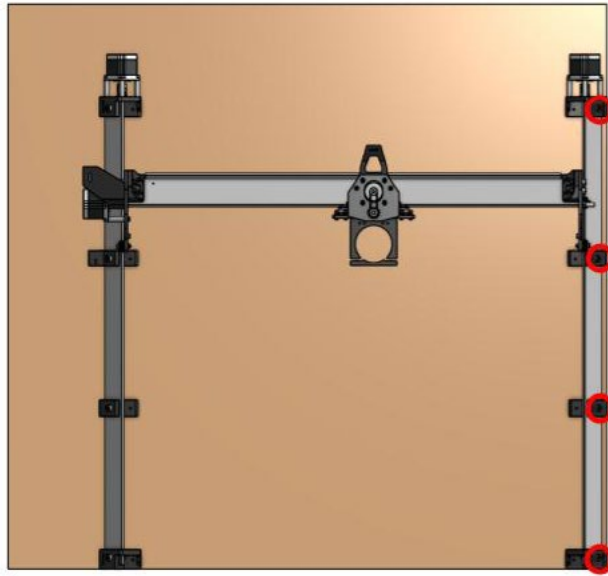


Next, we'll put screws in the other two spots on the same side, this time on the middle feet.

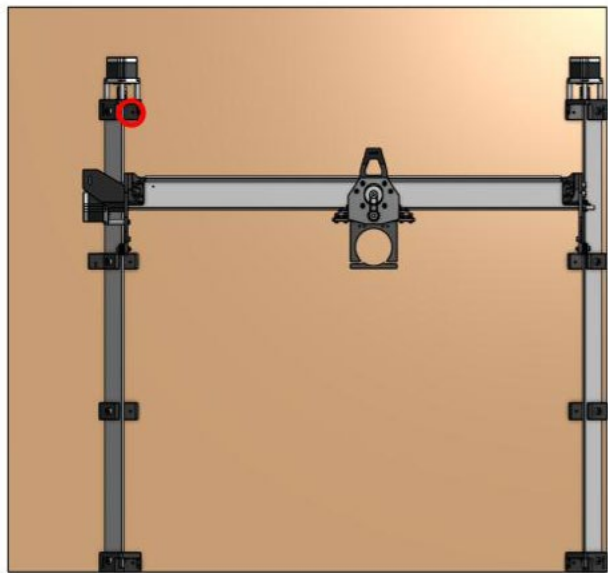




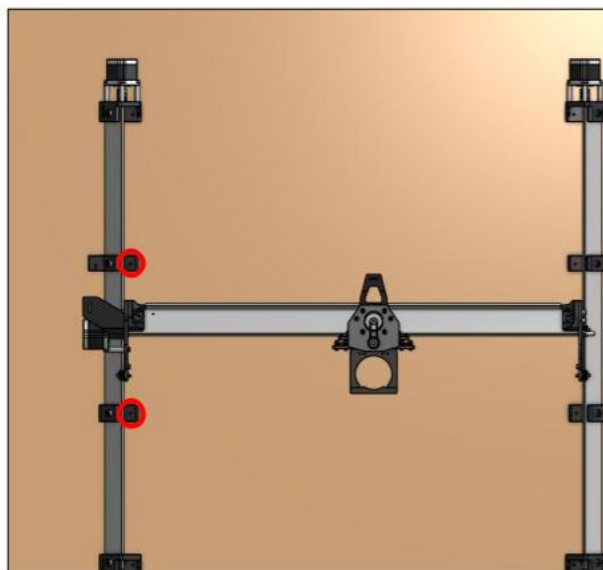
Now fasten the diagonal mounting points of all the right-side feet using the longer screws.



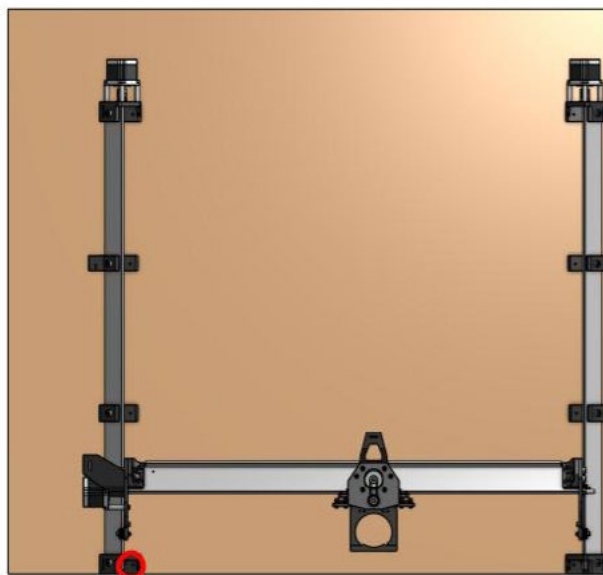
At this point, one side of your machine will be fully secure. The technique to make sure the other side is mounted parallel to the first side is by running the gantry between its limits and mounting the other side as you move it along the length. Start by mounting the top left foot on the inside:



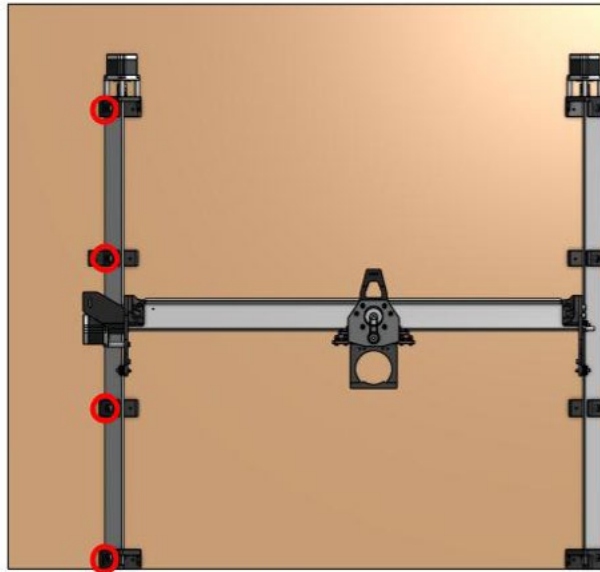
Move the machine down so that it is roughly in the middle of it's length, then secure the insides of the next two feet:



Finally, move it to the front and secure the inside of the front left foot:



Now move the machine again to the middle spot and use the longer screws to finish mounting the feet using their diagonal mounting holes.



Your machine should now be fully secure to its mounting surface. From this point, you should be ready to get cutting your first jobs! If you've got the touch plate or the dust shoe add-ons alongside your machine, you can see our pages on how to get those assembled and set up: <https://sienci.com/dmx-longmill/dust-shoes/>

You can also navigate to the Post-Build section of the LongMill resources if you'd like to try out one of our easy starter projects, learn how to maintain your machine, or would like to address some issues you had during setup by visiting the page on 'Common Issues & Fixes'.

# Appendix: Unboxing

The LongMill comes with a lot of parts, but we've organized them to make it as easy as possible to find and put everything together; each kit comes with several cartons.

For the complete BOM, visit: <https://docs.google.com/spreadsheets/d/1xyy-UfH2HbzT0Ood7SpQIwxkfFexDDYBOZeApSEc3IM/edit>

## Top Carton #1

When you first open the top carton #1 it should look like this:





This box includes:

- A welcome page with safety guidelines on the back
- Some assorted stickers, including long ones for the LongMill and some with Louis on the machine, Andy's dog and our unofficial mascot and CEO



- parts for the dust shoe (if you ordered it) including two hardware bags (one for assembling the dust shoe and one for mounting it), a backing plate, and 2 aluminum extrusions.



- The touch plate in the yellow padded envelope (if you ordered it)



- The end mill add on pack (if you ordered your machine through Kickstarter)



- Aluminum router mount (in the size you requested)



- Hardware bag #1 which contains: M8-25 (x12), M8 hex nut (x12), M5-25 (x35), M5-12 (x5), M5 nylock nut (x35), M5 washer (x14), M4-16 (x10), M4 hex nut (x10)



- Hardware bag #2 which contains: V-wheel (x12), 608zz flange bearing (x8), Delrin block nut (x4), Pulleys and belts (x2), ACME locking nut with M3 set screw (x4), 1/4" to 8mm coupler (x3)



- Hardware bag #3 which contains: M8-16 (x30), M8 washer (x4), M5-50 (x12), Aluminum standoff (x12), 1.25", 1.5", and 2" board screws (x10 each), Eccentric nut (x6)





- Three unthreaded motors (X & Y axis) and one threaded motor (Z axis)



- The power brick with its AC power cable inside a white cardboard box



- A bagged USB cable (type A to type B)



- The electronic control box protected by grey padded foam (the three orange components won't be there for most machines)

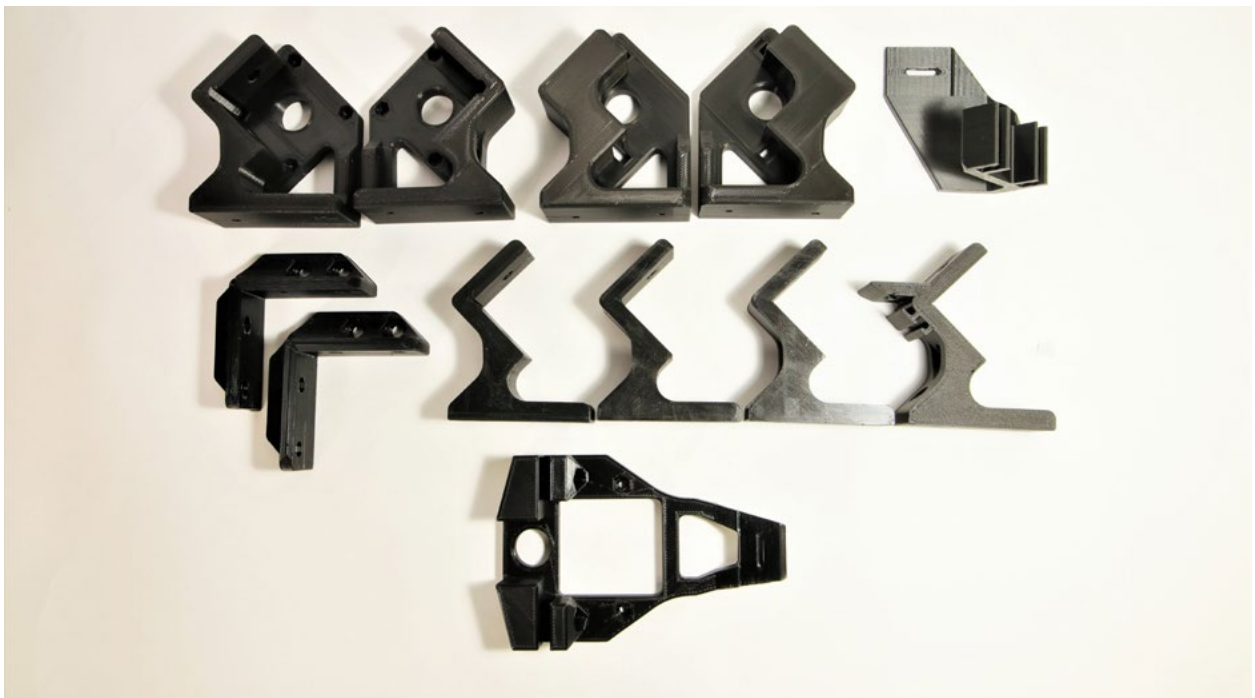


## Top Carton #2

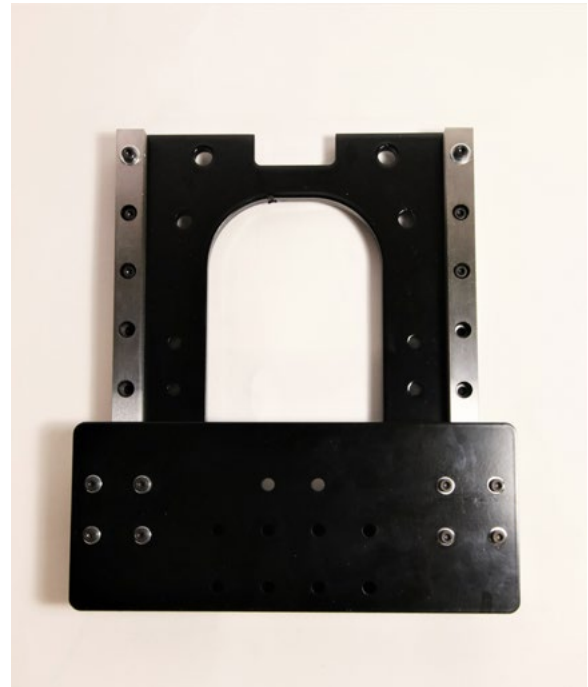
When you open the top carton #2 it should look like this:



- The whole range of 3D printed parts, listed from left-to-right and top-to-bottom: Back feet pair, Front feet pair, Drag chain mount, Shoulder brackets (x2), Middle feet (x3 for the 30×30 and x1 otherwise), Drag chain foot, Z-axis mount



- XZ-gantry sub-assembly protected within a padded envelope

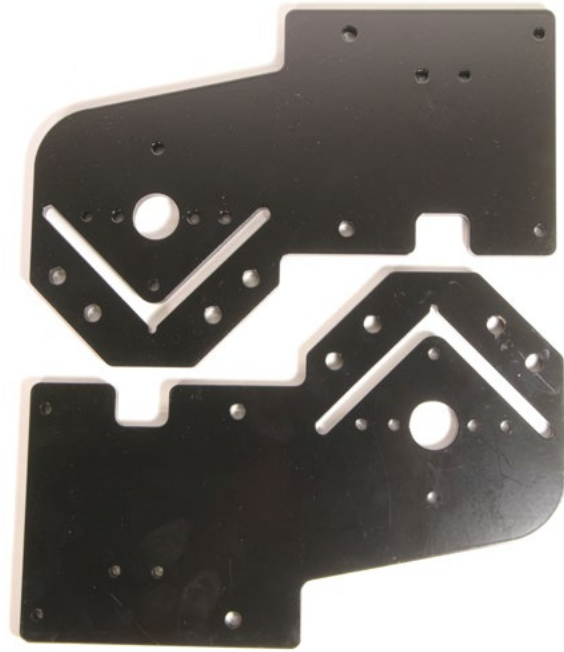
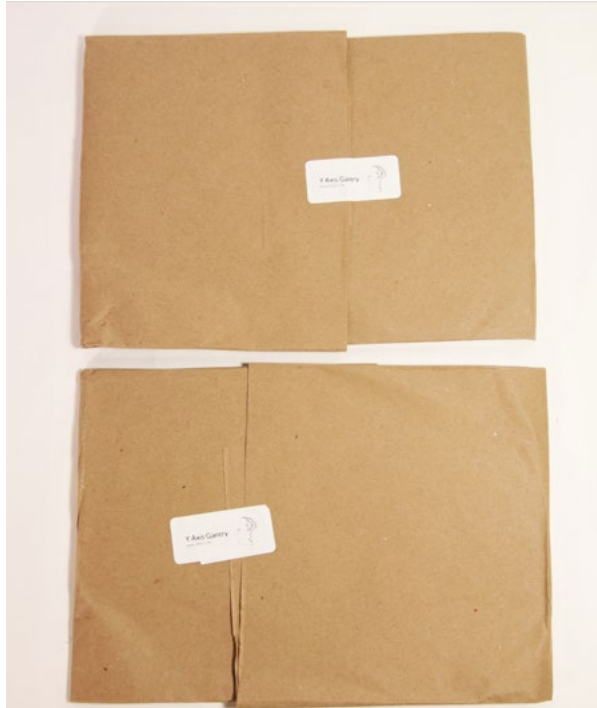


- Z motor plate, a piece of 1/8" thick steel protected by paper wrapping





- Two Y-axis gantries, both pieces of 1/4" thick steel protected by paper wrapping



### Top Carton #3

If you ordered a Makita Router with your Longmill it can be found here, if not this box will remain empty to help keep top cartons #1 and #2 secure during shipping.

